



AUTOMOTIVE

TAMCO PAINT

AG Series High Gloss Polyurethane Single Stage

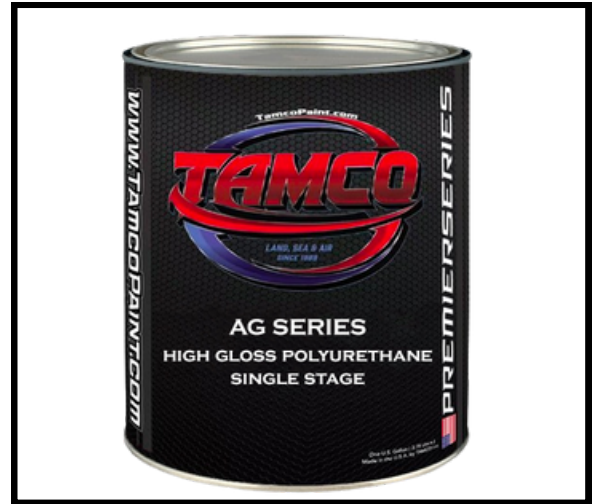
AG Series is a high gloss Acrylic Polyurethane SingleStage. This user friendly singlestage averages a 2-4 coat coverage. Designed to provide an outstanding appearance for overall & small applications, **AG Series** is ideal for Automotive, Custom, Fleet & Industrial coatings in both Solid & Pearl Colors.

This medium build, high-gloss combined with it being user-friendly and productivity makes it a great choice for almost any project.

AG Series Single Stage was designed using our HC4100 Glamour Clearcoat, which mean you can integrate your last coat for an even higher gloss finish.

Features & Benefits

- Ideal for Custom, Fleet & Industrial
- Overall & small applications
- Easy to spray / User friendly
- Integrates with HC4100 Glamour Clearcoat
- High buff ability
- Multi use
- 97-99% on gloss meter
- Very high UV resistance
- Durable (excellent weathering)



Compatible Surfaces

- Sanded Tamco® DTM Primer
- Sanded Tamco® DTA Epoxy
- Sanded Tamco® High Build Epoxy
- Tamco® Forever Seal
- Other premium primers, epoxies or sealers but no warranty implied

Required products

HH76XX series Hardeners.

- HH7603 Fast
- HH7605 Medium
- HH7607 Slow

Optional

- HR1370
- HR1380
- HR1390
- HP1001 Accelerator
- HP1010 Fisheye Eliminator
- HR900 Retarder
- HP Flat
- Pot Life Extender
- Flo N Go

(See our "What Temperature should I choose PDF" for a guideline on which suits your current job)

AG Series High Gloss Polyurethane Single Stage

Surface Preparation: Thoroughly cleaned with HR398 Final Wipe and wipe dry with clean cloth.
Plastics: Clean with HR397W Waterborne Wax & Grease Remover using a Scotch-Brite pad, wipe dry with clean cloth.

Mix Ratio:



Component	Volume
AG Series High Gloss Polyurethane	4
Single Stage	
HH7603/7605/7607	1
Activator	

Note: Tamco® reducer can be added up to 10% as needed.

Use only Tamco® Reducers. Our reducers are completely moisture free.

Moisture in reducer will kill the shine of your singlestage coating.

HH7603 - Fast 60-75°F Large areas 65-70°F	HH7605 - Medium 75-80°F Large areas 70-80°F	HH7607 - Slow 85-100°F Large areas 80-90°F
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HH7607 will be 87-100°F you may need to add 5% HR900 retarder in hot humid conditions.

Additives:



HR900 Retarder, Pot-Life Extender, HP1001 Accelerator, HH1010 Fisheye Eliminator, Flo N Go: 1-2 oz per spray able Quart.

HR Reducers: up to 10%

HP Flat: Refer to our HP Flat TDS sheet for mixing instructions.

Air Pressure & Gun Setups:



Gun Setups:

HVLP

Siphon Feed: 1.2 mm – 1.4 mm

Gravity Feed: 1.2 mm – 1.4 mm

Conventional

Siphon Feed: 1.2 mm – 1.4 mm

Gravity Feed: 1.2 mm – 1.4 mm

25-29 PSI at the gun

5-10 PSI at the cap

Air Pressures Conventional: Always refer to your gun manual for their advice in using our products.

