

Product Information

Product Description:

IME.TB400 (70% Binder - 30% Color Toner), is a two component Epoxy Topcoat with an excellent appearance with air and force-dry capabilities. IME.TB400 is specially developed for Industrial OEM, aftermarket repairs, with excellent chemical resistance. IME.TB400 is recommended for indoor use. All Color Toners are chromate and lead free.

Substrates:

Iron, steel, cast iron, aluminum and galvanized

Substrates coated with Primers: IME.FP400, IME.FP401, and IME.FP402.

Other: Solvent resistant surfaces, cleaned/sanded/hardened original and old cured coatings.

Preparation:

Dry Sanding Substrate: P80 – P180

Dry sanding VIM Primers: P320 – P400

Galvanized: Sweep Blasting recommended.

(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
TB400	Spray	40µm	65µm	50µm	100µm

*Product can be brushed and rolled.

Cleaning:






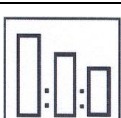
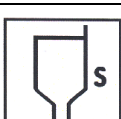

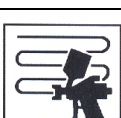
Surface must be dry and free from any contamination, eg, oil, grease and release agents. Use IME.RS405 Epoxy Reducer, IME.RS605/607/609 Universal Reducer, IME.AD690 Solvent Degreaser or Valspar Wax and Grease remover.

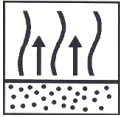




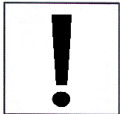
(More Detailed information go-to cleaning processes on Icris/CRS or website www.valsparindustrialmix.com)

Physical properties:

Chemical base	Epoxy
Density (kg/l)	1,042 (Binder)
Volume solids (%)	67.5%
Weight solids (%)	71%
Flash point	30.5°C
Pot life (+20°C)	Approx. 3 – 4 hours
Shelf life	Min. 24 month under normal storage conditions and unopened tins
Coverage (m ² /kg)	Approx. 8.5 – 9.5m ² (at 40µm dry film thickness)
Gloss	High Gloss
Color	See VIM – CRS
Temperature Stability	Dry Heat up to 140°C
VOC (g/l)	Max. 540g/l (VOC: 2004/42/IIB(c)(420)420g/l)
Processing temperature	+10°C till max. +40°C, max. Humidity 85%

Application Data

	Cleaning:	IME.RS405 Epoxy Reducer IME.RS605/607/609 Universal Reducer IME.AD690 Solvent Degreaser (primer surface) Valspar Wax and Grease Remover Surface must be dry and free from any contamination, e.g. oil, grease	
	Preparation:	Dry Sanding: P80 – P180 Dry sanding: VIM Primers: P320 – P400 Galvanized: Sweep Blasting recommended Abrasive blast to EN ISO 12944, Part 4 (Sa 2.5) with a uniform blast profile of 20 to 50µm	
	Before using:	The product must be shaken after adding the Color Toners and thoroughly stirred directly after the Activator and Reducer have been added.	
	Mixing stick:	Use the mixing stick M2 3:1 (74-202 = 3:1/4) or M6 (74-206 standard) / M7 (74-207 large) Universal cm-stick	
	Mixing ratio with Color Toner: (By volume)	IME.TB400 Epoxy Topcoat Binder IMU.CT Range of VIM Color Toners (For mixing formula's see VIM CRS)	70 parts 30 parts
	Mixing ratio with Activator and Reducer: (By volume)	IME.TB400 Epoxy Topcoat High Gloss IME.AT400 Epoxy Activator IME.RS603 Universal Reducer Fast or IME.RS605 Universal Reducer Medium or IME.RS607 Universal Reducer Slow or IME.RS609 Universal Reducer Ultra Slow	3 parts 1 part + 25-30%
	Viscosity:	18 – 24 sec. (DIN4/20°C)	
	Gravity or Suction Feed: Nozzle set Spray gun "High pressure" Spray gun "Reduce pressure" HVLP (Air cap pressure) Airless/Airmix Pressure Pot	1.3 – 1.5 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 1.0 – 1.5mm	
	Application: Film Thickness: (Recommended 40 – 65µm)	Option 1: ½ coat followed by 1 full coat 40 – 50µm (DFT)	Option 2: 1 closed light coat followed by 1 full coat 50 – 65 µm (DFT)

	Between coats at 20°C: Before baking at 20°C:	2 – 5 minutes 10 minutes	5 – 10 minutes 10 minutes
	Air-dry at 20°C:	Dust Free: 45 minutes Dry to assembly: 5 - 7 hours Dry: 12 - 16 hours	
	Force-dry at 60°C – 70°C:	30 minutes 60°C object temperature	
	IR-dry:	12 – 15 minutes (The panel must not reach a temperature above 90°C)	
	Use suitable respiratory protection (we recommend the use of a fresh air supply respirator).		
	Polish:	Dust and minor imperfections can be polished out after the stated air-dry times have been reached, or after a full bake at 60°C object temperature, followed by a cool down of the object to ambient temperature. Before polishing, make sure the surface is well cured. Follow the instructions of the polish manufacturer.	
	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		
	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.		
	With the publication of this Technical Data Sheet all previous versions regarding this product are no longer valid.		