



Technical Data Sheet

September 2022

V1010V

INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY

TURBO VISION® High Build Topcoat	
Product	Description
P650-1010	TURBO VISION Premium High Build Binder
P600-9xxx	Coloured Tinters
P210-7644	EHS Hardener - Standard
P210-7642	EHS Hardener - Slow
P210-7606	EHS Plural-Mix Hardener
P852-6440	EHS Thinner - Extra Slow
P852-6442	EHS Thinner - Slow
P852-6444	EHS Thinner - Medium
P852-6446	EHS Thinner - Fast
P852-6448	EHS Thinner - Extra Fast

Product Description

Turbo Vision High Build Topcoat is dedicated for Commercial Transportation Vehicles mainly dedicated for builders.

Turbo Vision High Build Topcoat is an easy to spray topcoat providing good opacity, high gloss and general appearance which meets the standards demanded by the builder and fleet market.

Thanks to the binder formulation, *Turbo Vision* High Build Topcoat:

- covers complex parts of vehicles like rivets, screws, weldings and edges
- can be used from small to large area
- can be sprayed across a large range of temperature conditions
- delivers very high opacity
- provides high sag resistance on overlaps and difficult areas to recoat



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Substrates and Preparation

Prepare the Substrate as follows:

Substrates:

- Original finishes and work in sound condition need to be degreased, cleaned and dry sanded with P320-P400 or (P600 wet) prior to topcoat application.
- Steel, Aluminum, GRP & Zinc coated steel need to be pre-primed with the appropriate primer in order to ensure correct intercoat adhesion and substrate protection.
- TURBO VISION® High Build Topcoat is suitable over all NEXA AUTOCOLOR® primers, surfacers and sealers.



Cleaning:

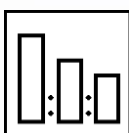


The substrate to be painted must be dry, clean, free of corrosion, grease & mould release agents.

Substrates need to be thoroughly wiped using the appropriate degreaser (P850-1367 Degreaser & P850-1378 Spirit Wipe or P980-9010 low V.O.C cleaner)

Process

Conventional or Pressure Pot Application



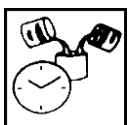
Mixing Ratio by Volume:

For P210-764X Hardeners:

<i>Turbo Vision</i> High Build EHS Topcoat	2
P210-764x Hardener (*)	1
P852-644x Thinner (**)	0.8-1.2

For P210-7606 Hardener ONLY: (High Temperature)

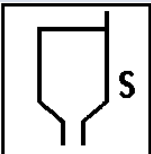

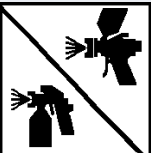



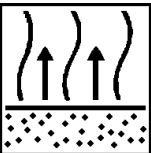

<i>Turbo Vision</i> High Build EHS Topcoat	3
P210-7606 Hardener (*)	2
P852-644x Thinner (**)	0.2-0.5

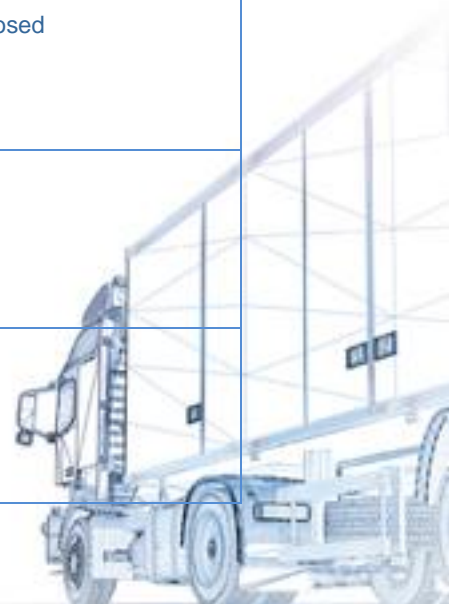


Temperature	<15°C	<15°C	15-20°C	20-25°C	20-30°C	25-35°C	>30°C	>35°C
Combination	Extra Fast	Fast	Standard / Fast	Standard / Slow	Slow / Medium	Slow	Very Slow	Very Slow
Job size	Very small/spot	Small	Small	Medium to Large	Medium to Large	Medium to Large	Large	Large
Hardener (*)	P210-7644				P210-7642			P210-7606
Thinner (**)	P852-6448	P852-6446	P852-6444	P852-6442	P852-6444	P852-6442	P852-6440	P852-6440
Potlife	<30 min	1 hour	> 2 hours	> 2 hours	> 2 hours	> 2 hours	> 2 hours	> 2 hours
Airdry schedule	<1 hour	2 hours	2-3 hours	3 hours	Overnight	Overnight	Overnight	24 hours
Baking schedule	Airdry	20 min @50°C	30 min @50°C	30 min @50°C	30 min @60°C	30 min @60°C	30 min @60°C	30 min @60°C



