valspar
INDUSTRIAL MIX

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Technical Data Sheet

IME.TB300 Synthetic Topcoat High Gloss IME.TB300 / AU

Product Information

Product Description:
IME.TB300 is a Synthetic Topcoat High Gloss 80% Binder - 20% Color Toner optional 70% Binder - 30% Color Toner (on low opacity colours), with excellent appearance. For Machinery, Industrial OEM and aftermarket repairs with air and force dry capabilities. All Toners are chromate and lead free.

Substrates:
Iron, steel, cast iron, galvanized steel, aluminum and galvanized.
Primer surfaces - IME.FP300, IME.PB300 (Corrosion Protection)
Other - solvent resistant surfaces, sanded, cleaned original and old cured coatings.

Preparation:

PB300/TB300 Synthetic primer dry sanding:	P320 – P400
PB300/TB300 Synthetic primer wet sanding:	P400 – P800
Dry Sanding on substrate:	P180 – P240
Galvanized:	Sweep Blasting recommended.

(More Detailed information go-to Preparation and Pre-treatment on Icris/CRS or website www.valsparindustrialmix.com)

Material Description	Application Method	Minimum DFT µm	Maximum DFT µm	Minimum WFT µm	Maximum WFT µm
IME.TB300	Spray	40µm	50µm	55µm	70µm

*Product can be brushed or rolled.

Cleaning:
Metal substrate surface must be dry and free from any contamination, eg, oil, grease, release agents. Use IME.RS605 Universal Reducer, IME.AD609 Solvent Degreaser or Valspar Wax and Grease Remover.
Primer surface must be dry and free from any contamination, eg, oil, grease, release agents. Use IME.AD609 Solvent Degreaser or Valspar Wax and Grease Remover
(More Detailed information go-to cleaning processes on Irics/CRS or website www.valsparindustrialmix.com)

Note:
IME.RS300 Reducer or IME.AS300 Synthetic Activator can be used. If you use IME.AS300 Synthetic Activator you improve the curing and the chemical resistance.

Physical properties:

Chemical base	Synthetic
Density (kg/l)	1,021 (Binder)
Volume solids (%)	47.9%
Weight solids (%)	54%
Flash point	29°C
Pot life (+20°C)	Approx. 24 hours (as 1K product)
Shelf life	Min. 24 month under normal storage conditions and unopened tins
Coverage (m²/kg)	Approx. 9.5 – 10.5m² (at 40µm dry film thickness)
Gloss	High Gloss >90 Gloss/60°
Color	See VIM - CRS
Temperature Stability	Dry Heat up to 120°C
VOC (g/l)	Max. 580 see CRS Not VOC Complaint 2004/42/IIB(d)420g/l(580)
Processing temperature	+10°C till max. +40°C, max. Humidity 85%

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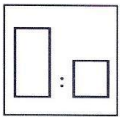
Application Data

	**Cleaning:**	(Metal substrate surface only: IME.RS605 Universal Reducer) Primer surface use: IME.AD690 Solvent Cleaner Valspar Wax and Grease Remover Surface must be dry and free from any contamination, e.g. oil, grease		
	**Preparing:**	**Substrate Dry sanding:** P180 – P240 **Dry sanding:** PB300/TB300 primers: P320 – P400 **Wet sanding:** PB300/TB300 primers: P400 – P800 Extra Corrosion protections use a recommend primer on blasted substrates.		
	**Before using:** The product must be shaken and stirred before and after adding the Color Toners and Dryer. Thoroughly stir directly after the Reducer (or/and Activator) have been added.			
	**Mixing ratio with Color Toner CRS Formula:** (By volume)	IME.TB300 Synthetic Binder High Gloss IMU.CT range of VIM Color Toners (For mixing formula's see VIM CRS) **Synthetic Dryer is included in CRS Formula**	80 parts 20 parts or	70 parts 30 parts
NOTE:	For custom formulas (**ONLY**) add	IME.AA300 Synthetic Dryer	3%	3%
	**Mix stick:** Use the Mixing stick **M2 4:1** (74-202 = 3:1/4:1)			
	**Mixing ratio with Reducer:** (By volume)	IME.TB300 Synthetic Topcoat High Gloss IME.RS300 Synthetic Reducer	100 parts 15–30%	
	Higher chemical resistant: **Use Activator.**	IME.TB300 Synthetic Topcoat High Gloss IME.AS300 Synthetic Activator IME.RS300 Synthetic Reducer	100 parts Max. 25% + 0 – 10%	
	**Viscosity:** 18 - 22 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	 1.3 – 1.6 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 – 1.5mm		

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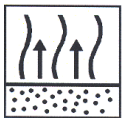
	**Application:** **Film Thickness:** (recommended 40 – 50µm)	1 closed coat followed by 1 full coat 40 – 50µm
	**Between coats at 20°C:**	5 – 10 minutes
	Before baking at 20°C:	10 minutes
	**Air–dry at 20°C:**	**Dust dry:** 20 – 30 minutes **Dry to assembly:** 5 – 7 hours **Dry:** 24 hours
	Force–dry at 60°C:	30 minutes Make sure: 60°C object temperature
	**IR–dry:**	approx.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).**	
	**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.	