



## DESCRIPTION

345 Series is a specialty product designed for interior or exterior vinyl surfaces. It offers excellent flexibility and adhesion, and can be used alone or with a hardener.



## COMPONENTS

- 345 Series . . . . . Base
- HPC000 (Optional) . . . . Activator
- 171 . . . . . Fast Reducer
- 172 . . . . . Medium Reducer



## MIXING RATIO

Interior Surfaces: Use as single component (Ready-to-Spray).

Exterior Surfaces: 8 parts 345 Color to 1 part HPC000.

May be reduced up to 5% with 171 or 172 Reducer.



## POT LIFE @ 77°F (25°C)

Indefinite without HPC000 activator  
8 Hours with HPC000 activator



## CLEAN UP

Valspar Refinish 100 Thinner  
(Check local regulations)



## ADDITIVES

ACCELERATOR: N/A  
FISHEYE: T152 1 oz. per gallon.  
FLEX ADDITIVE: N/A

**Note:** Do not spray when surface temperature is below 50°F (10°C).



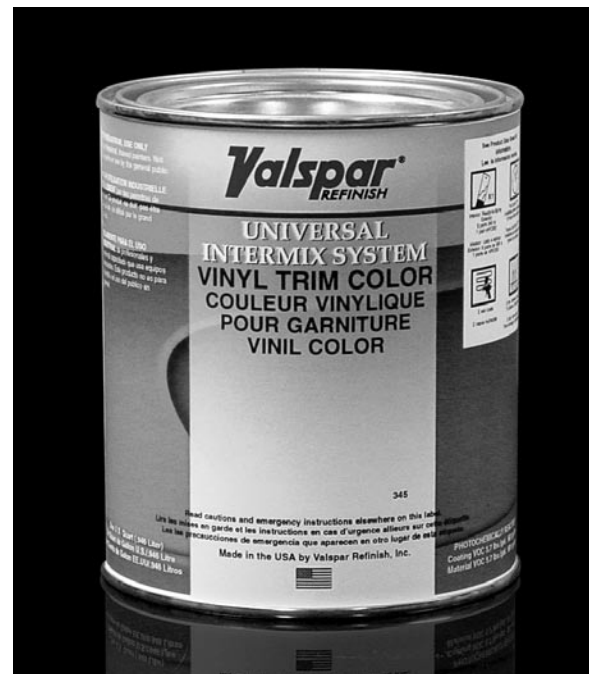
## SURFACE PREPARATION

**For Vinyl:**

- Wash surface with mild detergent and water.
- Rinse and dry surface.
- Wipe surface with Valspar Refinish 100 Thinner or 170 AquaClean and wipe dry with clean cloth before product flashes.
- Spot test before using lacquer thinner to clean vinyls.

**For Plastics:**

- Spray surface with PR1 Plastic Cleaner and wipe dry before product evaporates.
- Scuff surface with 320-400 grit wet or dry sandpaper or red scuff pad.
- Respray surface with PR1 and wipe dry with clean cloth before product evaporates.





## SUBSTRATES

- Properly cleaned vinyl
- PR2 Plastic Adhesive Promoter
- PR3/PR4 Flexible 2K Polyurethane Primers



## APPLICATION

- Apply two to three medium coats allowing 5 minutes between coats.



## FLASH / DRY TIMES AIR DRY @ 77°F (25°C)

Flash between coats . . . . .	5 Minutes
To Deliver . . . . .	Overnight



## GUN SETUPS CONVENTIONAL

Gravity Feed . . . . .	1.4 mm - 1.6 mm
Siphon Feed . . . . .	1.5 mm - 1.8 mm

### HVLP

Gravity Feed . . . . .	1.3 mm - 1.5 mm
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## AIR PRESSURES CONVENTIONAL @ GUN

Gravity Feed . . . . .	30 - 35 psi
Siphon Feed . . . . .	35 - 45 psi

### PANEL

HVLP @ Cap . . . . .	6 - 8 psi
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## PHYSICAL DATA

VOC (Unreduced) . . . . .	5.2 lbs. per gallon (mixed)
Volume Solids . . . . .	20 - 25% (Average)
Theoretical Coverage . . . . .	300 - 400 sq. ft. per mil per gallon
Recommended DFT . . . . .	1 - 2 mils
Zahn #2 Viscosity (RTS) . . . . .	19 - 20 seconds