valspar
INDUSTRIAL MIX

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Technical Data Sheet

IME.PB500 PU Primer Binder DTM — IME.PB500 / AU

Product Information

Product Description:
IME.PB500 is a tintable 2K Polyurethane Primer Binder DTM (direct to metal) with excellent corrosion protection, adhesion properties and also very good air and force dry capabilities. Add 20% Color Toner to Binder IME.PB500 to create any color.
All Toners are chromate and lead free, recommended for wet on wet application.

Substrates:
All Iron, steel, cast iron, galvanized steel, aluminum.
Industrial OEM and solvent resistant surfaces, sanded, cleaned original and old cured coatings.

Preparation:
Dry sanding: P150 – P240
Galvanized: Sweep blasting is 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.PB500	Spray	30µm	80µm	40µm	110µm

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)

Topcoat:
Recoat from a range of Valspar Industrial Mix PU Topcoats: IME.TB500/10/11/12/20/40/43.

Physical properties:

Chemical base	Polyurethane
Density (kg/l)	1,368 (Binder)
Volume solids (%)	58.5%
Weight Solids (%)	74%
Flash point	31°C
Pot life (+20°C)	Approx. 2 – 3 hours
Shelf life	Min. 24 month under normal storage conditions and unopened tins
Coverage (m^2)	Approx. 8.5m^2 40µm (DFT)
Gloss	Matt
Color	Binder Transparent
Temperature Stability	Dry Heat up to 140°C
VOC (g/l)	Max. 510g/l see CSF (VOC: 2004/42/IIB(c)540g/l)
Processing temperature	+10°C till max. +40°C, max. Humidity 85%

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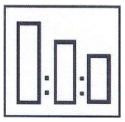
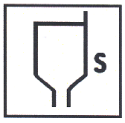
Application Data

	**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:**	**Sanded systems**: P150 – P240 **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.PB500 PU Primer Binder DTM IMU.CT Range of VIM Color Toners (For mixing formula's see VIM CRS)	80 parts 20 parts
	**Mix stick:** Use the mixing stick **M4 8:1** (M3 - 74-204 = 8:1/10:1)		
	**Mixing ratio with Activator and Reducer:** (By volume)	IME.PB500 PU Primer DTM tintable IME.AU500 PU Activator IME.RS603 Universal Reducer Fast or IME.RS605 Universal Reducer Medium or IME.RS607 Universal Reducer Slow	8 parts 1 part + 10-25%
	Faster process of drying:	IME.AA600 Accelerator	+ 3 – 5%
	**Viscosity:** 18 – 30 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 – 1.7 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 1.0 – 1.5 mm	
	**Application:** **Film Thickness:** (recommended 40 – 80µm)	**Option 1: wet on wet** 1 closed coat or ½ + 1 closed coat 30 – 50µm (DFT)	**Option 2: sanded version** 1 full closed coat followed by 1 full coat 60 – 100µm (DFT)

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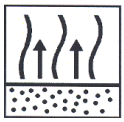	**Between coats at 20°C:** **Before baking at 20°C:**	5 minutes 10 minutes	5 – 10 minutes 10 minutes
	**Air–dry at 20°C:**	Dust Free: 25 – 30 minutes Dry: 8 – 10 hours	
	Force–dry at 60°C – 70°C:	30 minutes / 60°C object temperature	
	**IR–dry:**	12 – 15 minutes (The panel must not reach a temperature above 90°C)	
	**Use suitable respiratory protection (we recommend the use of a fresh air supply respirator).**		
	**Recoatable:** Recoatable 1hr – 24hrs at 20 °C:	PU Topcoat IME.TB500/10/11/12/20/40/43. (see Technical Data Sheets) After 24 hours: Sanding required	
	**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.		