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TW518 PU High Opacity Binder DTM High Gloss White — TW518 / AU

Product Information

Product Description:
TW518 PU High Opacity Binder DTM High Gloss White is a two-component, 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. TW518 contains the highest possible amount of white pigments for excellent coverage and fast operation, reducing production times & product consumption. Can be used as direct Topcoat or with 95% white Binder and 5% Color Toner for formulated white colors in CRS. TW518 is specifically developed for commercial vehicle and light-industrial markets, with good force and air-dry capabilities.

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: TW518				
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

Recoating: Can be coated with CC700 Clear coat Anti-Graffiti (see TDS: CC700).

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)	1,548 (Binder)
Volume solids (%)	64.7%
Weight Solids (%)	80.1%
Flash point	28.0°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	High Gloss >90 GU/60°
Color	White
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

Preparation/ Cleaning:

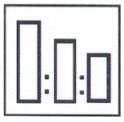
All surfaces must be properly shot blasted or sanded and cleaned. Abrasive blast to EN ISO 12944, part 4 (SA 2½) with a uniform blast profile of 20-50 micron.
Dry sanding
Steel: P80-P180
Solvent resistant existing ridged paint finishes: P280-P360

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

Handling:

Color preparation:	**Before use/spraying:**
1. Stir binder until homogeneous 2. Add Color Toners 3. Mix mechanically (paint shaker/ mechanical stirrer)	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

Use as standard White:	TW518 PU DTM Topcoat	100 parts
Mixing ratio with Color toner: (By volume)	TW518 PU DTM Topcoat	95 parts
	CT Range of VIM Color Toners	5 parts
For mixing machine users:	For mixing formulas see VIM CRS	(By weight)



Mixing ratio with Activator and Reducer: (By volume)	TW518 PU DTM Topcoat	8 parts
	AU500 Activator or AU576 HS Activator Fast or AU574 HS Activator Slow	1 part
	RS603 Universal Reducer Fast or RS605 Universal Reducer Medium or RS607 Universal Reducer Slow or RS609 Universal Reducer Ultra Slow	Add 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)	
Faster process of drying: (By volume)	AA600 Accelerator (with AU500 only)	Max. 3%

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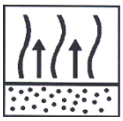
	**Viscosity:** 20 – 26 sec. (DIN4/20°C)		
	**Gravity or Suction Feed:** Nozzle set Spray gun "HP" Spray gun "RP" HVLP (Air cap pressure) Airless/Airmix Pressure Pot	 1.3 – 1.4 mm 3.0 – 4.5 bar (42 – 65 psi) 1.5 – 2.0 bar (21 – 30 psi) 0.7 bar (10 psi) maximum Not recommended 1.0 – 1.3 mm	
	**Application:** **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:** 5 – 8 hours **Dry:** 16 – 20 hours	
	Force–dry at 60°C:	20 – 45 minutes (object temperature)	
	**IR–dry:**	12 – 18 minutes (The panel must not exceed 90°C)	
	**Use suitable respiratory protection (air fed respirator strongly recommended).**		
	**Recoatable:** After: min. 1hr/20°C	CC700 Clear coat Anti-Graffiti (see TDS) After 24 hours sanding is required	
	**Polish:**	Dust and minor imperfections can be polished out after the stated air-dry times have been reached, or after a full bake at 60°C object temperature, followed by a cool down of the object to ambient temperature. Before polishing, make sure the surface is well cured. Follow the instructions of the polish manufacture.	

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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.