

AD600 High Build Additive - mixed in DTM Topcoats**AD600 / AU****Product Information****Product Description:**

AD600 is a High Build Additive to convert the DTM (direct to metal) PU Topcoats TB510/TB511/TB512 and TB540/TB543 into a high build coating with excellent protective properties and higher chemical resistance. This product combination can be used direct on steel. For a very high level of anti-corrosion performance and as adhesion promotor on gal. steel or aluminum we recommend use of suitable VIM Primer. Specially developed for Industrial OEM, Truck chassis and allover repainting. Ease of use enables fast operation - reducing costs. Addition of AD600 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 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).
Primers:	Use FP400/401/450/451 Epoxy Primer DTM or FP500/PB500 PU Primer
Other:	Solvent resistant surfaces, cleaned/sanded/hardened original and cured coatings.
Steel:	Recommended abrasive blast to SA 2½ or dry sanding P80 – P180
Aluminum:	P120 – P180 *
Galvanized:	Sweep blasting recommended
Paint finishes:	P280 – P360 (please, regularly check and change abrasive paper as required)
Note:	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 AD690 Solvent Degreaser.

*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.

Material Description: AD600

Application Method	Minimum DFT µm	Maximum DFT µm	Minimum WFT µm	Maximum WFT µm *
Spraying equipment (including airless/airmix)	75µm	200µm	100µm	220µm

* Higher thicknesses possible if given extended drying times





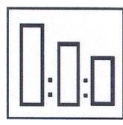

Physical properties:

Chemical base	Polyester resins and thixotropic agents
Density (kg/l)	1,210 (only Additive)
Volume solids (%)	50.3%
Weight Solids (%)	50.0%
Flash point	8.5°C
Pot life (+20°C)	Approx. 2 – 3 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	Satin gloss
Color	Additive transparent grey
Temperature Stability	Dry Heat up to 120°C
VOC (g/l)	Max. 600g/l see CRS (VOC: 2004/42/II(b)(d)420g/l)
Processing temperature	+10°C till max. +40°C, max. Humidity 85%

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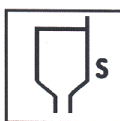
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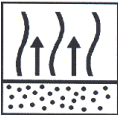




Application Data

 	Preparation/ Cleaning:	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 Solvent resistant existing ridged paint finishes: P280-P360 Aluminum & Galvanized pre-primed only (see Technical Information Sheet - Substrate and Pre-Treatment) Cleaning: AD690 Solvent Degreaser 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) 4. Add High Build Additive 5. Mix mechanically (like No. 3)	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	
Mixing procedure with TB510 / TB511 / TB512				
	Mixing ratio Binder/Toner: (By volume)	TB510 or TB511 or TB512 PU DTM Topcoat Binder VIM Color Toner	80 parts 20 parts or	70 parts 30 parts
		For mixing machine users, see formula's in VIM CRS	(By weight)	
	Option 1:	TB510/TB511 or TB512 PU DTM Topcoat AD600 High Build Additive	100 parts add 10–50 parts	
	Mixing ratio:	TB510/511/512 PU DTM Topcoat + AD600 High Build Additive AU500 Activator or (HS Activator AU576 Fast/ AU574 Slow) RS605 Universal Reducer Medium (RS603 Fast/RS607 Slow)	5 parts 1 part add 10-25%	
	Mix stick:	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)		
	Option 2:	TB510/TB511 or TB512 PU DTM Topcoat AD600 High Build Additive	100 parts add 51-100 parts	
	Mixing ratio:	TB510/511/512 PU DTM Topcoat + AD600 High Build Additive AU500 Activator or (HS Activator AU576 Fast/AU574 Slow) RS605 Universal Reducer Medium (RS603 Fast/RS607 Slow)	6 parts 1 part add 10-25%	
	Mix stick:	Use the Mixing stick M3 6:1 / (74-203 = 5:1/6:1) or M6 Universal cm-stick (74-206 standard) / M7 (74-207 large)		
Mixing procedure with TB540 / TB543				
	Mixing ratio Binder/Toner: (By volume)	TB540 or TB543 PU DTM Topcoat Binder VIM Color Toner	70 parts 30 parts or	60 parts 40 parts
		For mixing machine users, see formula's in VIM CRS	(By weight)	
	Option 1:	TB540 or TB543 PU DTM Topcoat AD600 High Build Additive	100 parts add 10–50 parts	
	Mixing ratio:	TB540/543 PU DTM Topcoat + AD600 High Build Additive AU540 Activator RS605 Universal Reducer Medium (RS603 Fast/RS607 Slow)	4 parts 1 part Max. 25%	

