

## Product Information

### Product Description:

IME.TB500 PU Topcoat Performance High Gloss with 70% Binder - 30% Color Toner, is a two component, high solid polyurethane topcoat with excellent gloss and flow. TB500 is specially developed for Industrial OEM, fleet and aftermarket repairs. IME.TB500 has very good air and force dry capabilities and provides excellent UV protection. All Toners are chromate and lead free. IME.TB500 is a **low VOC** product.

### Substrates:

Surfaces coated with Primers: IME.FP400/401Epoxy Primer, IME.FP500/IME.PB500 PU Primer DTM  
 Other: Solvent resistant surfaces, cleaned/sanded/hardened original and cured coatings.

### Preparation:

Primer must be used.  
 Dry sanding VIM Primers: P320 – P400.  
 Wet sanding VIM primers: P400 – P800  
 (More Detailed information go-to Preparation and Pre-treatment on Icris/CRS or website [www.valsparindustrialmix.com](http://www.valsparindustrialmix.com))

Material Description	Application Method	Minimum DFT $\mu\text{m}$	Maximum DFT $\mu\text{m}$	Minimum WFT $\mu\text{m}$	Maximum WFT $\mu\text{m}$
IME.TB500	Spray	45 $\mu\text{m}$	65 $\mu\text{m}$	50 $\mu\text{m}$	75 $\mu\text{m}$

### Cleaning:

Surface must be dry and free from any contamination, e.g oil, grease, release agents. Use 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](http://www.valsparindustrialmix.com))

### Recoating:

Can be recoated with IME.CC700 Clear Coat Anti Graffiti (see TDS)




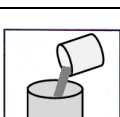

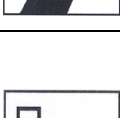
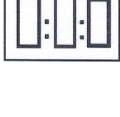

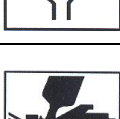
### Physical properties:

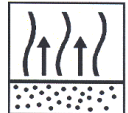






Chemical base	Polyurethane
Density (kg/l)	1,001 (Binder)
Volume solids (%)	53.2%
Weight Solids (%)	59%
Flash point	28°C
Pot life (+20°C)	Approx. 1 – 2 hours
Shelf life	Min. 24 month under normal storage conditions and unopened tins
Coverage (m <sup>2</sup> )	Approx. 8.5m <sup>2</sup> 40 $\mu\text{m}$ (DFT)
Gloss	High Gloss >90 GU/20°
Color	Binder Transparent
Temperature Stability	Dry Heat up to 140°C
VOC (g/l)	Max. 420g/l see CSF (VOC: 2004/42/IIB(c)420g/l)
Processing temperature	+10°C till max. +40°C, max. Humidity 85%

## IME.TB500 PU Topcoat Performance High Gloss

## IME.TB500 / UK

### Application Data

	<b>Cleaning:</b>	IME.AD690 Solvent Degreaser Valspar Wax and Grease Remover Surface must be dry and free from any contamination, e.g. oil, grease	
	<b>Preparation:</b>	<b>Primer must be used.</b> <b>Dry sanding VIM primers:</b> P320 – P400 <b>Wet sanding VIM primers:</b> P400 – P800	
	<b>Before using:</b>	The product must be shaken before adding the Color Toners and thoroughly stirred directly after the Activator and Reducer have been added.	
	<b>Mixing ratio with Color Toner:</b> (By volume)	IME.TB500 PU Topcoat Performance High Gloss IMU.CT Range of VIM Color Toners (For mixing formula's see VIM Icris/CRS)	70 parts 30 parts
	<b>Mix stick:</b>	Use the Mixing stick <b>M2 4:1</b> (74-202 = 3:1/4:1) or <b>M6</b> (74-206 standard) / <b>M7</b> (74-207 large) Universal cm-stick	
	<b>Mixing ratio with Activator and Reducer:</b> (By volume)	IME.TB500 PU Topcoat Performance High Gloss IME.AU500 PU 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	4 parts 1 part  + 0 - 5%
	<b>Faster process of drying:</b>	IME.AA600 Accelerator	+ 3 – 5%
	<b>Viscosity:</b> 20 – 24 sec. (DIN4/20°C)		
	<b>Gravity or Suction Feed:</b>	Nozzle set 1.3 – 1.5 mm Spray gun "High pressure" 3.0 – 4.5 bar (42 – 65 psi) Spray gun "Reduce pressure" 1.5 – 2.5 bar (21 – 36 psi) HVLP (Air cap pressure) 0.7 bar (10 psi) maximum Airless/Airmix See info manufacturer Pressure Pot 1.0 – 1.5mm	
	<b>Application:</b>	<b>Option 1:</b> ½ coat followed by 1 full coat	<b>Option 2:</b> 1 full closed coat followed by 1 full closed coat
	<b>Film Thickness:</b> (recommended 45 – 65µm)	45 – 55µm (DFT)	50 – 65µm (DFT)

	<b>Between coats at 20°C:</b>  <b>Before baking at 20°C:</b>	5 minutes  10 minutes	5 – 10 minutes  10 minutes
	<b>Air-dry at 20°C:</b>  <b>Force-dry at 60°C – 70°C:</b>	<b>Dust Free:</b> 45 – 60 minutes <b>Dry to assembly:</b> 5 – 7 hours <b>Dry:</b> 12 – 16 hours  30 – 40 minutes 60°C object temperature	
	<b>IR-dry:</b>	15 – 20 minutes  (The panel must not reach a temperature above 90°C)	
	<b>Use suitable respiratory protection (we recommend the use of a fresh air supply respirator).</b>		
	<b>Recoatable:</b>  Recoatable 1hr – 24hrs at 20 °C	IME.CC700 Clear Coat Anti Graffiti (See Technical Data Sheet)  After 24 hours: Sanding required	
	<b>Polish:</b>	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 manufacture.	
	<p><b>Precautions:</b> 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: <a href="http://www.valsparindustrialmix.com">www.valsparindustrialmix.com</a></p> <p><b>Note:</b> 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>		