



Technical Data Sheet

V1020V

July 2022

INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY

TURBO VISION® Premium High Productivity Topcoat	
Product	Description
P650-1020	Premium High Productivity Binder
P650-6000	Premium Matt Binder
P600-9xxx	Coloured Tinters
P210-7606	EHS Pluralmix Hardener
P852-6454	EHS Thinner - Medium

Product Description

Turbo Vision Premium High Productivity Topcoat is dedicated for builders of Commercial Transportation Vehicles.

Turbo Vision Premium High Productivity Topcoat is an easy to spray topcoat which can be applied by high pressure application methods including air-assisted airless spray. It is also suitable for electrostatic spray application and use through plural-mix equipment.

It provides 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* Premium High Productivity Topcoat:

- Covers complex parts of vehicles like rivets, screws, welds and edges
- Can be used on small to large areas
- Can be sprayed across a range of temperature conditions
- Delivers very high opacity
- Provides high sag resistance on overlaps and difficult areas to recoat
- Can be adjusted to optimal viscosity for plural-mix equipment.



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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® Premium High Productivity Topcoat is suitable over all NEXA AUTOCOLOR® primers, surfacers and sealers.



Cleaning:

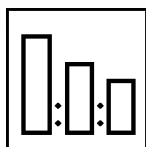
The substrate to be painted must be dry, clean, free of corrosion, grease & mould release agents.

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

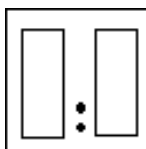
Conventional, Pressure-Feed or Air-Assisted Airless Application



Mixing Ratio by Volume:

<i>Turbo Vision</i> Premium High Productivity Topcoat	3
P210-7606 Hardener	2
P852-6454 Thinner	0.7-0.9

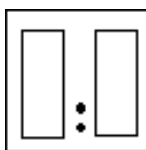
Pressure-Feed or Air-Assisted Airless Application – 2K Plural Mix



For 2K Plural-Mix equipment, it is recommended that the topcoat is pre-thinned, then the pre-thinned topcoat is activated by Plural-Mix

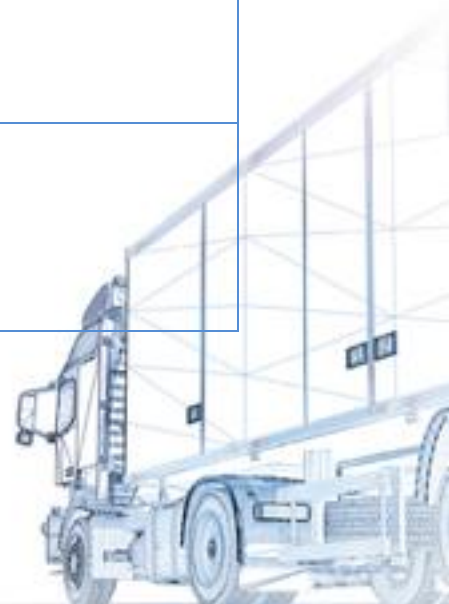
Pre-Thinning (mixing by volume):

<i>Turbo Vision</i> Premium High Productivity Topcoat	3
P852-6454 Thinner	0.7-0.9

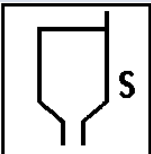



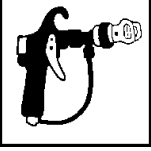

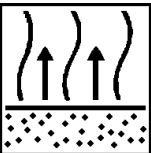



Activation of Pre-Thinned Topcoat via Plural-Mix Equipment:

<i>Turbo Vision</i> Premium High Productivity Topcoat (Prethinned)	2
P210-7606 Hardener	1



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Process		
	Conventional, Pressure-Feed or Air-Assisted Airless Application	
	Spray Viscosity at 20°C: 27-29 seconds DIN4	
	Potlife @20°C: 2-3 hours	
	Tip Size: 1.4-1.5 mm tip for Gravity or 1.6-1.8mm for Suction feed Air Pressure: 2.0-2.5 bars (consult spray equipment manufacturer's recommendations)	
	Tip Size: 0.8-1.0mm for Conventional Pressure-Feed (low pressure) Air Pressure: 2.0-2.5 bars (consult spray equipment manufacturer's recommendations) Paint Pressure: 0.3-1.0 bar Fluid flow rate: 280-320 cc/min	
	Tip Size: 9 to 11 Thou (0.23 to 0.28 mm) for Air Assisted Airless spray Paint Pressure: 90-110 bars Air Pressure (atomization): 2.5-3 bars For Electrostatic Application, a set up of 60kV Tension and 20µA is recommended	
	Number of Coats	
	<u>1 Visit:</u> 1 Light coat + 1 Full coat Dry Film Thickness: 40-60 µm	<u>2 Coats:</u> 2 Full coats 50-70 µm
	<u>1 Visit:</u> Flash-Off between coats: 2-3 minutes Flash-Off before bake: 10 minutes	<u>2 Coats:</u> 10-20 minutes 10 minutes
	Stoving at metal temperature of : 50-60°C 30 minutes Into-Service When cool	



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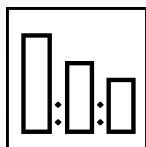
Matt and Semi Gloss Finishes

Matt and Semi-Gloss finishes can be achieved using the matting chart below. Please note that activation ratios are different those for gloss finishes

MATTING CHART:

FOR WHITE COLOURS			FOR OTHER COLOURS			Activation RATIO (by volume)	GLOSS 60°
P650-6000 MATT Binder quantity (by weight)	P650-1020 Gloss Binder Quantity (by weight)	Toners quantity (by weight)	P650-6000 MATT Binder quantity (by weight)	P650-1020 Gloss Binder Quantity (by weight)	Toners quantity (by weight)		
60	-	40	70	-	30	3:1:1.1-1.6	<10
54	6	40	63	7	30	3:1:1.1-1.6	10-25
48	12	40	56	14	30	3:1:1.1-1.6	25-40
45	15	40	52	18	30	2.25:1:0.75-1.1	40-50
42	18	40	49	21	30	2.25:1:0.75-1.1	50-60
36	24	40	42	28	30	2.25:1:0.75-1.1	60-70
30	30	40	35	35	30	2.25:1:0.75-1.1	70-80
24	36	40	28	42	30	2.25:1:0.75-1.1	80-85
-	40	60	-	40 - 60	40 - 60	3:2:0.7-0.9	>90

For 2K Plural Mix Equipment



Prethinning of the topcoat:

Turbo Vision Premium High Productivity Topcoat
P852-6454 Thinner

**By Volume:
10-40% Gloss**

2 parts
1 part

**By Volume:
40-85% Gloss**

3 parts
1 part

Activation through Pluralmix Equipment:

Turbo Vision Premium High Productivity Prethinned Topcoat
P210-7606 Hardener

4.5 parts
1 part

3 parts
1 part

Colour Mixing

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.

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



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General Process Notes

DECAL APPLICATION

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

COVERAGE

Approximately 9 to 12 m² per litre of ready for use paint at a dry film thickness of 60 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.

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.

The EU limit value for TURBO VISION® Matt, Semi-Matt, and Semi-Gloss Topcoat (product category: IIB.e) in ready to use form is max. 840g/litre of VOC. The VOC content of this product in ready to use form is max. 840g/litre.



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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

For further information please contact:

Customer Service Sales Group
PPG Industries (UK) Ltd
Needham Road
Stowmarket
Suffolk IP14 2AD
Tel: 01449 771771
Fax: 01449 773472

