

**AD600 High Build Additive**  
 (for retailer/to store the product – without Activator)

**AD600-R / AU**

## Product Information

### Product Description:

AD600 is a High Build Additive to convert the PU Series (TB500/510/520/540/543) into a high build coating with excellent protective properties and higher chemical resistance. Specially developed for Industrial OEM and repainting. Ease of use, enables fast operation - reducing costs. (Only air-drying is recommended). Addition of AD600 High Build Additive will alter (light) topcoat colors and will reduce the gloss finish.

### Preparation:

For more detailed information go-to TI-Substrate and Pre-treatment on Colour Retrieval System (CRS) or website [www.valsparindustrialmix.com](http://www.valsparindustrialmix.com).

#### Substrates:

Steel construction, shipping containers, chassis, cast iron, galvanized steel, aluminum, glass fiber reinforced plastics (GRP).

**Primers:** Use FP400/401 Epoxy Primer DTM or FP500/PB500 PU Primer for TB500/520 PU Topcoat - as option for TB510//540/543 DTM Topcoat (direct to metal).

**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:** P280 – P360 (please, regularly check and change abrasive paper as required)

**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: AD600

Application Method	Minimum DFT $\mu\text{m}$	Maximum DFT $\mu\text{m}$	Minimum WFT $\mu\text{m}$	Maximum WFT $\mu\text{m}$ *
Spraying equipment (including airless/airmix)	75 $\mu\text{m}$	150 $\mu\text{m}$	100 $\mu\text{m}$	200 $\mu\text{m}$

\* Higher thicknesses possible if given extended drying times

### Physical properties:

Chemical base	Polyester resins and thixotropic agents
Density (kg/l)	1,235 (Binder)
Volume solids (%)	50.3%
Weight Solids (%)	50.0%
Flash point	8.5°C
Pot life (+20°C)	Approx. 2 – 3 hours (with PU Topcoats)
Shelf life	Min. 24 month under normal storage conditions and unopened tins
Coverage (m <sup>2</sup> )	Approx. 8.5 – 9 m <sup>2</sup> 40 $\mu\text{m}$ (DFT)
Gloss	Satin gloss
Color	Additive transparent grey
Temperature Stability	Dry Heat up to 120°C
VOC (g/l)	Max. 600g/l see CRS (VOC: 2004/42/IIB(d)420g/l)
Processing temperature	+10°C till max. +40°C, max. Humidity 85%

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## Application Data

	<b>Preparation/ Cleaning:</b>	<b>All surfaces must be properly shot blast or sanded and cleaned</b> Abrasive blast to 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: P280 – P360 Cleaning: AD690 Solvent Degreaser (metal substrate & paint finishes) Surface must be dry and free from any contamination, e.g. oil, grease																						
	<b>Handling:</b>	<b>Color preparation:</b> 1. Stir binder until homogeneous 2. Add Color Toners 3. Mix mechanically (paint shaker/ mechanical stirrer)	<b>Before use/spraying:</b> 1. Mix mechanically (paint shaker/ mechanical stirrer) 2. Add Activator, Additive and Reducer 3. Stir this mixture well with a mixing stick or a (pneumatic) stirrer																					
	<b>Mixing ratio Binder/Toner:</b> (By volume)	<table border="1"> <tr> <td><b>TB500 PU Topcoat Binder Performance</b></td> <td></td> <td></td> <td>70 / 30</td> </tr> <tr> <td><b>TB510 PU DTM Binder</b></td> <td></td> <td>80 / 20 or</td> <td>70 / 30</td> </tr> <tr> <td><b>TB520 PU Topcoat Binder Basic</b></td> <td></td> <td>80 / 20 or</td> <td>70 / 30</td> </tr> <tr> <td><b>TB540/543 PU DTM Binder</b></td> <td></td> <td>70 / 30 or</td> <td>60 / 40</td> </tr> <tr> <td colspan="3">For mixing machine users, see formula's in VIM CRS</td> <td>(By weight)</td> </tr> </table>	<b>TB500 PU Topcoat Binder Performance</b>			70 / 30	<b>TB510 PU DTM Binder</b>		80 / 20 or	70 / 30	<b>TB520 PU Topcoat Binder Basic</b>		80 / 20 or	70 / 30	<b>TB540/543 PU DTM Binder</b>		70 / 30 or	60 / 40	For mixing machine users, see formula's in VIM CRS			(By weight)		
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	<b>Mix ratio: TB500/520 PU Topcoat with AD600 High Build Additive</b> <b>Note:</b> In combination with suitable VIM Primer!																							
	<b>Option 1:</b>  (Info for end-user)	TB500 PU Topcoat Performance AD600 High Build Additive  TB500 PU Topcoat Performance + AD600 High Build Additive AU500 PU Activator RS60x Universal Reducer (603/605/607/609)	100 parts add 10-70 parts  4 parts 1 part add max. 5%																					
	<b>Option 2:</b>  (Info for end-user)	TB500 PU Topcoat Performance AD600 High Build Additive  TB500 PU Topcoat Performance + AD600 High Build Additive AU500 PU Activator RS60x Universal Reducer (603/605/607/609)	100 parts add 71-100 parts  5 parts 1 part add max. 5%																					
	<b>Mix stick:</b>  (Info for end-user)	Use the Mixing stick <b>M2/M3 4:1 / 5:1</b> (74-202 = 3:1/4:1 and 74-203 = 5:1/6:1) and/or <b>M6 Universal cm-stick</b> (74-206 standard) / <b>M7</b> (74-207 large)																						
	<b>Option 1:</b>  (Info for end-user)	TB520 PU Topcoat Basic AD600 High Build Additive  TB520 PU Topcoat Basic + AD600 High Build Additive AU500 PU Activator RS60x Universal Reducer (603/605/607/609)	100 parts add 10-50 parts  6 parts 1 part add 15-30%																					
	<b>Option 2:</b>  (Info for end-user)	TB520 PU Topcoat Basic AD600 High Build Additive  TB520 PU Topcoat Basic + AD600 High Build Additive AU500 PU Activator RS60x Universal Reducer (603/605/607/609)	100 parts add 51-75 parts  7 parts 1 part add 15-30%																					
	<b>Option 3:</b>  (Info for end-user)	TB520 PU Topcoat Basic AD600 High Build Additive  TB520 PU Topcoat Basic + AD600 High Build Additive AU500 PU Activator RS60x Universal Reducer (603/605/607/609)	100 parts add 76-100 parts  8 parts 1 part add 15-30%																					





