

Product Data Sheet

September 2006

INTERNATIONAL MASTER
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V4320V

EHS Turbo Plus Structured Finish P478-Line

<i>Product</i>	<i>Description</i>
<i>P478-Line</i>	<i>EHS Turbo Plus Structured Finish</i>
<i>P210-982</i>	<i>EHS Turbo Plus Medium Hardener</i>
<i>P852-1791</i>	<i>EHS Turbo Plus Additive Thinner - Slow</i>
<i>P852-1792</i>	<i>EHS Turbo Plus Additive Thinner</i>
<i>P275-455</i>	<i>EHS Turbo Plus Rapide Catalyst</i>

Product Description

EHS Turbo Plus Structured Finish is a 2-pack acrylic topcoat system designed exclusively for painting commercial vehicles. EHS Structured Finish gives excellent gloss and durability along with improved sag resistance for structural work. When use as recommended, EHS Turbo Plus structured Finish is compliant with EPA Stage 2 legislation.



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Process

HVLP and Conventional Application

	<p>P478-line 4 parts P210-982 2 parts P850-1791/1792 1 parts</p>
	<p>Pot life at 20°C: 90 minutes</p> <p>Clean gun immediately after use.</p> <p>Note: To remain VOC compliant DO NOT add extra thinner</p>
	<p>35-42 secs BSB4 at 20°C (27-31 secs DIN4 at 20°C)</p> <p>For optimum performance ensure paint temperature is 18-25°C</p>
	<p>1.0-1.4 mm pressure feed 1.4-1.6 mm gravity feed 1.8-2.0 mm suction feed Use compliant spray equipment</p>
	<p>2 single coats 50-75 microns (2.0-3.0 thou)</p>
	<p>10-15 minutes between coats</p>
	<p>Air dry (20°C): Dust free: 30-40 mins Handleable: 6 hours Recoat: 16 hours Into-service: 16 hours</p> <p>Stoving at a metal temperature of: 40°C 90 minutes 50°C 1 hour 60°C 30 minutes Into-service: When cool</p>
RECOAT	<p>After "Into-service" time</p>

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General Process Notes

SUBSTRATE AND PREPARATION

Original finish in sound condition, works primer, fresh Turbo Plus (overnight dried/stoved) Fastbuild™, Buildprimer II P540-line, Wet-on-Wet primer P565-897, Epoxy Primer P580-2100/-2500, Transparent Sealer P565-755, Repaint Undercoat P595-line, Primecoat P565-625, Chromate Free Etch Primer P565-767.

Where flattening is required the following grades of flattening paper are recommended :

Wet or Dry paper : P600 - P800
Dry machine sanding : P280 - P320

For more detailed information on the preparation of specific substrates, see Preparation and Pre-treatment PDS, Q0100.

APPLICATION EQUIPMENT INFORMATION

HVLP

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

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.

Larger vehicles will need extended stoving times to reach the required metal temperature.

SELECTION OF CATALYST

To reduce drying times P275-455 EHS Turbo Plus Rapide Catalyst can be used in combination with the activated and thinned EHS Turbo Plus Structured Finish. However, pot life will be reduced. Please refer to EHS Turbo Plus Rapide Catalyst PDS for more information.

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 thickness is excessively high.



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VOC INFORMATION

The EU limit value for this product (product category: IIB.e) in ready to use form is max. 840g/litre of VOC. The VOC content of this product in ready to use form is max. 840g/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

For further information please contact:

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