EMEAI Valspar bv
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www.valsparindustrialmix.com

TB350 Synthetic Fast Drying Topcoat Binder High Gloss TB350 / UK

Product Information

Product Description:
TB350 Synthetic Fast Drying Topcoat Binder High Gloss with 80% Binder + 20% Color Toner, optional (70% Binder - 30% Color Toner on low opacity colors). This product is specially developed for light-industrial markets, with good air- and force dry capabilities. The Topcoat displays good resistance to corrosion and weathering.

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

Substrates:

Indoor:	Steel, cast iron, galvanized steel, aluminum and glass fiber reinforced plastics (GRP).
Outdoor:	For metal substrates and improvement of adhesion and corrosion protection use a suitable VIM primer.
Other:	Solvent resistant surfaces cleaned / sanded / hardened original and cured coatings.
Iron/steel:	Recommended abrasive blast to SA2½ or dry sanding P80 – P180
Aluminum:	Because of the wide range 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 aluminum substrate follow the steps as described in Ti-Aluminum. Sanding recommended P80 – P180*
Galvanized:	For proper preparation of the galvanized substrate follow the steps described in Ti-Galvanized steel. Sweep blasting recommended.
Paint finishes:	P280 – P360
Note:	Please, regularly check and change abrasive paper as required

*In light industrial, many different grades of aluminum 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 Degreaser Solvent Based.

Material Description: TB350 Synthetic Fast Drying Topcoat Binder High Gloss				
Application Method	Minimum DFT µm	Maximum DFT µm	Minimum WFT µm	Maximum WFT µm*
Spraying equipment (not-including airless/airmix)	40µm	50µm	55µm	70µm

*Higher thicknesses require extended drying times

Physical properties:

Chemical base	Modified phenolic, alkyd resin
Density (kg/l)	1,13
Volume solids (%)	49.8%
Weight Solids (%)	61.4%
Flash point	24°C
Pot life (+20°C)	Approx. 24 hours (as 1K product)
Shelf life	Min. 24 month under normal storage conditions and unopened tins
Coverage (m²)	Approx. 9m² 40µm (DFT)
Gloss	High Gloss >80GU/60°
Color	Binder Transparent
Temperature Stability	Dry Heat up to 120°C
VOC (g/l)	Max. 580g/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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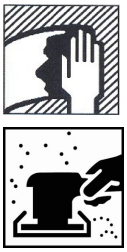
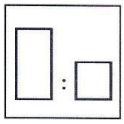
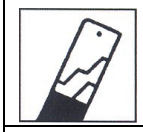
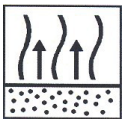
Application Data

	**Preparation/ Cleaning:**	**All surfaces must be properly shot blast or sanded and cleaned** Abrasive blast to EN ISO 12944, part 4 (SA 2½) with a uniform blast profile of 20 – 30µm Dry sanding Steel: P80 – P180 Aluminum/galv. Steel: pre-primed only (Outdoor) Paint finishes: P280 – P360 Cleaning: AD690 Degreaser Solvent Based 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/or Reducer 3. Stir this mixture well with a mixing stick or a (pneumatic) stirrer		
	**Mixing ratio with Color Toner, and Synthetic dryer:** (By volume)	TB350 Synthetic Topcoat **Binder** CT Range of VIM Color Toners AA300 Synthetic Dryer	80 parts 20 parts 3 parts or	70 parts 30 parts 3 parts	
	For mixing machine users:	For mixing formula's see VIM CRS	(By weight)		
	**Mix ratio with Reducer 4:1**	TB350 Synthetic Topcoat **Binder** RS330 Reducer NC or RS300 Synthetic Reducer	100 parts 20 - 30 parts		
	**Mix stick:**	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)			
	**Viscosity:** 18 – 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 – 1.6 mm 3.0 – 4.5 bar (42 – 65 psi) 1.6 – 2.0 bar (23 – 30 psi) 0.7 bar (10 psi) maximum Not recommended 1.0 – 1.3 mm			
	**Application:** **Film Thickness:**	1 closed coat Followed by 1-2 full coat (recommended 40 – 50µm)			
	**Between coats at 20°C:** **Before baking at 20°C:**	5 minutes 5 minutes			
	**Clean up:** (Check the local regulations!)	RS300 Synthetic Reducer, RS330 Reducer NC RS60x Universal Reducer or Gun cleaner (solvent)			

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	**Air–dry at 20°C:**	**Dust Free:** **Dry to assembly:** **Dry:**	15 – 30 minutes 1 – 2 hours 24 hours
	Force–dry:		20 - 30 minutes / 60°C object temperature
	**IR–dry:**		10 – 15 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 Material Safety Datasheet (MSDS). Information also available on our webpage: www.valsparindustrialmix.com/emea/en/		
	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.		