255 Lansdowne Road, Jacobs,
4052, KZN, South Africa
Tel: +27 (0)31 459 8400

Technical Datasheet

Valthane 520 White **LTW1158**

PRODUCT INFO

Product Description:
Valthane 520 PU White Topcoat is a two component, Polyurethane Topcoat with an excellent appearance. For Industrial OEM and repainting, easy to use, chromate and lead free, for air-dry and force-dry, high color fastness and weather resistance.

Surfaces:
Surfaces coated with recommended Valspar Primers. For Plastic substrates – after suitability and adhesion test using Valspar Plastic Primer.
Solvent resistant surfaces, cleaned/sanded/hardened original and old paintwork.

Preparation:
Primer – Wet on Wet or sanded surfaces (Excenter P320-P400) depending of the parts, size and application process. The durability of the coating system largely depends on the thoroughness of the preparation of the surface.

Cleaning:
Surface must be dry and free from any contamination, e.g. oil, grease, release agents. For non wet on wet application, degrease with Silicon remover.

Recoating:
Can be recoated with Valspar Valthane 520 Clear Coat

Physical properties:

Chemical base	Polyurethane
Specific Gravity	1.19 (White base only)
Mixed Volume Solids (%)	46%
Pot life (+20°C)	>4 hours
Coverage (m^2 / litre)	approx 9.0 – 11.5m^2 / litre (@ 40 - 50µm DFT)
Gloss	High Gloss >90 Gloss/60°
Colour	White
Processing temperature	+8°C till max. +40°C, max. Humidity 85%

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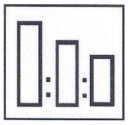
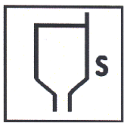
APPLICATION DATA

	**Cleaning** With appropriate cleaners	Surface must be dry and free from any contamination, e.g. oil, grease, release agents	
	**Before use** The product must be thoroughly stirred directly after the Activator and Reducer has been added.		
	**Mixing ratio with Activator and Reducer** (by volume)	**LTW1158** Valthane 520 White **LXC7151** 520/800 PU Hardener **LRC9153** PU Fast Reducer or **LRC9154** PU Medium Reducer or **LRC9155** PU Slow Reducer	4 parts 1 part 0 – 5%
	Faster drying in low ambient temperatures:	**LAC9235** Accelerator (after Activator)	1 – 2%
	**Viscosity** 120 – 130 sec. Ford 4 @ 23°C (Unmixed) 20 – 22 sec. Ford 4 @ 23°C (Mixed)		
	**Gravity or Suction Feed** Nozzle set Spray gun “High Pressure” Spray gun “Reduced Pressure” HVLP (Air cap pressure) Airless / Airmix	 1.3 – 1.6 mm 3.0 – 4.5 bar 1.5 – 2.5 bar 0.7 bar See manufacturer info	
	**Application** **DFT** (Recommended 40 - 50µm)	**Option 1** 1 Closed light coat followed by 1 full coat 35 – 45µm	**Option 2 – Double coat** 2 Full Coats 40 - 50µm

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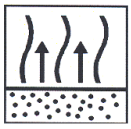	**Between coats: 20°C**	2 – 5 minutes	5 – 10 minutes
	Before baking: 20°C	5 minutes before force-dry	5 minutes before force-dry
	**Air-dry: 20°C**	Dust dry: 15 minutes Dry to assembly: 2 – 3 hours Dry: 8 – 10 hours	
	Force-dry: 60 – 70°C	30 minutes (ensure part temp reaches 65°C)	
	**IR-dry**	5 – 8 minutes Flash-off time, then 8 – 12 minutes Short wave (do not let the part temperature exceed 90°C)	
	**Polish:** (possibility)	Dust and minor imperfections can be polished out after the stated air-dry times have been reached, or after a full bake at 65°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 producer!	
	Use suitable respiratory protection (we recommend the use of a fresh air supply respirator).		
	**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).		
	Note: The products listed are intended only for the professional user and for professional use. All recommendations in words and writing given 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 universal 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.		