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Process		
	Conventional, Pressure Pot or Air Assisted Airless	
	Spray Viscosity at 20°C: 24-28 seconds DIN4	
	Potlife @20°C: 2-3 hours	
	1.4-1.5 mm Gravity or Suction feed at 2.0-2.5 bars	
	OR	
	0.8-1.0mm Pressure Pot Air Cap Pressure: 0.68 bar Paint Pressure : 0.3-1.0 bar Fluid flow rate: 280-320 cc/min	
	OR	
	Tip Size: 9 to 11 Thou (0,23 to 0,28 mm) for Air Assisted Airless Paint Pressure: 90-110 bars Air Atomization: 2,5-3 bars	
	Number of Coats	
	<u>1 Visit:</u> 1 light coat + 1 Full coat	<u>2 coats:</u> 1 Medium closed + 1 Full coat
	Dry Film Thickness:	50 – 60 µm 60 – 90 µm
	Flash-Off between coats:	<u>1 Visit:</u> <u>2 coats:</u> 2-3 minutes 10 minutes Flash-Off before bake: 10 minutes
	Stoving at metal temperature of : 50°C 30 minutes with Standard Hardener 60°C 30 minutes with Slow Hardener Into-Service When cool	



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Colour and Gloss

COLOUR MIXING and TINTING

All Tinters should be thoroughly hand stirred when first opened, and then stirred on a mixing machine for 10 minutes before use. Thereafter all tinters should be machine stirred twice a day for at least 10 minutes.

COLOUR CHECKING

As with all refinish paint systems, a colour check should be carried out before painting the vehicle.

General Process Notes

DECAL APPLICATION

It is recommended that TURBO VISION® High Build Ready Mix Topcoat is allowed to cure for at least one week prior to any decal application.

RECOAT

TURBO VISION® Premium High Build EHS Topcoat can be recoated by itself within 8 hours without sanding. If baked, or air-dried longer than 8 hours, the topcoat should be sanded before recoating.

COVERAGE

Approximately 8 to 10 m² per litre of ready for use paint at a dry film thickness of 70 microns depending on thinning ratio used.

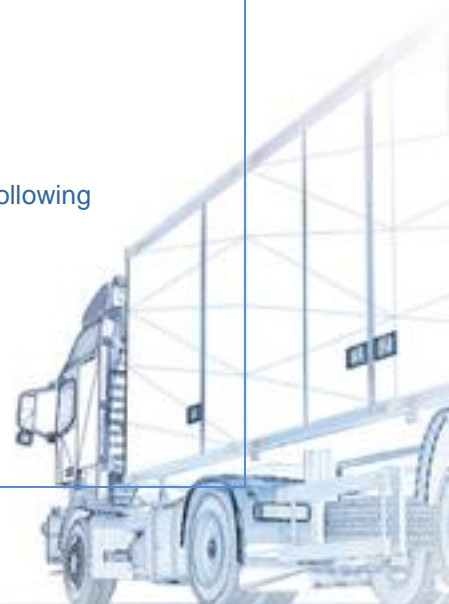
OTHER POINTS TO NOTE

Allow finishes to harden thoroughly before subjecting to vehicle washes. This can take a number of weeks if vehicles are air-dried in cold conditions and/or paint film thickness is excessively high.

STORAGE

Mixing Room Temperature:

Store P600-xxxx Tinters and P651-xxx products in the Mixing Room between the following temperatures: 18 to 25°C.



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Storage Temperature:

Store P600-xxxx Tinters and P650-xxx products between the following temperatures:
5 to 35°C (41 to 95°F).

Store in accordance with local regulations. Store in original container protected from direct sunlight in a dry, cool and well-ventilated area, away from incompatible materials and food and drink. Keep container tightly closed and sealed until ready for use.

Containers that have been opened must be carefully resealed and kept upright to prevent leakage. Do not store in unlabelled containers.

Use appropriate containment to avoid environmental contamination.

Always refer to the material Safety Data Sheet.

VOC INFORMATION

The EU limit value for this product (product category: IIB.d) in ready to use form is max. 420g/litre of VOC. The VOC content of this product in ready to use form is max. 420g/litre.

Depending on the chosen mode of use, the actual ready to use VOC of this product may be lower than that specified by the EU Directive code.

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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