Valspar Automotive
P.O. Box 1461
Minneapolis, MN 55440
1.800.845.2500

www.valsparindustrialmix.com

TB230 Acrylic Enamel 3.5 VOC High Gloss TB230 / US

Product Information

Product Description:
TB230 Acrylic Enamel 3.5 VOC High Gloss - 75% Binder and 25% Color Toner. A one-component, single-stage Acrylic Topcoat with a high gloss finish. Specially developed for Industrial OEM and aftermarket repair industry. Air-dry and force dry capabilities. Also provides excellent UV protection.

Substrates:
Properly prepared Steel and Aluminum substrates, also surfaces sprayed with Epoxy Primer: FP420/423 Epoxy Primer/Sealer (wet on wet or sanded)
Other: Solvent resistant surfaces, cleaned/sanded/hardened original and cured coatings.

Preparation:
Dry Sanding substrate: Steel: P80 – P180 / Aluminum: P180 – P240
Dry Sanding Coating: VIM Primer/existing finishes: P280 – P360
Steel surface Preparation: Abrasive blast to SSPC and NACE recommendation with a uniform blast profile of 0.7 to 2.0mil (20-50µm).
Galvanized: Sweep Blasting recommended.
Note: The layer thickness of the Primer should be three (3) times more than the grade of the shot blasted surface.
(More Detailed information go-to Preparation and Pre-treatment at www.valsparindustrialmix.com)

Cleaning:
Surface must be dry and free from any contamination, e.g. oil, grease, release agents. Use only approved cleaning products per your local regulations. (More Detailed information go-to cleaning processes at www.valsparindustrialmix.com)

Physical Data:

RTS REGULATORY DATA	Mix Ratio 1	1:+0-30%		1:+0-30%	
	Mix Ratio 2	8:1(AE230):+0-30%		8:1(AE230):+0-30%	
		(Reducer Line)		(Exempt Reducer Line)	
		LBS/GAL	g/L	LBS/GAL	g/L
Actual VOC		5.0 Max.	600 Max.	3.15 Max.	378 Max.
Regulatory VOC (less water and exempt solvents)		5.0 Max.	600 Max.	3.5 Max.	420 Max.
Density		8 - 12	960 - 1440	8 - 12	960 - 1440
		WT.%	VOL.%	WT.%	VOL.%
Total Volatile Content		30 – 50	40 - 60	30 – 55	40 – 65
Water Content		0	0	0	0
Exempt Compound Content		0 - 10	0 – 10	0 – 30	0 – 30

Physical properties:			
Chemical base	Acrylic (1K)	Coverage (sq ft - DFT)	Approx. 945sq ft / 1.0mil
Density lbs/gal (kg/l)	9.56 lbs/gal (1.14 kg/L)	Gloss	> 90/20°
Volume solids (%)	60%	Color	Buff
Weight Solids (%)	67%	Temperature Stability	Dry Heat up to 284°F/140°C
Flash point	81.5°F (27.5°C)	Processing temperature	50 – 104°F (+10°C - 40°C)
Pot life / 77°F (+25°C)	Mix Ratio 2: 2-3 hours	Humidity	Until 85% R.H.
Shelf life	Min. 24 month under normal storage conditions and unopened tins		

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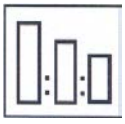
Application Data

	**Cleaning:** Use only approved products per your local regulations	Aluminum, Primed or existing finishes – 170 AquaClean Low VOC WaterBase All metal substrates and existing finishes – AD680 Water Based Cleaner Surface must be cleaned, dry and free from any contamination, e.g. oil, grease	
	**Preparation:**	**Dry sanding substrate:** Steel P80 – P180 / Aluminum P180 – P240 **Dry sanding coating**: Existing finishes P280 – P360 **Galvanized:** Sweep blasting recommended **Abrabsive blast**: with a uniform blast profile of 0.7 to 2mil (20-50µm)	
	**Before using:** The product must be shaken before adding the Color Toners and thoroughly stirred directly after Reducer has been added.		
	**Mixing ratio with Color Toner:** (By Volume)	TB230 Acrylic Enamel 3.5 VOC High Gloss CT Range of VIM Color Toners (For mixing formula's see Collision Core Color	75 parts 25 parts
	**Mixing stick:** Use the mixing stick **M6** (74-206 standard) / **M7** (74-207 large) Universal cm-stick		
	**US National Rule + Canada:** If used as instructed, this product is designed to comply with the US and Canadian National Volatile Organic Compound (VOC) Emission Standards for Automobile Refinish Coatings. Confirm compliance with state and local air quality rules before use. **Component:** Use component as instructed per Valspar guidelines. Verify that intended end use of component is in compliance with state and local air quality rules before use.		
	**Mixing ratio with Reducer:** (By volume)	Ready to use for brush, roller or airless spray (with/without air support)	
		TB230 Acrylic Enamel 3.5 VOC High Gloss RE670/680/690 - Exempt Reducers RS670/RS680/RS690/RS695 - National Rule Reducers	1 part + 0-30%
	Mixing ratio with Activator and Reducer: (By volume)	TB230 Acrylic Enamel 3.5 VOC High Gloss AE230 Activator RE670/680/690 - Exempt Reducers RS670/RS680/RS690/RS695 - National Rule Reducers)	8 parts 1 part + 0-30%
	USA VOC Compliant rules:	For 3.5 VOC areas, use Exempt Reducers (listed above) For National Rule areas, use Solvent Reducers (listed above)	
	**Viscosity:** 20 – 28 sec. (DIN4/68°F/20°C)		
	**Gun set up:** Gravity Feed Siphon Feed HVLP (Gravity Feed) Pressure Pot Airless / and with air support Atomizing Air Pressure	**Nozzle / Tip Size:** 1.6 – 1.8 mm 1.6 – 1.8 mm 1.3 – 15 mm 1.1 – 1.4 mm 013" - .017"	**Air Pressure:** 35-40 psi (2.5-2.8 bar) 35-45 psi (2.5-3.1 bar) 30 psi (2.0 bar) **Inlet Air** 35-40 psi (2.5-2.8 bar) 900 – 1200 psi (60-80 bar) 55-65 psi (3.8-4.5 bar)
	Application:	**For Air spray** 1 medium wet coat	

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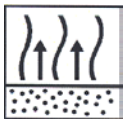
	**Recommended Film Thickness:**	followed by 1 – 2 medium/full wet coats 1.6 – 2.7mil DFT (40 – 65µm)

	**Clean up:** (check the local regulations!)	RS6x0 Reducer Solvent or RE6x0 Exempt Reducer
	**Flash between coats at 77°F/25°C:** **Before baking at 77°F/25°C:**	10 – 15 minutes or until previous coat is non stringing 10 minutes
	**Air–dry at 77°F/25°C:** (DFT dependent)	**Tack Free:** 1 hour **To Tape:** 6 hours **To Recoat:** 16 hours (overnight)
	Force–dry at 140 – 158°F: **(60°C – 70°C)**	30 minutes 140°F/60°C object temperature
	**IR-Dry**	12 – 15 minutes The panel must not reach a temperature above 194°F/90°C.
	**Use suitable respiratory protection (the use of fresh air supply respirator recommended).**	
	**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 at 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 universal 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.