

IME.TB540 PU Topcoat Binder DTM High Gloss**IME.TB540 / AU****Product Information****Product Description:**

IME.TB540 PU Topcoat DTM High Gloss - 70% Binder - 30% Color Toner optional 60% Binder - 40% 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.TB540 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.TB540 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 Icris/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.TB540	Spray	40µm	65µm	55µm	85µm

*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 Universal Reducer, 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)






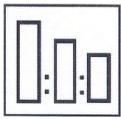
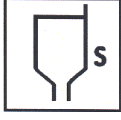


Physical properties:

Chemical base	Polyurethane
Density (kg/l)	1,030 (Binder)
Volume solids (%)	52%
Weight Solids (%)	54%
Flash point	27.5°C
Pot life (+20°C)	Approx. 2 hours
Shelf life	Min. 24 month under normal storage conditions and unopened tins
Coverage (m ²)	Approx. 8.5m ² 40µm (DFT)
Gloss	High Gloss >90GU/20°
Color	Binder Transparent
Temperature Stability	Dry Heat up to 140°C
VOC (g/l)	(VOC: 2004/42/IIIB(c)420g/l)
Processing temperature	+10°C till max. +40°C, max. Humidity 85%

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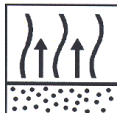





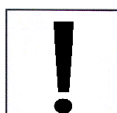
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Application Data

	Cleaning:	IME.RS605/607 Universal Reducer IME.AD690 Solvent Degreaser Valspar Wax and Grease Remover 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.TB540 PU Topcoat Binder DTM High Gloss IMU.CT Range of VIM Color Toners (For mixing formula's see VIM Icris/CRS)	70 parts or 30 parts	60 parts 40 parts
	Mix stick:	Use the Mixing stick M2 4:1 (74-202 = 3:1/4:1)		
	Mixing ratio with Activator and Reducer: (By volume)	IME.TB540 PU Topcoat DTM High Gloss IME.AU540 PU Activator IME.RS603 Universal Reducer Fast or IME.RS605 Universal Reducer Medium or IME.RS607 Universal Reducer Slow	4 parts 1 part + 25%	
	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 40 – 65µm)	Option 1: ½ coat followed by 1 full coat 40 – 50µm (DFT)	Option 2: 1 full closed coat followed by 1 full closed coat 50 – 65µm (DFT)	

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	Between coats at 20°C:	5 minutes	5 – 10 minutes
	Before baking at 20°C:	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:	IME.CC700 Clear Coat Anti Graffiti (See Technical Data Sheet)	
	Recoatable 1hr – 12hrs at 20 °C	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.		