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

TB512 PU Topcoat Binder DTM Matt TB512 / AU

Product Information

Product Description:
TB512 PU Topcoat Binder DTM is a two-component matt topcoat, direct to metal polyurethane topcoat. This topcoat contains special pigments which enhances corrosion protection. For a higher level of anti-corrosion performance, we recommend to use of suitable VIM primer. TB512 is specifically developed for commercial vehicle and light-industrial markets, with good force and dry air-dry capabilities. The standard mixing ratio is 80% Binder/20% Color Toner or optional 70% Binder/30% Color Toner for enhanced opacity. Air drying is recommended, force-drying will result in a higher gloss finish. Selection of hardener, reducer & color, can affect viscosity, flash-off time and thickness, this will also have an influence on the end gloss result, too.

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

Substrates:	Steel, stainless steel (Blasted) cast iron, primed galvanized steel, primed aluminum
Plastic:	FP600 Plastic Primer (adhesion test recommended)
Other:	E-coat, solvent resistant surfaces, original and cured coatings, cleaned/sanded
Primer options:	FP400/401/450/451 Epoxy Primer, FP500/PB500 PU Primer DTM
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 described in TI-Galvanized steel.
Stainless steel:	Blasting, followed by a VIM Epoxy Primer
Paint finishes:	P280 – P360
Note:	Please, regularly check and change abrasive paper as required

*In light industrial and CT sectors, many different types of aluminium's 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: TB512				
Application Method	Minimum DFT µm	Maximum DFT µm	Minimum WFT µm	Maximum WFT µm *
Spraying equipment (not-including airless/airmix)	50µm	80µm	70µm	120µm

* Higher thicknesses require extended drying times

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

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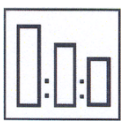
Physical properties:

Chemical base	Polyurethane
Density (kg/l)	1,058 (Binder)
Volume solids (%)	52,3%
Weight Solids (%)	63.0%
Flash point	29.0°C
Pot life (+20°C)	Approx. 1 – 2 hours
Shelf life	Min. 24 months under normal storage conditions and unopened tins
Coverage (m²)	Approx. 8.5m²/L at 40µm (DFT)
Gloss	Semi-Gloss 15–25GU/60°
Color	Binder white-beige
Temperature Stability	Dry Heat up to 140°C
VOC (g/l)	Max. 490g/l see CRS (VOC: 2004/42/IIB(d)420g/l)
Processing temperature	+10°C to max. +40°C, max. Humidity 85%

Application Data

<table>
<tr><td> 
  </td><td>Preparation/ Cleaning:</td><td colspan="4">All surfaces must be properly shot blasted or sanded and cleaned. Abrasive blast to EN ISO 12944, part 4 (SA 2½) with a uniform blast profile of 20-50 micron.
Dry sanding
Steel: P80-P180
Solvent resistant existing ridged paint finishes: P280-P360
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="2">Color preparation:
1. Stir binder until homogeneous
2. Add Color Toners
3. Mix mechanically (paint shaker/ mechanical stirrer)</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="2">  </td><td colspan="2" rowspan="2">Mixing ratio with Color toner:
(By volume)</td><td>TB512 PU Topcoat Binder DTM
CT Range of VIM Color Toners</td><td>80 parts
20 parts or</td><td>70 parts
30 parts</td></tr>
<tr><td colspan="2">For mixing machine users:</td><td colspan="2">For mixing formulas see VIM CRS</td><td>(By weight)</td></tr>
<tr><td rowspan="3"> 
  </td><td colspan="2">Mixing ratio with Activator and Reducer:
(By volume)</td><td colspan="2">TB512 PU Topcoat Binder DTM
AU500 Activator or
AU576 HS Activator Fast or
AU574 HS Activator Slow
RS603 Universal Reducer Fast or
RS605 Universal Reducer Medium or
RS607 Universal Reducer Slow or
RS609 Universal Reducer Ultra Slow</td><td>5 parts
1 part

10–25 %</td></tr>
<tr><td colspan="2">Mix stick:</td><td colspan="3">Use the Mixing stick
M3 5:1 (74-203 =5:1/6:1) or
M6 Universal cm-stick (74-206 standard) / M7 (74-207 large)</td></tr>
<tr><td colspan="2">Faster process of drying:
(By volume)</td><td colspan="2">AA600 Accelerator (with AU500 only)</td><td>Max. 3%</td></tr>
</table>

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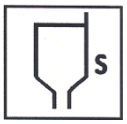
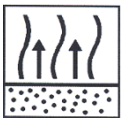
	**Viscosity:** 20 – 26 sec. (DIN4/20°C)		
	**Gravity or Suction Feed:** Nozzle set Spray gun "HP" Spray gun "RP" HVLP (Air cap pressure) Airless/Airmix Pressure Pot	 1.3 – 1.4 mm 3.0 – 4.5 bar (42 – 65 psi) 1.5 – 2.0 bar (21 – 30 psi) 0.7 bar (10 psi) maximum Not recommended 1.0 – 1.3 mm	
	**Application:** **Film Thickness:** (recommended 50 – 80µm)	**Option 1:** ½ coat followed by 1 full coat 40 – 60µm (DFT)	**Option 2:** 1 full closed coat followed by 1 full closed coat 60 – 80µm (DFT)
	**Between coats at 20°C:** **Before baking at 20°C:**	5 minutes 10 minutes	5 – 10 minutes 10 minutes
	**Clean up:** (Check the local regulations!)	RS605/607/609 Universal Reducer or Gun cleaner (solvent)	
	Drying and curing is dependent on speed of the wide range of Activator and Reducer used.		
	Air–dry at 20°C:	**Dust Free:** 1 – 3 hours **Dry to assembly:** 4 – 7 hours **Dry:** 12 – 16 hours	
	Force–dry at 60°C:	20 – 45 minutes (object temperature)	
	**IR–dry:**	10 – 16 minutes (The panel must not exceed 90°C)	
	**Use suitable respiratory protection (air fed respirator strongly 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 Safety Datasheet (SDS). 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.		