

Product Data Sheet

July 2014

INTERNATIONAL MASTER
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W1200V

EHS Turbo Plus™ Rapide P275-455

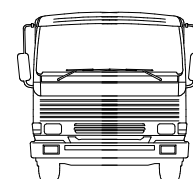
<i>Product</i>	<i>Description</i>
P275-455	EHS Turbo Plus Rapide
P498-	EHS Turbo Plus Colours
P210-9652	EHS Turbo Plus Medium Hardener
P852-179x	EHS Turbo Plus Additive Thinners

Product Description

The EHS Turbo Plus Rapide Process is designed to improve through hardening of EHS Turbo Plus solid colours at low and ambient temperatures (below 20°C).

P275-455 is based on an innovative and unique catalyst solution which when added to activated and thinned EHS Turbo Plus solid colours gives a very fast air drying or low bake system. At the same time the other excellent properties of the EHS Turbo Plus system are maintained.

P275-455 is particularly suitable for use when a second colour is to be applied and faster tape free times are required.

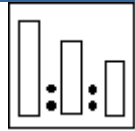


Process

HVLP and Conventional Application

Standard Process

Higher Build Process



P498-Line 3 parts
 P210-9652 2 parts
 P852-179X 0,5 part

P498-line 4 parts
 P210-9652 2 parts
 P852-179X 0,7 part



Then add P275-455 at up to 50 ml per litre of activated and thinned paint

Pot Life at 20°C : 1 hour

Pot Life at 20°C : 1 hour

NOTE

Higher temperatures will shorten the pot life significantly

Clean gun immediately after use.



19-24 secs DIN4
 (25-32 secs BSB4) at 20°C

23-27 secs DIN4
 (29-36 secs BSB4) at 20°C



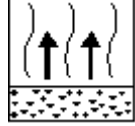
1.0-1.4 mm
 Use compliant spray equipment

1.0-1.4 mm
 Use compliant spray equipment



2 single coats
 60-75 microns (2.5-3.0 thou)

2 single coats
 75-100 microns (3.0-4.0 thou)



A maximum of up to 30 minutes between coats

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Air dry (20°C) :
 Dust free 20-40 mins
 Handleable 4-6 hours
 Tape marking : 4-6 hours
 Into-Service : 16 hours

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 Dust free : 20-40 mins
 Handleable : 4-6 hours
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 Into-Service : 16 hours

Stoving at a surface temperature of
 40°C 45-60 minutes
 50°C 30-45 minutes
 60°C 15-30 minutes
 Recoat: after into service times

Stoving at a metal temperature of
 40°C 45-60 minutes
 50°C 30-45 minutes
 60°C 15-30 minutes
 Recoat: after into service times

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General Process Notes

APPLICATION EQUIPMENT INFORMATION

HVLP

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

Use a compliant spray gun.

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

CATALYST ADDITION

1. The P275-455 container has a reservoir which holds 25 ml, therefore 2 additions will be required for each litre of ready for use EHS Turbo Plus topcoat.
2. To dispense 25ml carefully squeeze the bottle to fill the reservoir to the 25ml mark and allow excess to drain back into the bottle.
3. Do **NOT** use more than the recommended amount of 50 ml per litre of activated and thinned paint.
4. Stir the mix thoroughly before use.

FLASH OFF

The very fast curing of P275-455 results in a different drying behaviour from standard EHS Turbo Plus systems. It is therefore essential that the flash-off times between coats are kept between 5-30 minutes or longer than 3 hours. Flash off times between 30 minutes and 3 hours may lead to film lifting under certain conditions.

DECAL APPLICATION

It is recommended that P498-line is allowed to cure for at least one week prior to decal application.

OTHER POINTS TO NOTE

1. Apply immediately after addition of P275-455. The high reactivity of this system results in a reduced pot life.
2. The drying times quoted are approximate times and will vary depending on drying conditions and film thickness. Poor ventilation, low temperatures and excessive film thickness will extend the drying/mask-up times.
3. 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.
4. P275-455 should only be used with EHS Turbo Plus single layer solid colours and EHS Turbo Plus Clearcoat P190-1230. Do **NOT** use with any **Basecoats, primers or undercoats**.



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VOC INFORMATION

The EU limit value for this product (product category: IIB.c) in ready to use form is max. 540g/litre of VOC.
The VOC content of this product in ready to use form is max. 540g/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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