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Technical Data Sheet

IME.AD600 High Build Additive IME.AD600 / UK

Product Information

Product Description:
IME.AD600 is a High Build Additive to convert the PU Series (IME.TB510/11/12/20) into a high build coating with excellent protective properties and high chemical resistance. Specially developed for Industrial OEM and repainting. Ease of use, enables fast operation - reducing costs. Air-drying only is recommended.
Addition of AD600 additive the topcoat the gloss will reduce.

Surfaces:
Iron, steel, stainless steel (blasted), galvanized steel, cast iron, aluminum.
For Shipping Containers, steel construction, chassis, solvent resistant surfaces, cleaned/sanded/hardened original and old cured coatings.
Use a suitable primer with IME.TB500/TB520.

Preparation:
Dry Sanding: P180–P320.
Galvanized: Sweep Blasting recommended.
(More Detailed information go-to Preparation and Pre-treatment on CRS or website www.valsparindustrialmix.com)

Surface Preparation: Abrasive blast toEN 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.AD600	Spray	75µm	150µm	100µm	180µm

Cleaning:
Surface must be dry and free from any contamination, eg.. oil, grease and release agents. Use IME.RS605/607 Universal Reducer (Metal surfaces) or IME.AD690 solvent degreaser.
(More Detailed information go-to cleaning processes on CRS or website www.valsparindustrialmix.com)

Physical properties:

Chemical base	Polyester resins and thixotropic agents
Density (kg/l)	1.235
Volume Solids (%)	50.3%
Weight solids (%)	50%
Flash point	8.5°C
Pot life (+20°C)	Approx. 2 – 3 hours
Shelf life	Min. 24 month under normal storage conditions and unopened tins
Coverage (m²/kg)	Approx. 8.5 – 9m² (at 40µm dry film thickness)
Gloss	Satin gloss
Color	Transparent grey
Temperature Stability	Dry Heat up to 120°C
VOC (g/l)	Approx. 600 g/l (VOC: 2004/42/IIB(e)(840g/l)600)
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) Primer surface use: IME.AD690 Solvent Degreaser Surface must be dry and free from any contamination, e.g. oil, grease.	
	**Before using:** The product must be shaken after adding the Color Toners and thoroughly stirred directly after the Activator and Reducer have been added.		
	**Mixing stick:** Use the Mixing stick **M3** (74-203) 5:1 / 6:1		
IME.TB510/11/12 PU Topcoat DTM with IME.AD600 High Build Additive			
	**Mixing ratio with Activator and Reducer:** (By volume)	IME.TB500/10/11/12 PU Topcoat DTM High Gloss IME.AU500 PU Activator **IME.AD600 High Build Additive** IME.RS603 Universal Reducer Fast or IME.RS605 Universal Reducer Medium or IME.RS607 Universal Reducer Slow	5 parts 1 part + 40-80% + 10-20%
	Faster process of drying:	IME.AA600 Accelerator	+ 3 – 5%
IME.TB520 PU Topcoat Basic (in combination with suitable Primer) with IME.AD600 High Build Additive			
	**Mixing ratio with Activator and Reducer:** (By volume)	IME.TB520 PU Topcoat Basic High Gloss IME.AU500 PU Activator **IME.AD600 High Build Additive** IME.RS603 Universal Reducer Fast or IME.RS605 Universal Reducer Medium or IME.RS607 Universal Reducer Slow	6 parts 1 part + 40-80% + 10-20%
	Faster process of drying:	IME.AA600 Accelerator	+ 3 - 5%
	**Viscosity:** 35 – 50 sec. (DIN4/20°C)		

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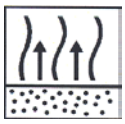
	**Gravity or Suction Feed:** Nozzle set Spray gun "High pressure" Spray gun "Reduce pressure" HVLP (Air cap pressure) Airless/Airmix	1.5 – 2.0 mm 3.0 – 4.5 bar (42 – 65 psi) 1.5 – 2.5 bar (21 – 36 psi) 0.7 bar (10 psi) maximum See info manufacturer	
	**Application:** **Film Thickness:** (Recommended 75 – 150 µm)	**Option 1:** ½ + 1-2 full coats 75 – 100µm (DFT)	**Option 2:** 1 closed light coat followed by 1-2 full coats 120 – 150 µm (DFT)
	**Between coats at 20°C:**	0 – 2 minutes between coats	0 – 5 minutes between coats
	**Air–dry at 20°C:**	**Dust Free:** 1 - 2 hours **Dry to assembly:** 5 - 7 hours **Dry:** 12 - 16 hours	
	**Use suitable respiratory protection (we recommend the use of a fresh air supply respirator).**		
	**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.		