

Product Information

Product Description:

IME.TB520 PU Topcoat Basic High Gloss with 80% Binder - 20% Color Toner optional 70% Binder - 30% Color Toner (on low opacity colours), is a two component, very fast polyurethane topcoat with excellent gloss and flow. TB520 is specially developed for Industrial OEM, fleet and aftermarket repairs. This product has excellent air and force dry capabilities and provides very good UV protection. All Toners are chromate and lead free.

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)

Material Description	Application Method	Minimum DFT μm	Maximum DFT μm	Minimum WFT μm	Maximum WFT μm
IME.TB520	Spray	40 μm	60 μm	55 μm	90 μm

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)




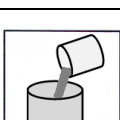
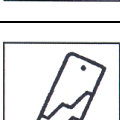
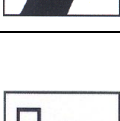
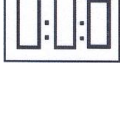

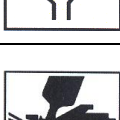
Recoating:

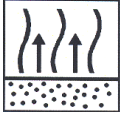







Can be recoated with IME.CC700 Clear Coat Anti Graffiti (see TDS)

Physical properties:

Chemical base	Polyurethane
Density (kg/l)	1,056 (Binder)
Volume solids (%)	40.7%
Weight Solids (%)	46.5%
Flash point	23.5°C
Pot life (+20°C)	Approx. 3 - 4 hours
Shelf life	Min. 24 month under normal storage conditions and unopened tins
Coverage (m ²)	Approx. 8.0 – 9,0m ² 40 μm (DFT)
Gloss	High Gloss >90 GU/20°
Color	Binder Transparent
Temperature Stability	Dry Heat up to 140°C
VOC (g/l)	Max. 590g/l see CSF (VOC: 2004/42/IIB(c)420g/l)
Processing temperature	+10°C till max. +40°C, max. Humidity 85%

IME.TB520 PU Topcoat Basic High Gloss
IME.TB520 / UK
Application Data

	Cleaning:	IME.AD690 Solvent Degreaser Valspar Wax and Grease Remover Surface must be dry and free from any contamination, e.g. oil, grease		
	Preparation:	Primer must be used. Dry sanding VIM primers: P320 – P400 Wet sanding VIM primers: P400 – P800		
	Before using:	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: (By volume)	IMU.TB520 PU Topcoat Basic High Gloss IMU.CT Range of VIM Color Toners (For mixing formula's see VIM Icris/CRS)	80 parts 20 parts or	70 parts 30 parts
	Mix stick:	Use the mix stick M3 6:1 (M3 - 74-203 = 5:1/6:1) or M6 (74-206 standard) / M7 (74-207 large) Universal cm-stick		
	Mixing ratio with Activator and Reducer: (By volume)	IME.TB520 PU Topcoat Basic 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	6 parts 1 part + 20 - 35%	
	Faster process of drying:	IME.AA600 Accelerator	+ 3 – 5%	
	Viscosity: 20 – 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:	Option 1: ½ coat followed by 1 full coat	Option 2: 1 full closed coat followed by 1 full closed coat	
	Film Thickness: (recommended 40 – 60µm)	40 – 50µm (DFT)	50 – 60µm (DFT)	

	Between coats at 20°C: Before baking at 20°C:	2 – 5 minutes 5 minutes	5 – 10 minutes 5 minutes
	Air-dry at 20°C:	Dust Free: 15 – 25 minutes Dry to assembly: 1 – 3 hours Dry: 6 – 8 hours	
	Force-dry at 60°C – 70°C:	20 – 30 minutes 60°C object temperature	
	IR-dry:	8 – 12 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).		
	Recoatable: Recoatable 1hr – 12hrs @20 °C	IME.CC700 Clear Coat Anti Graffiti (See Technical Data Sheet) After 12 hours: Sanding required	
	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 manufacture.	
	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.			