

Product Data Sheet

October 2008



FOR PROFESSIONAL USE ONLY

V1900V

EHS Hi-Gloss 383™ P383-Line

<i>Product</i>	<i>Description</i>
<i>P383-Line</i>	<i>EHS Hi-Gloss 383</i>
<i>P850-1597</i>	<i>EHS Adjuster Thinner</i>
<i>P565-669</i>	<i>Synthetic Matting Agent</i>
<i>P272-560</i>	<i>Drier Solution</i>
<i>P275-499</i>	<i>Winter Accelerator</i>
<i>P276-88</i>	<i>Brushing Retarder</i>

Product Description

EHS Hi-Gloss 383 is a one pack polyurethane topcoat specially formulated for use on commercial vehicles. It provides a finish with outstanding gloss and good durability, built to withstand the rigours of commercial use. EHS Hi-Gloss 383 can be used as an original finish or for respray and repair work.

EHS P383 has been developed in accordance with the UK VOC regulations for Stage 2 topcoats as laid down in PG6/34.

In ready-for-use mode, the VOC content of this product is lower than 420 g/l.



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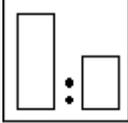
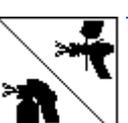
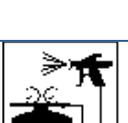
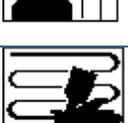
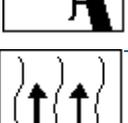
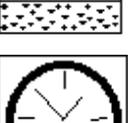
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Process

	Cold Spray	Hot Spray The paint to be applied should be heated in an approved apparatus to 70-80°C	Airless Spray
	EHS Hi-Gloss 383 10 part P850-1597 1 parts	EHS Hi-Gloss 383 1 part Can be thinned up to 5% for ease of application	EHS Hi-Gloss 383 1 part Can be thinned up to 5% for ease of application
	Stir paint well before thinning.	Stir paint well before thinning.	Stir paint well before thinning.
	30-42 secs BSB4 at 20°C (24-31 secs DIN4) at 20°C		50-70 secs BSB4 at 20°C (36-51 secs DIN4) at 20°C
	1.8-2.2 mm 2.7-4.7 bar (40-70 psi)	1.8-2.2 mm 2.7-4.7 bar (40-70 psi)	
	Gravity/Suction 1.4-1.8 mm Pressure 1.0-1.2 mm Air cap pressure: 0.675 bar (10 psi) maximum	Gravity/Suction 1.4-1.8 mm Pressure 1.0 mm Air cap pressure: 0.675 bar (10 psi) maximum	
			0.22-0.33 mm (9-13 Thou) 130 - 200 bar (2000 - 3000 psi)
	1 mist and 1 single coat 37-50 microns (1.5-2 thou)	1 full coat 37-50 microns (1.5-2 thou)	1 full coat 37-50 microns (1.5-2 thou)
	15 minutes minimum - 1.5 hours maximum between coats	15 minutes minimum - 1.5 hours maximum between coats	15 minutes minimum - 1.5 hours maximum between coats
	Air dry at 20°C Dust free - 1.5 hours Handleable (light pressure) 6-8 hours Recoat overnight	Air dry at 20°C Dust free - 1.5 hours Handleable (light pressure) 6-8 hours Recoat overnight	Air dry at 20°C Dust free - 1.5 hours Handleable (light pressure) 6-8 hours Recoat overnight
RECOAT	After the above stated recoat times	After the above stated recoat times	After the above stated recoat times

