

Product Information

Product Description:

AD309 is a Synthetic High Build Additive to convert the VIM Synthetic Topcoat TB300 into a high build coating with excellent protective properties and high chemical resistance. AD309 is especially developed for Industrial OEM and aftermarket repairs. Enables fast operation - reducing costs, (air-dry only recommended). All Toners are chromate and lead free. To improve the curing and the chemical resistance use AS300 Synthetic Activator. The addition of AD309 Synthetic High Build Additive will alter (light) topcoat colors and will reduce the gloss finish.

Preparation:

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

Substrates:

Indoor: Iron, steel, cast iron, galvanized steel, aluminum and glass fiber reinforced plastics.
Outdoor: For metal substrates use FP300/PB300 Synthetic Primer or FP400/401 Epoxy Primer.
Other: Solvent resistant surfaces, cleaned/sanded/hardened original and cured coatings.

Iron/steel: Abrasive shot blasting is recommended or dry sanding P80 – P180
Aluminum: P180 – P240 (Coating on Aluminum up to max. 80µm)
Galvanized: Sweep blasting recommended
Paint finishes: P280 – P360 (please, regularly check and change abrasive paper as required)

Cleaning: Surface must be dry and free from any contamination, e.g. oil, grease, release agents.
 Use RS605/607/609 for metal substrate and AD690 Solvent Degreaser for paint finishes.

Material Description: AD309 Synthetic High Build Additive + TB300 Synthetic Topcoat				
Application Method	Minimum DFT µm	Maximum DFT µm	Minimum WFT µm	Maximum WFT µm *
Spraying equipment	75µm	150µm	100µm	200µm

* Higher thicknesses possible if given extended drying times

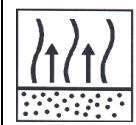

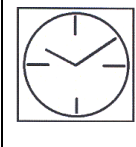


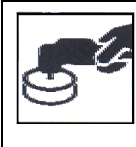
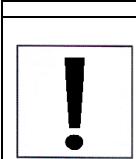
Note: RS300 Reducer or AS300 Synthetic Activator can be used. AS300 Synthetic Activator will improve the curing and the chemical resistance.

Physical properties:

Chemical base	Polyester resins and thixotropic agents
Density (kg/l)	1,085 (Binder)
Volume solids (%)	39,0%
Weight Solids (%)	46,0%
Flash point	8,5°C
Pot life (+20°C)	Approx. 2 – 3 hours
Shelf life	Min. 24 month under normal storage conditions and unopened tins
Coverage (m ²)	Approx. 7.5 – 8 m ² 40µm (DFT)
Gloss	Satin/Semi Gloss
Color Additive	Transparent grey
Temperature Stability	Dry Heat up to 140°C
VOC (g/l)	
Processing temperature	+10°C till max. +40°C, max. Humidity 85%

Application Data

	Preparation/ Cleaning:	<p>All surfaces must be properly shot blast or sanded and cleaned Abrasive blast to EN ISO 12944, part 4 (SA 2.5) with a uniform blast profile of 20 – 50µm. Dry sanding Steel: P80 – P180 Aluminum: P180 – P240 (Coating on Aluminum up to max. 80µm) Galvanized: Sweep blasting recommended Paint finishes: P280 – P360 Cleaning: RS605/607/609 (metal surface) or AD690 Solvent Degreaser (paint finishes) Surface must be dry and free from any contamination, e.g. oil, grease</p>		
	Handling:	<p>Color preparation: 1. Stir binder until homogeneous 2. Add Color Toners 3. Mix mechanically (paint shaker/ mechanical stirrer) 4. Add Additive 5. Mix mechanically (like No.3)</p>	<p>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</p>	
	<p>Mixing ratio with Color Toner: (By volume) For custom formulas (ONLY) add</p>	<p>TB300 Synthetic Topcoat Binder CT Range of VIM Color Toners AA300 Synthetic Dryer</p>	<p>80 parts 20 parts or 3 parts</p>	<p>70 parts 30 parts 3 parts</p>
	<p>For mixing machine users:</p>	<p>For mixing formula's see VIM CRS</p>	<p>(By weight)</p>	
	<p>Mixing ratio with Additive: (By volume)</p>	<p>TB300 Synthetic Topcoat AD309 Synthetic High Build Additive</p>	<p>100 parts 20 – 100 parts</p>	
	<p>Mix ratio with Reducer (4:1) (By volume)</p>	<p>TB300 Topcoat + AD309 High Build Add. RS300 Synthetic Reducer</p>	<p>100 parts add 15–30%</p>	
<p>Possibility:</p>	<p>Mix ratio with Activator and Reducer (4:1 +10%)</p>	<p>TB300 Topcoat + AD309 High Build Add. AS300 Synthetic Activator RS300 Synthetic Reducer</p>	<p>100 parts max. 25 parts add max. 10%</p>	
	<p>Mix stick:</p>	<p>Use the Mixing stick M2 4:1 (74-202 = 3:1/4:1) or M6 Universal cm-stick (74-206 standard) / M7 (74-207 large)</p>		
	<p>Faster process of drying:</p>	<p>AA600 Accelerator</p>	<p>+ 3 – 5%</p>	
	<p>Viscosity: N/A</p>			
	<p>Gravity or Suction Feed: Nozzle set Spray gun “High pressure” Spray gun “Reduce pressure” HVLP (Air cap pressure) Airless/Airmix Pressure Pot</p>	<p>1.5 – 2.0 mm 3.0 – 4.5 bar (42 – 65 psi) 1.5 – 2.5 bar (21 – 36 psi) 0.7 bar (10 psi) maximum 0.009 – 0.013 (see manufacture information) 1.2 – 1.5mm</p>		
	<p>Application: Film Thickness: (recommended 75 – 120µm)</p>	<p>Option 1: ½ coat followed by 1 full coat 40 – 75µm</p>	<p>Option 2: 1 closed coat followed by 1 – 2 full coats 80 – 150µm</p>	

	Between coats at 20°C: Baking:	5 – 10 minutes Not recommended – Only air-dry
	Clean up: (Check the local regulations!)	RS300 Synthetic Reducer, RS60x Universal Reducer or Gun cleaner (solvent)
	Air-dry at 20°C: Force-dry:	Dust Free: 1 – 2 hours Dry to assembly: 12 – 16 hours Dry: 48 hours Not recommended
	IR-dry:	Not recommended
	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 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.	