valspar
REFINISH

AC4400 HS Clearcoat

GENERAL INFORMATION

AC4400 is a versatile 4.4 VOC Polyurethane Clearcoat which exhibits ease of application, high durability, and the ultimate in gloss and depth. AC4400 may be mixed as either a spot/panel or overall clear depending upon activator and reducer selection. AC4400 is included in the Limited Lifetime Warranty category for CTE certified shops. When reduced with X01 or X02, AC4400 meets 3.5 VOC regulations.

1. COMPONENTS

- AC4400 Clearcoat
- HPC0 Slow Activator
- HPC1 Medium Activator
- HPC2 Fast Activator
- HPC3 Warp Speed Activator
- X01/X02 Fast/Medium Exempt Uni-Solvent (For 3.5 VOC)
- 171 Fast Uni-Solvent up to 75°F (24°C)
- 172 Medium Uni-Solvent 75°-85°F (24°-29°C)
- 173 Slow Uni-Solvent 85°-95°F (29°-35°C)
- 174 Very Slow Uni-Solvent 95°F (35°C) and over

2. MIXING RATIO

Note: *Activator and Uni-Solvent selections should be based on the size of the area to be painted, air movement, and temperature. For larger areas and/or high temperatures, HPC0 or HPC1 should be used. For panel and multi-panel refinishing, HPC2 should be used. HPC3 should only be used for small areas.*

FOR 4.4 VOC

Mix two (2) parts AC4400 Clear with one (1) part HPC0/1/2/3 Activator and reduce with one (1) part 171 or 172 Uni-Solvent for spot and panel refinishing. (2:1:1).

FOR 3.5 VOC

Mix two (2) parts AC4400 Clear with one (1) part HPC0/1/2/3 Activator and reduce with one (1) part X01 or X02 Uni-Solvent (2:1:1).

3. ADDITIVES

ACCELERATOR: T566 up to 2oz. per gallon (max).
FISHEYE: T152 Fisheye Eliminator up to 1oz. per gallon.
FLEX ADDITIVE: N/A
Note: Do not spray when curface temperature is below 50°F (10°C).

4. POT LIFE @ 77°F (25°C)

HPC0 Activated - 4 Hours
HPC1 Activated - 3 Hours
HPC2 Activated - 1 Hour
HPC3 Activated - 1 Hour

5. CLEAN UP

Valspar Refinish 100 Thinner (check local regulations).

6. SURFACE PREPARATION

FOR APPLICATION OVER RECOMMENDED BASECOAT SYSTEM.

- Mask all adjacent areas to prevent over spray problems.
- Allow basecoats sufficient dry times.
- Over OEM finish using gray scuff pad.

7. SUBSTRATES

- 333 Series
- 840 Series

8. APPLICATION

Spray two wet coats allowing 10-20 minutes flash time between coats. Flash times will be dependent on temperature, air flow, activator selection, and reducer selection.

9. FLASH / DRY TIMES

AIR DRY @ 77°F (25°C)

	HPC0	HPC1	HPC2	HPC3
Flash between coats	15-20 min.	10-20 min.	10-15 min.	5-10 min.
Dust Free	25-30 min.	15-20 min.	10-15 min.	5-10 min.
Sand and Buff	Overnight	Overnight	4-6 Hours	2-3 Hours

FORCE DRY

	HPC0	HPC1	HPC2	HPC3
Flash before Force Dry	15-20 min.	10-20 min.	0 min.	0 min.
Force Dry Temp.	145°F (63°C)	145°F (63°C)	165°F (74°C)	165°F (74°C)
Force Dry Time	60 min.	45 min.	20 min.	20 min.

10. INFRARED CURE

See Infrared Curing Information.

11. GUN SET UP

CONVENTIONAL GUN

Gravity Feed	1.4 mm - 1.6 mm
Siphon Feed	1.6 mm - 1.8 mm

HVLP

Gravity Feed	1.3 mm - 1.5 mm

AIR PRESSURES

Conventional @ Gun	PANEL	OVERALL
Gravity Feed	35-40 psi	45 psi
Siphon Feed	35-45 psi	45-50 psi
HVLP @ Cap	6-8 psi	9-10 psi

12. PHYSICAL DATA

VOC (Packaged)	3.5 or 4.4 lbs./gal. (RTS)
Volume Solids	38.4% Average
Theoretical Coverage	616 sq. ft. per mil per gallon
Recommended DFT	1-4 mils.
Zahn #2 Viscosity (RTS)	19 - 21 Seconds