

Product Information

Product Description:

IME.AD602 Texture Additive Coarse use to convert the VIM PU Series (IME.TB500/510/11/12/20/40/43) into a coarse texture paint surface. IME.AD602 is specially developed for Industrial OEM and aftermarket, has air and force-dry capabilities. Adding IME.AD602 improves the flexibility. Different surface effects can be achieved by using, different Spray technique, changing thinning ratios, different layer thickness or apply a drop coat after flash off.

Substrates:

Iron, steel, stainless steel (blasted), galvanized steel, cast iron, aluminum, Shipping Containers, steel construction, commercial vehicles, chassis, solvent resistant surfaces, cleaned/sanded/hardened original and old cured coatings.

With IME.TB500/520 use a suitable primer.

Preparation:

Dry Sanding VIM Primers: P180 – P240

Wet sanding VIM Primers: P400 – P800

Dry sanding: P80 – P180

(More Detailed information go-to Preparation and Pre-treatment on Icris/CRS or website www.valsparindustrialmix.com)

Surface Preparation: Abrasive blast to EN ISO 12944, Part 4 (ISO Sa 2.5) with a uniform blast profile of 20 to 50µm.

Material Description	Application Method	Minimum DFT µm	Maximum DFT µm	Minimum WFT µm	Maximum WFT µm
IME.AD602	Spray	40µm	65µm	55µm	90µm

Cleaning:





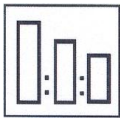

Surface must be dry and free from any contamination, eg oil, grease, release agents. IME.AD690 Solvent degreaser or Valspar Wax and Grease Remover.



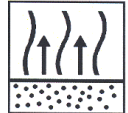
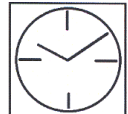

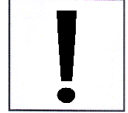
(More Detailed information go-to cleaning processes on Icris/CRS or website www.valsparindustrialmix.com)

Physical properties:

Chemical base	Hydroxy-acrylic resins / polypropylene
Density (kg/l)	1.012
Volume Solids (%)	60,6%
Weight solids (%)	66%
Flash point	27°C
Pot life (+20°C)	Approx. 1 – 2 hours
Shelf life	Min. 24 month under normal storage conditions and unopened tins
Coverage (m ² /kg)	Approx. 8.5 – 9m ² (at 40µm dry film thickness)
Gloss	Reduction of gloss
Color	Milky
Temperature Stability	Dry Heat up to 120°C
VOC (g/l)	Max. 600 g/l (VOC: 2004/42/II B(e)(840)600)
Processing temperature	+10°C till max. +40°C, max. Humidity 85%

Application Data

	Cleaning:	IME.AD609 Solvent Cleaner. Valspar Wax and Grease Remover. Surface must be dry and free from any contamination, e.g. oil, grease.	
	Before using:	The product must be shaken after adding the Color Toners and thoroughly stirred directly after the Activator and Reducer have been added.	
	Topcoat / structure additive Mix Stick M1 2:1 (74-201 - 1:1/2:1)	PU Topcoat TB500/510/511/512/520 Mix Stick M2 4:1 (74-202 - 3:1/4:1) for TB500 M3 5:1 (74-203 - 5:1/6:1) for TB510/511/512 M3 6:1 (74-203 - 5:1/6:1) for TB520 or M6 (74-206 standard) / M7 (74-207 large) Universal cm-stick	
	1. Step - Mixing paint with Structure Additive:		
	Mixing ratio: (By volume)	IME.TB500/520 PU Topcoat (with toner) or IME.TB510/511/512 PU DTM Topcoat (with toner) or IME.AD602 Texture Additive Coarse	2 Parts 1 Part
	2. Step - Mixed paint and Structure Additive with Activator and Reducer:		
	Note: In combination with suitable primer! (By volume)	IME.TB500 PU Topcoat Performance High Gloss + IME.AD602 IME.AU500 PU Activator IME.RS60x Universal Reducer (603/605/607/609)	4 parts 1 part 0-5 parts
		IME.TB520 PU Topcoat Basic + IME.AD602 IME.AU500 PU Activator IME.RS60x Universal Reducer (603/605/607/609)	6 parts 1 part +15-30 parts
	DTM Products (primer isn't necessary but possible) (By volume)	IME.TB510 PU DTM Topcoat High Gloss + IME.AD602 or IME.TB511 PU DTM Topcoat Semi Gloss + IME.AD602 or IME.TB512 PU DTM Topcoat Matt + IME.AD602 IME.AU500 PU Activator IME.RS60x Universal Reducer (603/605/607/609)	5 parts 1 part +10-20 parts
	Faster process of drying:	IME.AA600 Accelerator	+ 3 – 5%
	Viscosity: (DIN4/20°C)	N/A	

	Gravity or Suction Feed: Nozzle set Spray gun "High pressure" Spray gun "Reduce pressure" HVLP (Air cap pressure) Airless/Airmix Pressure Pot	1.5 – 1.9 mm 3.0 – 4.5 bar (42 – 65 psi) 1.5 – 2.5 bar (21 – 36 psi) 0.7 bar (10 psi) maximum See info manufacturer 1.2 – 1.5mm	
	Application: Do not use a paint strainer before use! Film Thickness: (Recommended 40 – 65µm)	Option 1: Smooth Finish ½ + 1 full coat 40 – 50µm (DFT)	Option 2: Textured coat 1 closed coat followed by 1 light/full coat 50 – 65µm (DFT)
	Between coats at 20°C: Before baking at 20°C:	2 minutes between coats 5 minutes before Force-dry	5 – 10 minutes between coats 5 minutes before Force-dry
	Air-dry at 20°C: Force-dry at 60°C – 70°C:	Dust Free: 1 – 2 hours Dry to assembly: 5 – 7 hours Dry: 12 – 16 hours 30 minutes 60°C object temperature	
	Use suitable respiratory protection (we recommend the use of a fresh air supply respirator).		
	<p>Precautions: During application all health and safety measures referring to the use and handling of coating materials are to be observed, e. g. existing regulations issued by the trade associations in the Chemical Industry. For Health and Safety information please refer the Material Safety Datasheet (MSDS). Information also available on our webpage: www.valsparindustrialmix.com</p> <p>Note: The products listed are intended only for the professional user and for professional use. All recommendations in words and writing given on the use of our products to customers or users are not binding and do not give reasons for secondary obligations resulting from the bill of sale. Every care is taken to ensure that the technical information provided is accurate and up to date according to the present state of knowledge in science and our experience. These recommendations do not, however, exempt the customer from autonomously checking whether our products are suitable for the intend purpose. The durability of the coating system largely depends on the thorough preparation of the surface. Furthermore our uniform terms of delivery and payment are applicable.</p> <p>With the publication of this Technical Data Sheet all previous versions regarding this product are no longer valid.</p>		