

## Product Information

### Product Description:

IME.TB512 PU Topcoat DTM Matt 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 matt finish (25GU/60°). This Binder contains anti-corrosion chemicals offering excellent corrosion protection. IME.TB512 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.TB512 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](http://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.TB512	Spray	50µm	80µm	65µm	110µm

\*Product can be brushed and rolled.

### Cleaning:






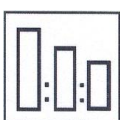
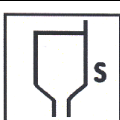


Surface must be dry and free from any contamination, e.g oil, grease, release agents. Use IME.RS605/607/609 Universal Reducer, IME.AD690 Solvent Degreaser or Valspar Wax and Grease Remover.

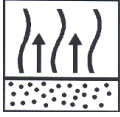






(More Detailed information go-to cleaning processes on CRS or website [www.valsparindustrialmix.com](http://www.valsparindustrialmix.com))

### Physical properties:

Chemical base	Polyurethane
Density (kg/l)	1,058 (Binder)
Volume solids (%)	52.3%
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 (m <sup>2</sup> )	approx. 8.5m <sup>2</sup> 40µm (DFT)
Gloss	Matt ~25GU/60°
Color	Binder Transparent
Temperature Stability	Dry Heat up to 140°C
VOC (g/l)	Max. 470g/l (VOC: 2004/42/IIB(e))(840)470g/l)
Processing temperature	+10°C till max. +40°C, max. Humidity 85%

## Application Data

	<b>Cleaning:</b>	IME.RS605/607/609 Universal Reducer 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>Dry sanding VIM primers:</b> P180 – P240 – P320 <b>Sanded systems:</b> P80 – P180 <b>Galvanized:</b> Sweep blasting recommended <b>Abrasive blast:</b> AS 1627.4 Class 2.5 (ISO Sa 2.5) with a uniform blast profile of 20 to 50µm		
	<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.TB512 PU Topcoat Binder DTM Matt IMU.CT Range of VIM Color Toners (For mixing formula's see VIM CRS)	80 parts 20 parts or	70 parts 30 parts
	<b>Mix stick:</b>	Use the mixing stick <b>M3 5:1</b> (M3 - 74-203 = 5:1/6:1) 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.TB512 PU Topcoat DTM Matt 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	5 parts 1 part	+ 10-25%
	<b>Faster process of drying:</b>	IME.AA600 Accelerator	+ 3 – 5%	
	<b>Viscosity:</b> 22 – 26 sec. (DIN4/20°C)			
	<b>Gravity or Suction Feed:</b> Nozzle set Spray gun "High pressure" Spray gun "Reduce pressure" HVLP (Air cap pressure) Airless/Airmix Pressure Pot	1.4 – 1.8mm 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		
	<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 50 – 80µm)	40 – 60µm (DFT)	60 – 80µm (DFT)	

	<b>Between coats at 20°C:</b>	5 minutes	5 – 10 minutes
	<b>Before baking at 20°C:</b>	10 minutes	10 minutes
	<b>Air-dry at 20°C:</b>	Dust Free: 25 – 30 minutes Dry to assembly: 3 – 5 hours Dry: 8 – 10 hours	
	<b>Force-dry at 60°C – 70°C:</b>	30 minutes  60°C object temperature	
	<b>IR-dry:</b>	12 – 15 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>	Not recommended	
	<b>Polish:</b>	Not recommended	
	<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>		
	With the publication of this Technical Data Sheet all previous versions regarding this product are no longer valid.		