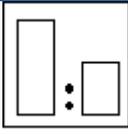
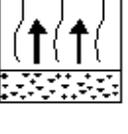
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		Accelerator (NOT to be hot sprayed)	
		Airless Spray	Cold Spray
	<p>EHS Hi-Gloss 383 10-15 parts* P275-499 1 part</p> <p>* Mixing ratios can be varied to ensure correct application viscosity - e.g.: black 10:1, white 15:1</p>	<p>EHS Hi-Gloss 383 10 parts P275-499 1 part</p> <p>For refurbishment work thin up to 0.5 part with P850-1597</p>	
	<p>Stir paint well before thinning.</p> <p>Pot life at 20°C 2-4 hours</p>	<p>Stir paint well before thinning.</p> <p>Pot life at 20°C 2-4 hours</p>	
	<p>50-70 secs BSB4 at 20°C (36-51 secs DIN4) at 20°C</p>	<p>50-70 secs BSB4 at 20°C (36-51 secs DIN4) at 20°C</p> <p>35-43 secs BSB4 at 20°C (26-32 secs DIN4) at 20°C</p>	
		<p>1.8-2.2 mm 2.7-4.7 bar (40-70 psi)</p>	
		<p>1.0-1.4 mm Air cap pressure: 0.675 bar (10 psi) maximum</p>	
	<p>0.22-0.33 mm (9-13 Thou) 130 - 200 bar (2000 - 3000 psi)</p>		
	<p>1 mist and 1 single coat 37-50 microns (1.5-2 thou)</p>	<p>1 mist and 1 single coat 37-50 microns (1.5-2 thou)</p>	
	<p>15 minutes minimum - 1.5 hours maximum between coats</p> <p>15 minutes before stoving</p>	<p>15 minutes minimum - 1.5 hours maximum between coats</p> <p>15 minutes before stoving</p>	
	<p>Air dry at 20°C Dust free - 1.5 hours Handleable (light pressure) 6-8 hours Recoat overnight</p> <p>Stoving</p> <p>40°C 60 minutes 50°C 50 minutes 60°C 40 minutes 70°C 30 minutes</p>	<p>Air dry at 20°C Dust free - 1.5 hours Handleable (light pressure) 6-8 hours Recoat overnight</p> <p>Stoving</p> <p>40°C 60 minutes 50°C 50 minutes 60°C 40 minutes 70°C 30 minutes</p>	
RECOAT	<p>After the above stated recoat times</p>	<p>After the above stated recoat times</p>	

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General Process Notes

SUBSTRATES AND PREPARATION

Fastbuild™ (P540-line), Anti-Corrosive Primer (P540-511/-512/-514), High build Anti-Corrosive Primer (P540-414, /-614), Primecoat (P565-625), Repaint Undercoat (P595-line).

EHS Hi-Gloss 383 is NOT recommended for use over Nitro-cellulose Primer.

For more detailed information on the preparation of specific substrates, see "Preparation and Pre-treatment" PDS.

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)

Airless Spray

Fluid tip : 0.22-0.33 mm (9-13 thou)
Paint pressure : 130-200 bar (2000-3000 psi)

BRUSHING

EHS P383 can be brushed very successfully if a 1-4% addition of P276-88 is added to the paint. It can be brushed thinned or unthinned. Air dry overnight between coats.

NB – The use of the brushing retarder will extend drying times

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. Under these circumstances, it is recommended to use P275-499 Winter Accelerator.

EHS Hi-Gloss 383 may be force dried to help speed-up through hardening. Use of P275-499 Winter Accelerator under forced bake will further speed up the drying.

PAINT TEMPERATURE

When cold spraying, the ideal temperature should be 20-25°C for optimum spray application.

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REDUCTION OF GLOSS LEVELS

The gloss level of EHS Hi-Gloss 383 can be reduced by adding Synthetic Matting Agent (P565-669) as follows :

Gloss level	EHS Hi-Gloss 383 : P565-669 (by volume)
Semi-gloss	4:1
Eggshell	3:1
Matt	3:2

AFTER the addition of P565-669 thin in the normal way.

NOTE: P565-669 must be stirred thoroughly before use.

SIGNWRITING

Apply signwriting after the specified "Recoat" drying times. Transfers should be applied when the paint film is hard dry. For application of self-adhesive decals see below.

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.

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.

COVERAGE

About 10m² per litre of ready for use paint at a dry film thickness of 50 microns (2 thou).



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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.

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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