

Product Data Sheet

September 2006

INTERNATIONAL MASTER
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V2700

Chassis Gloss Aluminium P304-1151

<i>Product</i>	<i>Description</i>
P304-1151	Chassis Gloss – Aluminium
P850-930	Thinner (medium)
P850-1039	Fast Thinner

Product Description

Chassis Gloss Aluminium is a high quality, glossy, aluminium finish, which is petrol, and oil resistant when fully dry. It is ideally suited for application by spray or brush to chassis or chassis parts.



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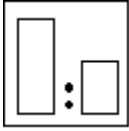




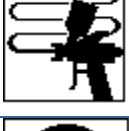

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Process

HVLP and Conventional Application

	P304-1151 Thinner (P850-930/-1039)	6 parts 1 part
		
	22-28 secs DIN4 (35-40 secs BSB4) at 20°C	
	1.4-1.8 mm 3.3-4.3 bar (50-65 psi)	
	1.0-1.4 mm Air cap pressure : 0.675 bar (10 psi) maximum	
	2 single coats 40-60 microns (1.5-2.5 thou)	
	Air-dry (20°C) : Dust free : Handleable (light pressure):	1.5 hours 4-6 hours

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General Process Notes

SUBSTRATES AND PREPARATION

Well prepared works primers, OE finishes, aged old finishes, 1-pack and 2-pack topcoats, Primecoat P565-625, Fastbuild™ P540-4XX, Anti-corrosive primers P540-50X and P540-414 and Repaint Undercoat P595-line.

For more detailed information, 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)

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

Hot Spray

Use unthinned at 60-80°C. The paint to be applied should be heated in an approved apparatus.

DRYING

The drying times quoted are approximate 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 SELECTION

Under normal circumstances the use of P850-930 is recommended. However, P850-1039 can be used in the same ratio (6:1) to adjust application to other conditions.

COVERAGE

About 9m² per litre of thinned paint at a dry film thickness of 40-60 microns (1.5-2.5 thou).

OTHER POINTS TO NOTE

P304-1151 provides good petrol and oil resistance when fully dry.

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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

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