

TB320 Quick Dry Enamel Topcoat**TB320 / AU****Product Information****Product Description:**

TB320 is a Quick Dry Enamel Topcoat with 80% Binder + 20% Solid Colour Toners. TB320 is specially developed for Industrial OEM and aftermarket repairs, easy to apply with fast air- and force dry capabilities to improve productivity. For solid colours which are all chromate and lead free.

Substrates:

Indoor: Iron, steel, cast iron, galvanized steel, aluminum and glass fiber reinforced plastics (GRP).
Outdoor: For metal substrates use FP300/PB300 Synthetic Primer or FP400/401 Epoxy Primer
Other: Solvent resistant surfaces, cleaned / sanded / hardened original and cured coatings.

Iron/steel: Abrasive shot blasting is recommended or dry sanding P80 – P180
Aluminum: P180 – P240
Galvanized: Sweep blasting recommended
Paint finishes: P220 – P240 (Please, check and change regularly sanding paper)

Cleaning: Surface must be dry and free from any contamination, e.g. oil, grease, release agents.
Use AD690 Solvent Degreaser for metal substrate and paint finishes.

Material Description: TB320 Quick Dry Enamel Topcoat

Application Method	Minimum DFT µm	Maximum DFT µm	Minimum WFT µm	Maximum WFT µm *
Spraying equipment (not-including airless/airmix)	50µm	60µm	125µm	150µm




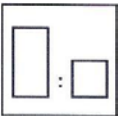

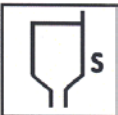



Physical properties:

Chemical base	Synthetic, Alkyd Enamel.
Density (kg/l)	0,9 - 1,1
Volume solids (%)	40%
Weight Solids (%)	40%
Flash point	- 6°C
Pot life (+20°C)	Indefinitely
Shelf life	Min. 24 month under normal storage conditions and unopened tins
Coverage (m²)	Approx. 8 m² / L / 50µm (DFT) Ready to Spray.
Gloss	High Gloss
Colour	Binder Transparent
Processing temperature	+15°C till max., max. Humidity 85%

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Application Data

	Preparation/ Cleaning:	All surfaces must be properly shot blast or sanded and cleaned Abrasive blast to EN ISO 12944, part 4 (SA 2.5) with a uniform blast profile of 20 – 50µm. Dry sanding Steel: P80 – P180 Aluminum: P180 – P240 Galvanized: Sweep blasting recommended Paint finishes: P220 – P240 Cleaning: AD690 Solvent Degreaser (metal surface & paint finishes) Surface must be dry and free from any contamination, e.g. oil, grease		
	Handling:	Color preparation: 1. Stir binder until homogeneous 2. Add Solid Colour Toners 3. Mix mechanically (paint shaker/mechanical stirrer)		Before use/spraying: 1. Mix mechanically (paint shaker/mechanical stirrer) 2. Add Reducer 3. Stir this mixture well with a mixing stick or a (pneumatic) stirrer
	Mixing ratio with Solid Colour Toners: (By volume)		TB320 Quick Dry Enamel Topcoat Binder CT Range of VIM Solid Colour Toners	80 parts 20 parts
	For mixing machine users:		For mixing formula's see VIM CRS	(By weight)
	Mix ratio with Reducer:		TB320 Quick Dry Enamel Topcoat RS300 Synthetic Reducer	100 parts 10 - 25 parts
	Mix stick:		Use the Mixing stick M6 Universal cm-stick (74-206 standard) / M7 (74-207 large)	
	Viscosity: 20 – 28 sec. (DIN4/20°C)			
	Gravity or Suction Feed: Nozzle set Spray gun Spray gun "Reduce pressure" HVLP (Air cap pressure) Airless/Airmix Pressure Pot		1.3 – 1.6 mm 2 bar (25 psi) 1.5 – 2.5 bar (21 – 36 psi) 0.7 bar (10 psi) maximum ± 0.33mm (0.013 inch) pressure 1200 Psi. 1.0 – 1.5mm	
	Application: Film Thickness:		1 closed coat Followed by 1 full coat (recommended 50 – 60µm) DFT	
	Between coats at 20°C:		5 – 10 minutes	
	Before baking at 20°C:		10 minutes	

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	Clean up: (Check the local regulations!)	RS300 Synthetic Reducer, RS60x Universal Reducer or Gun cleaner (solvent)
	Air-dry at 25°C:	Touch Dry: 15 – 20 minutes Dry to handle: 30 minutes Hard Dry: 4 – 6 hours Re-Coat time < 4 hours or > 16 hours.
	Use suitable respiratory protection (air fed respirator strongly recommended).	
	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 Safety Datasheet Sheet (SDS). 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 given in writing 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.	