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Application:



1. Refer to Tamco® Epoxies TDS, Tamco® Primers TDS & Tamco® Sealers TDS for flash times before top coating with your singlestage.
 2. Apply 1 medium wet coat. Spray the way you want it to look.
 3. Allow 20-30 minute flash at 78°F between coats.
 4. Apply only 3 coats of color for each session. Shop conditions temperature and air flow will determine flash times.
 5. Monitor an area by lightly touching. If the color is still wet or stringing do not apply additional coats.
 6. Wait until singlestage becomes tacky but doesn't string. Do not apply more singlestage after 1 hour of dry time.
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Drying Times:



Airdry: 12-16 hours @ 78°F.

Tape Time: 6-8 hours

Baking: 140°F for 30 minutes

Wet Sanding:



Sand with 400-600 grit if re-coat is needed

Recoat:

If you choose to apply additional coats of singlestage, after sanding you can add 5% Tamco® reducer and apply 1 medium coat followed by 2 more medium wet coats with 20-30 minute flash between.

As above shop conditions will vary flash times so "string" test is recommended

Polishing:



Allow singlestage to dry for at least 12 hours before polishing.

For best results use Tamco's® 3 step polish & compound system.

We recommend going all the way up to 3000 grit for best results and ease of polishing.

For show car polishing. Allow the vehicle to sit up to 3 or 4 days for a total gas-out of solvents before sanding and polishing. After you finish sanding, when the clear is 'open' sit the vehicle in the sun for a full 24 hours before buffing.

This allows more solvents to evaporate and the surface to be easier to polish and won't show sand scratches.

Do not wax for 120 days



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Tamco® Tips:



Tips:

1. To increase air dry time, a minimum temperature of 60°F must be maintained.
2. Sanded surface should be re-sanded if not top- coated within 8 hours.
3. Extra reducer may be required In High Temps using HR1390 Extra Slow Reducer or HR900 retarder.
4. When using hardeners, be sure the mixture is stirred throughly.
5. We recommend no longer than 1 hour application time between coats for maximum adhesion.
6. Shop conditions, Temperature and air flow will determine flash times. The “string” test method can be used to determine temperature and air flow will determine flash times. The “string” test method can be used to determine proper flash time for your conditions.
7. Integrating Clearcoat with your SingleStage (optional not required) :
We recommend adding up to 50% HC4100 Glamour Clearcoat to your Singlestage for an even higher gloss finish. This should be an extra coat after you achieve your full coverage. Mix HC4100 into your singlestage, then activate as usual, 4:1. This is a last application only to help enhance the gloss.
8. If your AG Series Singlestage is drying to fast, you can Integrate with HC4105 Extra Slow Glamour Clearcoat. This is a last application only to help enhance the gloss.

Note: Use only Tamco® Reducers.

Equipment Cleaning:

Lacquer Thinner or HR1360 is an excellent cleaner.

Cold Shop Conditions:

Do not spray under 65°F or above 100°F.



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TECHNICAL DATA & PHYSICAL PROPERTIES

Color: Solid/Pearl

Mix Ratio: 4:1

Viscosity: (RTS) 18-22 sec. EZ Zahn #2

Pot Life: 1-4 hours depending on temperature

Theoretical Dry Film: 480 ft² @ 1 Mil Weight Solids (RTS) 45% - 49%

Color & Gloss Holdout: Excellent

Volume Solids (RTS): 45% - 49%

Humidity Resistance: Excellent

Weight Per Gallon: 8.08 lbs. - 9.65 lbs.

Solvent Resistance: Excellent

Topcoat Times: 30 min. at 1 mils or less

Repair Ability: Excellent

Florida Exposure: Good

Package VOC: 3.5 # / gal

Chip Resistance: Good

RTS VOC: 3.5 # / gal

See Safety Data Sheet/Material Safety Data Sheet and Labels for additional safety information and handling instructions.

Important: The contents of this package must be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the public. Products mentioned may be hazardous and should only be used according to direction, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to Tamco Paint Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results, or fitness for any intended use, nor does Tamco Paint warrant freedom from patent infringement in the use of any formula or process set forth herein.

Tamco Paint
Barney Family Enterprises
PO BOX 711
Wakefield, Va 23888
(757-627-9551)

www.TamcoPaint.com

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