valspar
INDUSTRIAL MIX

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# Technical Data Sheet

## IME.TB511 PU Topcoat Binder DTM Semi Gloss IME.TB511 / UK

## Product Information

**Product Description:**
IME.TB511 PU Topcoat DTM Semi Gloss with 80% Binder - 20% Color Toner optional 70% Binder - 30% Color Toner (on low opacity colours), is a two component, Polyurethane Topcoat DTM (direct to metal) with a semi gloss finish (60GU/60°). This Binder contains anti-corrosion chemicals offering excellent corrosion protection. IME.TB511 is specially developed for Industrial OEM and aftermarket repair industry. Application enables fast operation - reducing costs. Air-dry and force dry capabilities. All Color Toners are chromate and lead free. IME.TB511 provides excellent UV protection.

**Substrates:**
Iron, steel, stainless steel (blasted), cast iron, galvanized steel, aluminum.
Primers: IME.FP400/401Epoxy Primer, IME.FP500/IME.PB500 PU Primer DTM
Other: Solvent resistant surfaces, cleaned/sanded/hardened original and cured coatings.

**Preparation:**
Dry Sanding VIM Primers: P180 – P240 – P320.
Dry sanding: P80 – P180
Galvanized: Sweep blasting recommended.
(More Detailed information go-to Preparation and Pre-treatment on 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.TB511 | Spray | 50µm | 80µm | 65µm | 110µm |

*Product can be brushed and rolled.

**Cleaning:**
Surface must be dry and free from any contamination, e.g oil, grease, release agents. Use IME.RS605/607/609 Universal Reducer, IME.AD690 Solvent Degreaser or Valspar Wax and Grease Remover.
(More Detailed information go-to cleaning processes on CRS or website www.valsparindustrialmix.com)

**Physical properties:**

| | |
|---|---|
| Chemical base | Polyurethane |
| Density (kg/l) | 1,058 (Binder) |
| Volume solids (%) | 54,7% |
| Weight Solids (%) | 63% |
| Flash point | 29°C |
| Pot life (+20°C) | approx. 1 – 2 hours |
| Shelf life | min. 24 month under normal storage conditions and unopened tins |
| Coverage (m²) | approx. 8.5m² 40µm (DFT) |
| Gloss | Semi Gloss ~60GU/60° |
| Color | Binder Transparent |
| Temperature Stability | Dry Heat up to 140°C |
| VOC (g/l) | Max. 460g/l (VOC: 2004/42/IIB(e)(840)460g/l) |
| Processing temperature | +10°C till max. +40°C, max. Humidity 85% |

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## Application Data

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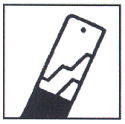
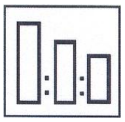
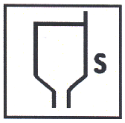
|---|---|---|---|---|
|  | **Cleaning:** | IME.RS605/607/609 Universal Reducer<br>IME.AD690 Solvent Degreaser<br>Valspar Wax and Grease Remover<br>Surface must be dry and free from any contamination, e.g. oil, grease | | |
|  | **Preparation:** | **Dry sanding VIM primers**:P180 – P240 – P320<br>**Sanded systems**: P80 – P180<br>**Galvanized:** Sweep blasting recommended<br>**Abrasive blast**: AS 1627.4 Class 2.5 (ISO Sa 2.5) with a uniform blast profile of 20 to 50µm | | |
|  | **Before using:**<br>The product must be shaken before adding the Color Toners and thoroughly stirred directly after the Activator and Reducer have been added. | | | |
|  | **Mixing ratio with Color Toner:**<br>(By volume) | IME.TB511 PU Topcoat Binder DTM Semi Gloss<br>IMU.CT Range of VIM Color Toners<br>(For mixing formula's see VIM CRS) | 80 parts or<br>20 parts | 70 parts<br>30 parts |
|  | **Mix stick:**<br>Use the mixing stick **M3 5:1** (M3 - 74-203 = 5:1/6:1) or<br>**M6** (74-206 standard) / **M7** (74-207 large) Universal cm-stick | | | |
|  | **Mixing ratio with Activator and Reducer:**<br>(By volume) | IME.TB511 PU Topcoat DTM Semi Gloss<br>IME.AU500 PU Activator<br>IME.RS603 Universal Reducer Fast or<br>IME.RS605 Universal Reducer Medium or<br>IME.RS607 Universal Reducer Slow or<br>IME.RS609 Universal Reducer Ultra Slow | 5 parts<br>1 part<br><br>+ 10-25% | |
| | **Faster process of drying:** | IME.AA600 Accelerator | + 3 – 5% | |
|  | **Viscosity:**<br>22 – 26 sec. (DIN4/20°C) | | | |
|  | **Gravity or Suction Feed:**<br>Nozzle set<br>Spray gun "High pressure"<br>Spray gun "Reduce pressure"<br>HVLP (Air cap pressure)<br>Airless/Airmix<br>Pressure Pot | <br>1.4 – 1.8mm<br>3,0 – 4,5 bar (42 – 65 psi)<br>1,5 – 2,5 bar (21 – 36 psi)<br>0,7 bar (10 psi) maximum<br>See info manufacturer<br>1.0 – 1.5mm | | |
|  | **Application:**<br><br>**Film Thickness:**<br>(recommended 50 – 80µm) | **Option 1:**<br>½ coat<br>followed by 1 full coat<br><br>40 – 60µm (DFT) | **Option 2:**<br>1 full closed coat<br>followed by 1 full closed coat<br><br>60 – 80µm (DFT) | |

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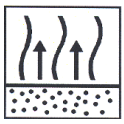
|  | **Between coats at 20°C:**<br><br>**Before baking at 20°C:** | 5 minutes<br><br>10 minutes | 5 – 10 minutes<br><br>10 minutes |
|  | **Air–dry at 20°C:** | Dust Free: 25 – 30 minutes<br>Dry to assembly: 3 – 5 hours<br>Dry: 8 – 10 hours | |
| | **Force–dry at 60°C – 70°C:** | 30 minutes<br><br>60°C object temperature | |
|  | **IR–dry:** | 12 – 15 minutes<br><br>(The panel must not reach a temperature above 90°C) | |
|  | **Use suitable respiratory protection (we recommend the use of a fresh air supply respirator).** | | |
| | | | |
|  | **Recoatable:** | Not recommended | |
|  | **Polish:** | Not recommended | |
| | | | |
|  | **<u>Precautions:</u>** 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 | | |
| | **<u>Note:</u>** 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. | | |