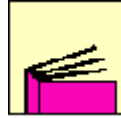


FOR PROFESSIONAL USE ONLY



# V3620

Date of issue : September 2002

## Turbo Plus™ Multistripe

Products	
P486-	Turbo Plus colour mixes and ready mixed colours
P488-	Turbo Plus mixing basics
P016-181	Turbo Plus Multistripe Medium converter
P016-191	Turbo Plus Multistripe Slow 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

### 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.



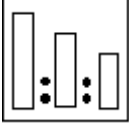





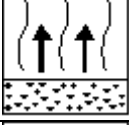

**THESE PRODUCTS ARE FOR THE PROFESSIONAL PAINTING OF AUTOMOTIVE VEHICLES ONLY AFTER REFERENCE TO THE MANUFACTURER'S MATERIAL SAFETY DATA SHEET**

# Turbo Plus Multistripe P486



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## PROCESS

HVLP and Conventional Application	
	Turbo Plus (P486-) 1 part Activator (P210-814/-815) 1 part Converter (P016-181/-191) 2 parts Thinner (if required) up to 10%
<b>NOTES</b>	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 P210-191 and P210-814.
	<b>Pot Life at 20°C :</b> 4-6 hours  Clean gun immediately after use.
	18-21 secs DIN4 (22-27 secs BSB4) at 20°C
	1.4-1.8 mm 2.7-3.3 bar (40-50 psi)
	1.0-1.4 mm  Air cap pressure : See manufacturers recommendations
	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).
	5 minutes between coats 20-40 minutes before application of Clearcoat
	<b>Air dry (20°C) :</b> Mask-up 20-40 mins Recoat : 20-40 mins
<b>MASKING UP</b>	Care should be taken to use the correct type of masking tape to produce clean, straight edges, e.g. low tack tape.
<b>RECOAT</b>	May be recoated after the above drying times itself, metallic basecoats or 2-pack clearcoats.



## GENERAL PROCESS NOTES

### SUBSTRATES AND PREPARATION

- 1. 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.
- 2. Turbo Plus Wet-on-Wet Undercoats :**  
Allow to harden thoroughly, i.e. overnight air dry if cold or 2-4 hours at 20°C prior to overcoating.
- 3. 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.
- 4. 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 thoroughly cleaned 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 Compliant pressure feed is recommended.

Gravity feed Compliant 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

### 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) 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

Medium Converter P016-181 / P210-814 Activator	15°C - 30°C
Slow Converter P016-191 / P210-814 Activator	25°C - 40°C

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

# Turbo Plus Multistripe P486-



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## GENERAL PROCESS NOTES

### 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.

**This information is given in good faith but without warranty.**

For further information please contact:  
Customer Service and Sales Group  
PPG Industries (UK) Ltd  
Needham Road  
Stowmarket  
Suffolk, IP14 2AD

**Tel: 01449 771771**  
**Fax: 01449 773472**

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