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www.valsparindustrialmix.com

Technical Data Sheet

IME.TB510 PU Topcoat Binder DTM High Gloss IME.TB510 / UK

Product Information

Product Description:
IME.TB510 PU Topcoat DTM High 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 high gloss finish. This Binder contains anti-corrosion chemicals offering excellent corrosion protection. IME.TB510 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.TB510 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.TB510	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 Universal Reducer (Metal surfaces) or IME.AD690 Solvent Degrease.
(More Detailed information go-to cleaning processes on 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)	1,023 (Binder)
Volume solids (%)	52.9%
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	High Gloss >90 GU/20°
Color	Binder Transparent
Temperature Stability	Dry Heat up to 140°C
VOC (g/l)	(VOC: 2004/42/IIB(c)420g/l)
Processing temperature	+10°C till max. +40°C, max. Humidity 85%

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Application Data

	**Cleaning:**	(Metal substrate surface only: IME.RS605 Universal Reducer) IME.AD690 Solvent Degreaser Surface must be dry and free from any contamination, e.g. oil, grease		
	**Preparation:**	**Dry sanding VIM primers**: P180 – P240 – P320 **Sanded systems**: P80 – P180 **Galvanized:** Sweep blasting recommended **Abrasive blast**: AS 1627.4 Class 2.5 (ISO Sa 2.5) with a uniform blast profile of 20 to 50µm		
	**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)	IME.TB510 PU Topcoat Binder DTM High Gloss IMU.CT Range of VIM Color Toners (For mixing formula's see VIM CRS)	80 parts 20 parts or	70 parts 30 parts
	**Mix stick:** Use the mixing stick **M3 5:1** (M3 - 74-203 = 5:1/6:1)			
	**Mixing ratio with Activator and Reducer:** (By volume)	IME.TB510 PU Topcoat DTM High Gloss IME.AU500 PU Activator IME.RS603 Universal Reducer Fast or IME.RS605 Universal Reducer Medium or IME.RS607 Universal Reducer Slow	5 parts 1 part + 10-20%	
	Faster process of drying:	IME.AA600 Accelerator	+ 3 – 5%	
	**Viscosity:** 22 – 26 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	 1.4 – 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		
	**Application:** **Film Thickness:** (recommended 50 – 80µm)	**Option 1:** ½ coat followed by 1 full coat 40 – 60µm (DFT)	**Option 2:** 1 full closed coat followed by 1 full closed coat 60 – 80µm (DFT)	

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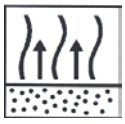	**Between coats at 20°C:** **Before baking at 20°C:**	5 minutes 10 minutes	5 – 10 minutes 10 minutes
	**Air–dry at 20°C:**	Dust Free: 25 – 30 minutes Dry to assembly: 3 – 5 hours Dry: 8 – 10 hours	
	Force–dry at 60°C – 70°C:	30 minutes 60°C object temperature	
	**IR–dry:**	12 – 15 minutes (The panel 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 at 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.		