EMEAI Valspar bv
Zuiveringweg 89
8243 PE Lelystad
The Netherlands
Tel. +31 (0) 320292200
www.valsparindustrialmix.com.au

AD602 Texture Additive Coarse AD602 / AU

Product Information

Product Description:
AD602 Texture Additive Coarse to convert the PU Topcoat Series into a fine texture paint surface. AD602 is especially developed for Industrial OEM and aftermarket repainting. The product improves the flexibility with the PU Topcoat, easy to use with force & air-dry capabilities. Different surface effect can be achieved with different spraying techniques. Advice for the standard effect coat: Two Layers with flash-off time in between until covering, wait 10-15 minutes and spray finally one till two crossing drop-coat layers with less pressure and more distance.

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

Substrates:	Steel construction, shipping containers, chassis, cast iron, primed galvanized steel, primed aluminum, glass fiber reinforced plastics (GRP).
DTM Topcoats:	TB510/511/512/TW518/TY518/TB540/543 DTM Topcoat (direct to metal). For a higher level of anti-corrosion performance, we recommend to use of suitable VIM Primer.
Primers:	FP400/401/450/451 Epoxy Primer, FP500/PB500/PB500-S PU Primer DTM
PU Topcoats:	TB500/520 PU Topcoat to use on primed surfaces only.
Steel:	Recommended abrasive blast to SA 2½ or dry sanding P80 – P180
Aluminum:	Because of the wide number of aluminum types we recommend to use primers as described above for the best adhesion and corrosion protection on aluminum before applying this topcoat. For proper preparation of the aluminum substrate follow the steps as described in TI-Aluminum. Sanding aluminum recommendations: P80 – P180*
Galvanized steel:	For proper preparation of the galvanized substrate follow the steps as describe in TI-Galvanized steel.
Stainless steel:	Blasting, followed by a VIM Epoxy Primer
Paint finishes:	P320 – P400
Note:	Please, regularly check and change abrasive paper as required

*In light industrial and commercial transport sectors, many different grades of aluminium are used in manufacture and fabrication. Because of this, good sanding and cleaning is essential to create a sound coating process. Please contact your local technical adviser if unsure of the correct process and or materials.

Cleaning: Surface must be dry and free from any contamination, e.g. oil, grease, release agents, use AD690 Solvent Degreaser.

Material Description: AD602				
Application Method	Minimum DFT µm	Maximum DFT µm	Minimum WFT µm	Maximum WFT µm *
Spraying equipment (not-including airless/airmix)	50µm	70µm	70µm	100µm

* Higher thicknesses require extended drying times

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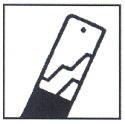
Physical properties:

Chemical base	Hydroxy-acrylic resins /polypropylene
Density (kg/l)	1,007 (Additive)
Volume solids (%)	60.6%
Weight Solids (%)	66.0%
Flash point	27°C
Pot life (+20°C)	Approx. 1 – 2 hours (with PU Topcoats)
Shelf life	Min. 24 month under normal storage conditions and unopened tins
Coverage (m²)	Approx. 8.5 – 9 m²/L at 40µm (DFT)
Gloss	Reduction of gloss
Color	Additive is milky
Temperature Stability	Dry Heat up to 120°C
VOC (g/l)	Max. 600g/l see CRS (VOC: 2004/42/IIB(e)840g/l)
Processing temperature	+10°C till max. +40°C, max. Humidity 85%

Application Data

<table>
<tr><td> 
  </td><td>Preparation/ Cleaning:</td><td colspan="5">All surfaces must be properly abrasive blasted or sanded and cleaned. Abrasive blast steel to EN ISO 12944, Part 4 (SA 2½) with a uniform blast profile.
Dry sanding Steel: P80 – P180
Paint finishes: P320 – P400
Aluminum & Galvanized pre-primed only (see Technical Information- Substrate and Pre-treatment and or primer Technical Data Sheet)
Cleaning: AD690 Solvent Degreaser
Surface must be dry and free from any contamination, e.g., oil, grease</td></tr>
<tr><td>  </td><td>Handling:</td><td colspan="3">Color preparation:
1. Stir binder until homogeneous
2. Add Color Toners
3. Mix mechanically (paint shaker/ mechanical stirrer)
4. Add Texture Additive
5. Mix mechanically (like No. 3)</td><td colspan="2">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</td></tr>
<tr><td rowspan="8"> 
  </td><td rowspan="7">Mixing ratio Binder/Toner:
(By volume)</td><td colspan="3">TB500 PU Topcoat Binder Performance (not Recommended)</td><td>70/30</td><td></td></tr>
<tr><td>TB510/511/512 Binder DTM</td><td></td><td>80/20 or</td><td>70/30</td><td></td></tr>
<tr><td>TW518 PU High Opacity Binder - White</td><td>95/5</td><td></td><td></td><td></td></tr>
<tr><td>TY518 PU High Opacity Binder - Yellow</td><td></td><td></td><td>70/30</td><td></td></tr>
<tr><td>TB520 PU Topcoat Binder</td><td></td><td>80/20 or</td><td>70/30</td><td></td></tr>
<tr><td>TB540/543 DTM Binder</td><td></td><td></td><td>70/30 or</td><td>60/40</td></tr>
<tr><td colspan="5">For mixing machine users, see formula’s in VIM CRS (by weight)</td></tr>
<tr><td>Mixing ratio:</td><td colspan="5">PU Topcoats with AD602 Texture Additive Coarse (use max. 50%)</td></tr>
<tr><td>Mixing ratio:
(By volume)</td><td colspan="3">All mentioned PU Topcoats
AD602 Texture Additive Coarse</td><td colspan="2">2 parts
1 part</td></tr>
<tr><td>Mix stick:</td><td colspan="5">M1 2:1 (74-201 = 1:1/2:1) and/or
M6 Universal cm-stick (74-206 standard) / M7 (74-207 large)</td></tr>
</table>