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	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)				
	Option 2:	TB540/TB543 PU DTM Topcoat AD600 High Build Additive	100 parts add 51-100 parts			
	Mixing ratio:	TB540/543 PU DTM Topcoat + AD600 High Build Additive AU540 Activator RS605 Universal Reducer Medium (RS603 Fast/RS607 Slow)	5 parts 1 part Max. 25%			
	Mix stick:	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)				
	Mixing procedure with TW518 White / TY518 Yellow – High Opacity Topcoat / Binder Those Products can be used as Standard Ready for use Topcoat or as Color Binder .					
		Mixing ratio Binder/Toner:	TW518 PU High Opacity Topcoat DTM White VIM Color Toner	100 parts or	95 parts 5 parts	
		Mixing ratio Binder/Toner:	TY518 PU High Opacity Topcoat DTM Yellow VIM Color Toner	100 parts or	70 parts 30 parts	
		(By volume)	For mixing machine users, see formula's in VIM CRS (by weight)			
	Option 1:	TW518 or TY518 PU DTM Topcoat AD600 High Build Additive		100 parts add 10–50 parts		
	Mixing ratio:	TW518/TY518 PU DTM Topcoat + AD600 High Build Additive AU500 Activator or (HS Activator AU576 Fast/ AU574 Slow) RS605 Universal Reducer Medium (RS603 Fast/RS607 Slow)		8 parts 1 part Max. 25%		
		Mix stick:	Use the Mixing stick M4 8:1 (74-204 = 8:1/10:1) or M6 Universal cm-stick (74-206 standard) / M7 (74-207 large)			
		Option 2:	TW518 or TY518 PU DTM Topcoat AD600 High Build Additive		100 parts add 51–100 parts	
		Mixing ratio:	TW518/TY518 PU DTM Topcoat + AD600 High Build Additive AU500 Activator or (HS Activator AU576 Fast/ AU574 Slow) RS605 Universal Reducer Medium (RS603 Fast/RS607 Slow)		10 parts 1 part Max. 25%	
		Mix stick:	Use the Mixing stick M4 10:1 (74-204 = 8:1/10:1) or M6 Universal cm-stick (74-206 standard) / M7 (74-207 large)			
		Faster process of drying for all mentioned Topcoats: (By volume)		AA600 Accelerator		Max. 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	1.4 – 2,2 mm (depends on the amount of AD600) 3.0 – 4.5 bar (42 – 65 psi) 2.0 – 2.2 bar (29 – 32 psi) 0.7 bar (10 psi) maximum 0,011 – 0,013 (see manufacture information) 1.1 – 1.5mm	
	Application: Film Thickness:	Option 1 (AD600 / 10–50 parts): 1 closed coat followed by 1 full coat 50 – 100µm (DFT)	Option 2 / (AD600 / 51–100 parts): 1 full coat followed by 1-2 full coats 100 – 200µm (DFT)
	Between coats at 20°C:	2 – 5 minutes	1 – 5 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: Force–dry:	Dust Free: 1 – 2 hours Dry to assembly: 4 – 10 hours Dry: 16 – 24 hours max. 100µm Thickness: 40-60°C/ max. 30 minutes more than 100µm: Not recommended / only air-dry!	
	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 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.		