

TURBO VISION[®]



Technical Data Sheet

Y0104V

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**INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY**

TURBO VISION[®] Multistripe Process

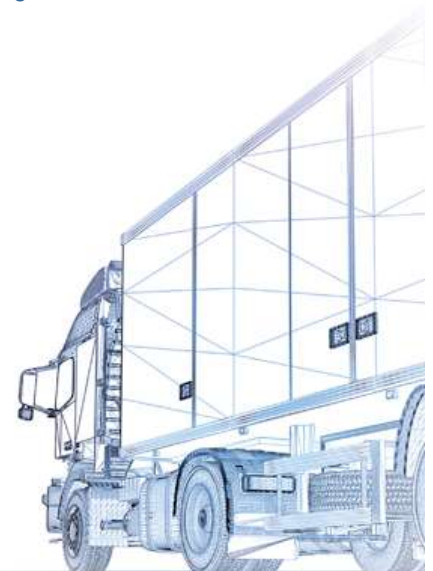
<i>Product</i>	<i>Description</i>
<i>P650-1000</i>	<i>Premium EHS High Flow Binder</i>
<i>P650-1010</i>	<i>Premium EHS High Build Binder</i>
<i>P600-9xxx</i>	<i>Coloured Tinters</i>
<i>P210-7644</i>	<i>EHS Hardener - Standard</i>
<i>P852-6448</i>	<i>EHS Thinner - Extra Fast</i>

Process Description

Turbo Vision Multistripe Process is a fast Direct Gloss system for producing multicolour drawings and effects on commercial vehicles, using Turbo Vision EHS Premium High Flow or High Build Topcoat

Extra Fast Thinner will give a very fast drying topcoat which can be masked with tape and paper after just 45 minutes at room temperature.

If required to smooth the interlayer edge Turbo Vision EHS Premium Binder activated in a multistripe process can be recoated within 8 hours with P190-1280 or P190-1400 CT Clearcoat without flattening.

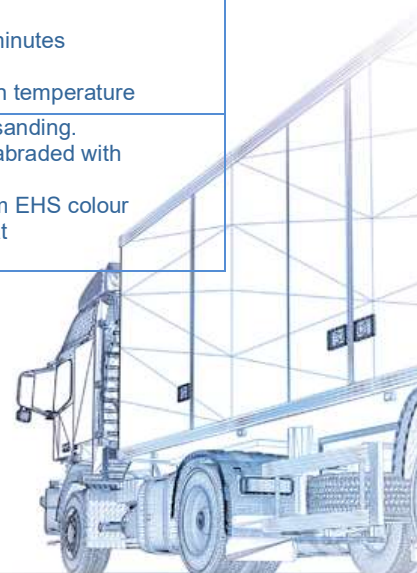
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Process	
Conventional or HVLP Application	
	Mixing Ratio by Volume: <i>Turbo Vision</i> Premium EHS Topcoat (High Flow or High Build) 2 P210-7644 Hardener 1 P852-6446 Extra Fast Thinner 1
	Spray Viscosity at 20°C: 18-22 seconds DIN4
	1.3-1.4 mm Gravity or 1.6 mm suction feed at 2.0-2.4 bars <u>IMPORTANT: Potlife at 20°C is maximum 20 minutes</u> <u>Clean spraygun immediately after use</u>
	Number of Coats <u>1 Visit:</u> 1 very light coat + 1 full coat Dry Film Thickness: 40 – 50 µm (higher build might extend drying time)
	Flash-Off between coats: 1 minute Flash-Off before bake: 10 minutes when baked MASKING UP 45 (*) minutes at 20°C or 10 minutes at 60°C and cool down 20 minutes (*) times may vary according to spraybooth temperature
	Recoatability Between 45 minutes and 8 hours without sanding. If left over 8 hours, the surface should be abraded with Scotchbrite before recoating. Recoat with another <i>Turbo Vision</i> Premium EHS colour or with P190-1280 or P190-1400 Clearcoat (see TDS W0617V or W0640V).

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General Process Notes

SUBSTRATE AND PREPARATION

1. **Freshly applied Turbo Vision EHS Premium High Flow or High Build EHS topcoat** (e.g. when used as a main colour in multicolour designs):

Abrade with Scotch-Brite™ Fine after air drying of more than 8 hours or after stoving.

2. **Wet-on-Wet Undercoats or Transparent Undercoat**

Allow to get a fully dried and even surface before topcoating.

3. **1-pack or 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.

If not possible to get a smooth surface, spray a light coat of wet-on-wet undercoat and let it dry properly prior recoating with topcoat activated for multistripe process.

RECOAT

The topcoat may be left up to a maximum of 8 hours without abrading before application of another colour or of a clearcoat. If left over 8 hours, or baked, the surface should be abraded with Scotchbrite before recoating.

DRYING

It is recommended to leave the topcoat air drying at least 45 minutes at 20°C prior recoating. Cooler conditions and high film builds might extend the drying and mask up time.

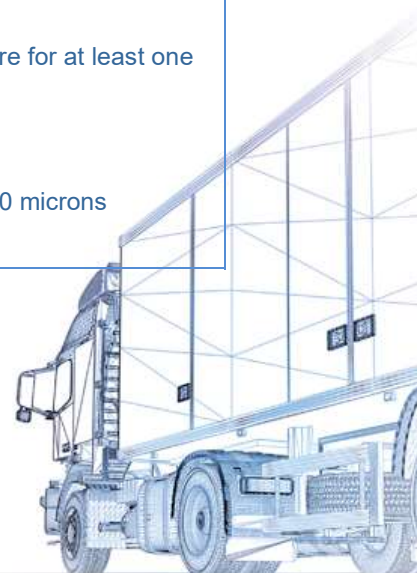
DECAL APPLICATION

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

COVERAGE

Approximately 12-13 m² per litre of ready for use paint at a dry film thickness of 50 microns depending on thinning ratio used.

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Colour

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.

COLOUR CHECKING

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

VOC INFORMATION

The EU limit value for this product (product category Topcoats: 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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