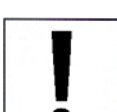

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	<b>Mix stick:</b>	Use the Mixing stick <b>M2/M3 4:1 / 5:1</b> (74-202 = 3:1/4:1 and 74-203 = 5:1/6:1) and/or <b>M6 Universal cm-stick</b> (74-206 standard) / <b>M7</b> (74-207 large)	
	<b>TB510/TB540/TB543 PU DTM Topcoats with AD600 High Build Additive</b> (DTM = direct to metal product, the use of a VIM primer is optional)		
	<b>Option 1:</b>	TB510 PU Topcoat DTM AD600 High Build Additive	100 parts add 10-70 parts
	(Info for end-user)	TB510 PU Topcoat DTM + AD600 High Build Additive AU500 PU Activator RS60x Universal Reducer (603/605/607/609)	5 parts 1 part add 10-20%
	<b>Option 2:</b>	TB510 PU Topcoat DTM AD600 High Build Additive	100 parts add 71-100 parts
	(Info for end-user)	TB510 PU Topcoat DTM + AD600 High Build Additive AU500 PU Activator RS60x Universal Reducer (603/605/607/609)	6 parts 1 part add 10-20%
	<b>Mix stick:</b>	Use the Mixing stick <b>M3 5:1</b> (74-203 = 5:1/6:1) and/or <b>M6 Universal cm-stick</b> (74-206 standard) / <b>M7</b> (74-207 large)	
	<b>Option 1:</b>	TB540/543 PU Topcoat DTM AD600 High Build Additive	100 parts add 10-70 parts
	(Info for end-user)	TB540/543 PU Topcoat DTM + AD600 High Build Additive AU500 PU Activator RS60x Universal Reducer (603/605/607/609)	4 parts 1 part add max. 25%
	<b>Option 2:</b>	TB540/543 PU Topcoat DTM AD600 High Build Additive	100 parts add 71-100 parts
(Info for end-user)	TB540/543 PU Topcoat DTM + AD600 High Build Additive AU500 PU Activator RS60x Universal Reducer (603/605/607/609)	5 parts 1 part add max. 25%	
<b>Mix stick:</b>	Use the Mixing stick <b>M2/M3 4:1 / 5:1</b> (74-202 = 3:1/4:1 and 74-203 = 5:1/6:1) and/or <b>M6 Universal cm-stick</b> (74-206 standard) / <b>M7</b> (74-207 large)		
<b>Faster process of drying:</b>	AA600 Accelerator	add 3 – 5%	
	<b>Viscosity:</b> N/A		
	<b>Gravity or Suction Feed:</b> Nozzle set Spray gun “High pressure” Spray gun “Reduce pressure” HVLP (Air cap pressure) Airless/Airmix Pressure Pot	1.5 – 2,0 mm 3.0 – 4.5 bar (42 – 65 psi) 1.5 – 2.5 bar (21 – 36 psi) 0.7 bar (10 psi) maximum 0.011 – 0.015 (see manufacture information) 1.0 – 1.5mm	
	<b>Application:</b>  <b>Film Thickness:</b> (recommended 75 – 150µm)	<b>Option 1:</b> 1 closed coat followed by 1 full coat 50 – 80µm (DFT)	<b>Option 2:</b> 1 full coat followed by 1-2 full coats 100 – 180µm (DFT)
	<b>Between coats at 20°C:</b>	0 – 5 minutes	5 minutes

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	<p><b>Clean up:</b>                  (Check the local regulations!)</p>	<p>RS605/607/609 Universal Reducer or                  Gun cleaner (solvent)</p>
	<p><b>Air-dry at 20°C:</b></p>	<p><b>Dust Free:</b> 1 – 2 hours  <b>Dry to assembly:</b> 4 – 10 hours  <b>Dry:</b> 16 – 24 hours</p>
	<p><b>Force-dry:</b></p>	<p>Not recommended</p>
	<p><b>IR-dry:</b></p>	<p>Not recommended</p>
	<p><b>Use suitable respiratory protection (air fed respirator strongly recommended).</b></p>	
	<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 given in writing on the use of our products to customers 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> <p>With the publication of this Technical Data Sheet all previous versions regarding this product are no longer valid.</p>	