

# Product Data Sheet

September 2006

INTERNATIONAL MASTER  
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# W0120

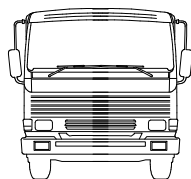
## Turbo Plus™ 2-Pack Clearcoat P190-555

| <i>Product</i> | <i>Description</i>                |
|----------------|-----------------------------------|
| P190-555       | Turbo Plus 2-Pack Clearcoat       |
| P210-820       | Turbo Plus Extra Slow MS Hardener |
| P210-821       | Turbo Plus Slow MS Hardener       |
| P210-822       | Turbo Plus Medium MS Hardener     |
| 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

P190-555 is a high quality 2-pack acrylic clearcoat specially formulated to provide outstanding gloss and final appearance over **Nexa Autocolor** Commercial Transport basecoat systems, e.g. Turbo Plus Multistripe basecoat (P488-) or Turbo Plus Metallic basecoat (P492-).

The range of Turbo Plus MS hardeners and thinners provide easy application over large areas and a tough durable finish with excellent stone chip resistance.



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# Process

## HVLP and Conventional Application



P190-555 5 parts  
 Turbo Plus MS Hardener 2 parts  
 Turbo Plus Thinner if required add up to 10%

### NOTES

1. Stir IMMEDIATELY after activation.
2. Do NOT use the Multistripe Activator P210-815/-814



**Pot Life at 20°C :** 4-6 hours  
 The activated paint should be applied as soon as possible after activation.  
 Clean gun immediately after use.



16-18 secs DIN4  
 (20-23 secs BSB4) at 20°C



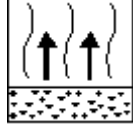
1.4-1.8 mm  
 3.0-3.7 bar (45-55 psi)



1.0-1.4 mm  
 Air cap pressure : 0.675 bar (10 psi maximum)



2-3 single coats depending on final finish required.



Minimum of 10 minutes between coats  
 No flash off required before stoving



**Air dry (20°C):**  
 Dust free 10 –15 minutes  
 Handleable (light pressure) 6 hours  
 Into-Service 16 hours

**Stoving at metal temperature of:**  
 40°C 120 minutes  
 50°C 60 minutes  
 60°C 30 minutes  
 70°C 20 minutes  
 Into-Service When cool

Longer warm-up times may be required for heavy sections to reach temperature.

### RECOAT

After "Into-Service" times

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# General Process Notes

## SUBSTRATES AND PREPARATION

Turbo Plus Multistripe basecoat (P488-) or Turbo Plus Metallic basecoat (P492-).

Normally flattening of Turbo Plus Multistripe or Turbo Plus Metallic basecoat is not required. However, imperfections in the basecoat may be rectified after approximately 45 minutes air-dry using P1200 or finer paper.

Basecoated areas which have been left overnight should be dust free before application of P190-555.

## RECOAT

P190-555 can be recoated with itself or any other **Nexa Autocolor** Commercial Transport primer, undercoat or topcoat after the Into-Service times stated.

## APPLICATION EQUIPMENT INFORMATION

### HVLP

The most suitable HVLP gun for the application of Commercial Transport products is the pressure feed system.

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. Poor ventilation, temperatures below 20°C and excessive film thickness will extend the drying times.

## THINNER ADDITION

Addition of thinner is not normally required, however, up to 10% Turbo Plus Thinner may be added to adjust application to suit other conditions, e.g. hot temperatures.

## DECAL APPLICATION

Ensure that the paint system is fully cured prior to the application of self-adhesive decals. This may take longer than the stated "Into Service" times and will vary according to paint systems used, film thickness, application and drying conditions, type of decal used, etc.

P190-555 is **NOT** recommended for use over self-adhesive decals.

## 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 thicknesses are excessively high.

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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](http://www.ppg.com/Autocolor_MSDS)

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