EMEAI Valspar bv
Zuiveringweg 89
8243 PE Lelystad
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www.valsparindustrialmix.com

TB520 PU Topcoat Basic High Gloss TB520 / UK

Product Information

Product Description:
TB520 PU Topcoat Basic High Gloss with 80% Binder - 20% Color Toner optional (70% Binder - 30% Color Toner on low opacity colors), TB520 is a two component very fast polyurethane topcoat with very good gloss and flow, especially developed for Industrial OEM and aftermarket repairs. TB520 has excellent air and force dry capabilities and provides very good UV protection. All Toners are chromate and lead free.

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

Substrates:

Surfaces coated with Primers:	FP400/401 Epoxy Primer, FP500/PB500 PU Primer DTM and FP600 Plastic Primer (adhesion test recommended).
.Other:	Solvent resistant surfaces, cleaned/sanded/hardened original and cured coatings.
Dry sanding:	P320 – P400 (Please, check and change abrasive paper regularly as required)
Wet sanding:	P400 – P800
Cleaning:	Surface must be dry and free from any contamination, e.g. oil, grease, release agents, use AD690 Solvent Degreaser.

Material Description: TB520				
Application Method	Minimum DFT µm	Maximum DFT µm	Minimum WFT µm	Maximum WFT µm *
Spraying equipment (not-including airless/airmix)	40µm	60µm	55µm	90µm

* Higher thicknesses possible if given extended drying times

Recoating: Can be coated with CC700 Clear Coat Anti Graffiti (see TDS: CC700)

Additives: (optional) AD601/602 Texture Additive fine/coarse and AD600 High Build Additive (see TDS: AD600/601/602).

Physical properties:

Chemical base	Polyurethane
Density (kg/l)	0,965 (Binder)
Volume solids (%)	40.7%
Weight Solids (%)	46.5%
Flash point	23.5°C
Pot life (+20°C)	Approx. 3 – 4 hours
Shelf life	Min. 24 month under normal storage conditions and unopened tins
Coverage (m²)	Approx. 8.0m² 40µm (DFT)
Gloss	High Gloss >90 GU/60°
Color	Binder Transparent
Temperature Stability	Dry Heat up to 140°C
VOC (g/l)	Max. 590g/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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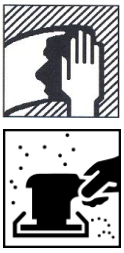
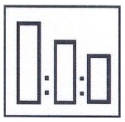
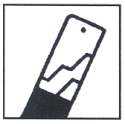
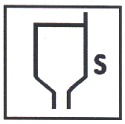
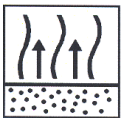
Application Data

	**Preparation/ Cleaning:**	**All surfaces must be properly sanded and cleaned** Dry sanding: P320 – P400 Wet sanding: P400 – P800 Cleaning: AD690 Solvent Degreaser Surface must be dry and free from any contamination, e.g. oil, grease		
	**Handling:**	**Color preparation:** 1. Stir binder until homogeneous 2. Add Color Toners 3. Mix mechanically (paint shaker/ mechanical stirrer)	**Before use/spraying:** 1. Mix mechanically (paint shaker/ mechanical stirrer) 2. Add Activator and Reducer 3. Stir this mixture well with a mixing stick or a (pneumatic) stirrer	
	**Mixing ratio with Color Toner:** (By volume)	TB520 PU Topcoat **Binder** Basic CT Range of VIM Color Toners	80 parts 20 parts or	70 parts 30 parts
	For mixing machine users:	For mixing formula's see VIM CRS	(By weight)	
 	**Mixing ratio with Activator and Reducer:** (By volume)	TB520 PU **Topcoat** Basic AU500 PU Activator RS603 Universal Reducer Fast or RS605 Universal Reducer Medium or RS607 Universal Reducer Slow or RS609 Universal Reducer Ultra Slow	6 parts 1 part add 20 – 35%	
	Mix stick:	Use the Mixing stick **M3 6:1** (74-203 = 5:1/6:1) or **M6 Universal cm-stick** (74-206 standard) / **M7** (74-207 large)		
	Faster process of drying:	AA600 Accelerator	+ 3 – 5%	
	**Viscosity:** 20 – 24 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 – 1.5 mm 3.0 – 4.5 bar (42 – 65 psi) 1.5 – 2.5 bar (21 – 36 psi) 0.7 bar (10 psi) maximum Not recommended 1.0 – 1.5mm		
	**Application:** **Film Thickness:** (recommended 40 – 60µm)	**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 – 60µm (DFT)	
	**Between coats at 20°C:** **Before baking at 20°C:**	2 – 5 minutes 5 minutes	5 – 10 minutes 5 minutes	

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	**Clean up:** (Check the local regulations!)	RS605/607/609 Universal Reducer or Gun cleaner (solvent)
	**Air–dry at 20°C:** **Force–dry at 60°C – 70°C:**	**Dust Free:** 15 – 25 minutes **Dry to assembly:** 1 – 3 hours **Dry:** 6 – 8 hours 20 – 30 minutes (object temperature)
	**IR–dry:**	8 – 12 minutes (The panel must not exceed 90°C)
	**Use suitable respiratory protection (air fed respirator strongly recommended).**	
	**Recoatable:** After: min. 1hr/20°C	CC700 Clear Coat Anti Graffiti (See Technical Data Sheet) After 24 hours: Sanding required (scuff-pad)
	**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 given in writing 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.	