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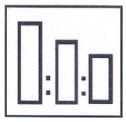
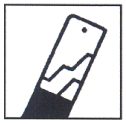
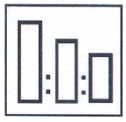
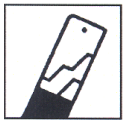
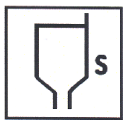
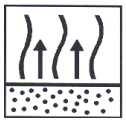
	Recommendation: Texture Additive mixed with a 2K DTM Product is economical and saves time.		
 (By volume)	**DTM** Products – The use of a VIM Primer is optional!	**TB510** PU Topcoat High Gloss + AD602 Texture Additive mixed or **TB511** PU Topcoat Semi Gloss + AD602 Texture Additive mixed or **TB512** PU Topcoat Matt + AD602 Texture Additive mixed AU500 Activator or (HS Activator 576 Fast/574 Slow) RS605 Universal Reducer Medium (603 Fast/607 Slow)	5 parts 1 part add 10-25%
	**Mix stick:**	Use the Mixing stick **M3 5:1** (74-203 = 5:1/6:1) and/or **M6 Universal cm-stick** (74-206 standard) / **M7** (74-207 large)	
	DTM Products – The use of a VIM Primer is optional!	**TW518** PU **Topcoat** + AD602 Texture Additive mixed or **TY518** PU **Topcoat** + AD602 Texture Additive mixed AU500 Activator or (HS Activator 576 Fast/574 Slow) RS605 Universal Reducer Medium (603 Fast/607 Slow)	8 parts 1 part add 25-35%
	Mix stick:	Use the Mixing stick **M4 8:1** (74-204 = 8:1/10:1) and/or **M6 Universal cm-stick** (74-206 standard) / **M7** (74-207 large)	
	**DTM** Products – The use of a VIM Primer is optional!	**TB540** PU **Topcoat** High Gloss + AD602 Texture Additive mixed or **TB543** PU **Topcoat** Matt + AD602 Texture Additive mixed AU540 Activator RS605 Universal Reducer Medium (603 Fast/607 Slow)	4 parts 1 part add max. 25%
	Mix stick:	**M2 4:1** (74-202 = 3:1/4:1) and/or **M6 Universal cm-stick** (74-206 standard) / **M7** (74-207 large)	
	**Note:** In combination with primer!	**TB520** PU **Topcoat** + AD602 Texture Additive (mixed) AU500 Activator or (HS Activator 576 Fast/574 Slow) RS605 Universal Reducer Medium (603 Fast/607 Slow)	6 parts 1 part add 20-35%
	Mix stick:	**M3 6:1** (74-203 = 5:1/6:1) and/or **M6 Universal cm-stick** (74-206 standard) / **M7** (74-207 large)	
	Drying and curing is dependent on speed of the wide range of Activator and Reducer used.		
Faster process of drying:		AA600 Accelerator	add 3%
	**Viscosity:** N/A		
	**Gravity or Suction Feed:** Nozzle set Spray gun “High pressure” Spray gun “Reduce pressure” HVLP (Air cap pressure) Airless/Airmix Pressure Pot	 1.5 – 1,9 mm 3.0 – 4.5 bar (42 – 65 psi) 2.0 – 2.2 bar (21 – 36 psi) 0.7 bar (10 psi) maximum Not recommended 1.2 – 1.5mm	
	**Application:**	1 closed coat → Flash-off around 5 Minutes → 1 full coat Flash-off 10-15 Minutes Effect coat: Spraying 1-2 crossing layers - reduce air pressure (1.5 bar) and double spray distance (30-40 cm).	
	**Film Thickness:**	50 – 70µm (DFT)	
	Before force drying at 20°C:	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:**	**Dust Free:** 1 – 2 hours **Dry to assembly:** 5 – 7 hours **Dry:** 12 – 16 hours 20 – 30 minutes 60°C object temperature
	**IR–dry:**	10 – 16 minutes (The panel must not exceed 90°C)
	**Use suitable respiratory protection (air fed respirator strongly recommended).**	
	**Polish:**	Not recommended
	**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 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.	