

Product Information

Product Description:

TB543 PU Topcoat Binder DTM Low Gloss with 70% Binder - 30% Color Toner, optional (60% Binder – 40% Color Toner on low opacity colours), is a two component, polyurethane topcoat DTM (direct to metal) with a low gloss finish – 20GU/60° gloss reading +/- 10GU this is dependent on color and spray technique. This Topcoat contains anti corrosion chemicals offering excellent corrosion protection. TB543 is especially developed for Industrial OEM and aftermarket repair industry. Application enables fast operation – reducing costs, excellent air-dry and force dry capabilities. All Toners are chromate and lead free and provides excellent UV protection.

Recommendation for air-dry, however force-dry will give a higher gloss result. Selection of hardener, reducer, color, viscosity, application, flash-off time and thickness will all have a influence of the end gloss result too.

Preparation:

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

Substrates: Iron, steel, stainless steel (blasted) cast iron, galvanized steel, aluminum, glass fiber reinforced plastics (GRP).
Primers: FP400/401 Epoxy Primer, FP402 Epoxy Primer Zinc rich,
 (as option) FP500/PB500 PU Primer DTM and FP600 Plastic Primer (adhesion test recommended).
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
Galvanized: Sweep blasting recommended
Paint finishes: P280 – P360 (Please, check and change abrasive paper regularly as required)

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

Material Description: TB543

Application Method	Minimum DFT µm	Maximum DFT µm	Minimum WFT µm	Maximum WFT µm *
Spraying equipment (not-included airless/airmix)	40µm	65µm	55µm	85µm

* Higher thicknesses possible if given extended drying times







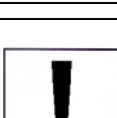
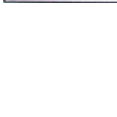
Additive: (optional) AD601/602 Texture Additive fine/coarse and AD600 High Build Additive (see TDS AD600/601/602).

Physical properties:

Chemical base	Polyurethane
Density (kg/l)	1,440 (Binder)
Volume solids (%)	38,0%
Weight Solids (%)	54,0%
Flash point	27,5°C
Pot life (+20°C)	Approx. 1 – 2 hours
Shelf life	Min. 24 month under normal storage conditions and unopened tins
Coverage (m ²)	Approx. 8.5m ² 40µm (DFT)
Gloss	Low Gloss 20GU/60° +/- 10GU
Color	Binder yellowish milky
Temperature Stability	Dry Heat up to 140°C
VOC (g/l)	Max. 500g/l see CRS (VOC: 2004/42/IIB(d)420g/l)
Processing temperature	+10°C till max. +40°C, max. Humidity 85%

Application Data

	Preparation/ Cleaning:	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 Galvanized: Sweep blasting recommended Paint finishes: P280 – P360 Cleaner: AD690 Solvent Degreaser (metal surface & paint finishes) Surface must be dry and free from any contamination, e.g. oil, grease		
	Handling:	Color preparation: 1. Stir binder until homogeneous 2. Add Colour Toners 3. Mix mechanically (paint shaker/ mechanical stirrer)	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 ratio with Color Toner: (By volume)	TB540 PU Topcoat Binder DTM High gloss CT Range of VIM Color Toners	70 parts 30 parts or	60 parts 40 parts
For mixing machine users:		For mixing formula's see VIM CRS		(By weight)
	Mixing ratio with Activator and Reducer: (By volume)	TB543 PU Topcoat DTM Low gloss AU540 PU Activator RS603 Universal Reducer Fast or RS605 Universal Reducer Medium or RS607 Universal Reducer Slow or RS609 Universal Reducer Ultra Slow		4 parts 1 part add max. 25%
	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)		
	Faster process of drying:	AA600 Accelerator	+ 3 – 5%	
	Viscosity: 20 – 26 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	1.4 – 1.8 mm 3.0 – 4.5 bar (42 – 65 psi) 1.5 – 2.5 bar (21 – 36 psi) 0.7 bar (10 psi) maximum Not recommended 1.0 – 1.5mm		
	Application: Film Thickness: (recommended 50 – 65µm)	Option 1: ½ coat followed by 1 full coat 40 – 50µm (DFT)	Option 2: 1 full closed coat followed by 1 full closed coat 50 – 65µm (DFT)	
	Between coats at 20°C:	5 minutes		5 – 10 minutes
	Before baking at 20°C:	10 minutes		10 minutes

	Clean up: (Check the local regulations!)	RS605/607/609 Universal Reducer or Gun cleaner (solvent)
	Air-dry at 20°C:	Dust Free: 25 – 30 minutes Dry to assembly: 3 – 5 hours Dry: 8 – 10 hours
	Force-dry:	Not recommended (30-40 min./60°C)
	IR-dry:	Not recommended
	Use suitable respiratory protection (air fed respirator strongly recommended).	
	Recoatable:	Not recommended (recoating with clear coat)
	Polish:	Not recommended
	<p>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</p> <p>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.</p> <p>With the publication of this Technical Data Sheet all previous versions regarding this product are no longer valid.</p>	