

Product Data Sheet

September 2006 (updated in June 2016)

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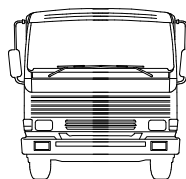
V0200

Turbo Plus™ Multistripe P488-

Product	Description
P488-	Turbo Plus Mixing basics / Ready Mixed finish
P016-170	Turbo Plus Multistripe Fast converter
P016-181	Turbo Plus Multistripe Medium converter
P210-814	Turbo Plus Multistripe Medium activator
P210-815	Turbo Plus Multistripe Fast activator
P850-1390	Turbo Plus Extra Slow thinner
P850-1391	Turbo Plus Slow thinner
P850-1392	Turbo Plus Medium thinner
P850-1393	Turbo Plus Fast thinner

Product Description

The Turbo Plus Multistripe System is a fast, effective basecoat/clear system for producing high quality, durable multicolour effects on commercial vehicles. It is ideally suited for use on cabs and coaches. Multistripe Activator and Multistripe Converter, when added to Turbo Plus Solid Colours will give a very fast drying basecoat finish with tape-up times of 20-40 minutes. Overcoat with Turbo Plus 2-Pack clearcoat to achieve a full gloss finish. Compared to conventional basecoats, the Turbo Plus Multistripe System offers a tougher, more durable finish with significantly improved stone-chip resistance. It is also easier to repair should this be necessary.



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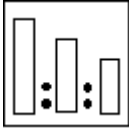







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Process

HVLP and Conventional Application

	<p>Turbo Plus (P488-) 1 part Activator (P210-814/815) 1 part Converter (P016-170/-181) 2 parts Thinner (if required) up to 10%</p>
<p>NOTES</p>	<ol style="list-style-type: none"> 1. Stir the paint well before mixing and use a measuring stick to ensure the correct ratio of paint to Multistripe Activator and Converter. 2. Stir the mix thoroughly before use. 3. For large area applications and/or hot conditions use combination of P016-170, P210-814 and P850-1390.
	<p>Pot Life at 20°C : 4-6 hours</p> <p>Clean gun immediately after use.</p>
	<p>18-21 secs DIN4 (22-27 secs BSB4) at 20°C</p>
	<p>1.4-1.8 mm 2.7-3.3 bar (40-50 psi)</p>
	<p>0.85-1.0 mm Air cap pressure : 0.675 bar (10 psi maximum)</p>
	<p>2 single coats. (For large areas where increased opacity is required, P273-1086, blending clear, may be omitted from the colour formulation, but could result in slight colour change).</p>
	<p>5 minutes between coats 20-40 minutes before application of Clearcoat</p>
	<p>Air dry (20°C) : Mask-up 20-40 mins Recoat : 20-40 mins</p>
<p>MASKING UP</p> <p>RECOAT</p>	<p>Care should be taken to use the correct type of masking tape to produce clean, straight edges, e.g. low tack tape.</p> <p>May be recoated after the above drying times itself, metallic basecoats or 2-pack clearcoats.</p>

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General Process Notes

SUBSTRATE AND PREPARATION

- Freshly applied Turbo Plus** (e.g. when used as a main colour in multicolour designs):
Abrade with Scotch-Brite™ Fine after overnight dry or stoving.
- Turbo Plus Wet-on-Wet Undercoats, Turbo Plus Transparent Undercoat:**
Allow to harden thoroughly, i.e. overnight air dry if cold or 2-4 hours at 20°C prior to overcoating.
- Isocyanate cured Fastbuild:**
Allow to dry overnight prior to topcoating. May be used to seal old synthetic finishes. However, care must be taken to allow each stage to dry **thoroughly** before overcoating.
- 2-pack epoxy primers**
Air-dry overnight or stove at temperatures specified in the PDS before flattening or topcoating. Flattening is recommended to give a smooth surface for topcoating.

RECOAT

The basecoat may be left up to a maximum of 48 hours before application of clearcoat. Basecoated areas which have been left overnight should be lightly tak-ragged before application of clearcoat.

Once all the colours have been applied, the basecoat areas should be coated after 20-30 minutes with Turbo Plus 2-Pack Clearcoat.

APPLICATION EQUIPMENT INFORMATION

For large area application HVLP pressure feed is recommended.

Gravity feed HVLP is more suitable for small areas and multi-stripe applications.

Pressure feed

Air cap pressure : 0.675 bar (10 psi) maximum

Paint pressure : 0.3-1.0 bar (5-15 psi) maximum

If long fluid lines are used, the paint pressure will need to be increased.

DRYING

The drying times quoted are approximate times and will vary depending on drying conditions and film thickness. The colour can be masked up after 20-40 minutes at a paintshop temperature of 20°C. However, temperatures below 20°C, high film thicknesses and poor ventilation will extend the mask-up time

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SELECTION OF CONVERTER AND THINNER

This will depend on temperature, size of job, air movement, gun set-up and personal preference. Up to 10% of Turbo Plus Thinners (P850-1390/-1391/-1392/-1393) may be added to improve the application and minimise overspray, although tape marking might be slightly longer. A rough guide on how to use the different converters is shown below.

Temperature Range for 1/2 to Full Cab

Fast Converter P016-170 / P210-815 Activator	5°C - 20°C
Medium Converter P016-181 / P210-814 Activator	15°C - 30°C
Slow Converter P016-181 / P210-814 Activator / P850-1390 Extra Slow thinner	25°C - 40°C

NOTE : The choice of activator and thinner can extend the temperature range at which the converter can be used.

DECAL APPLICATION

It is **NOT** recommended to apply self-adhesive decals directly over basecoats. They should be applied over the fully cured clearcoat.

RECTIFICATION

Imperfections in the basecoat may be rectified after approximately 45 mins. (at 20°C) using P1200 or finer paper.

These products are for professional use only, and are not to be used for purposes other than those specified. The information on this TDS is based on present scientific and technical knowledge, and it is the responsibility of the user to take all necessary steps in order to ensure the suitability of the product for the intended purpose. For Health and Safety information please refer to the material Safety Data Sheet, also available at: http://www.ppg.com/Autocolor_MSDS

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