

Product Data Sheet

September 2006

INTERNATIONAL MASTER
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W0630V

EHS Turbo Plus Clearcoat P190-1250

<i>Product</i>	<i>Description</i>
P190-1250	EHS Turbo Plus Clearcoat
P210-983	EHS Turbo Plus Clearcoat

Product Description

P190-1250 is the all new premium CT Clearcoat from Autocolor. Designed specifically to meet the toughest requirements of today's fleet market, P190-1250 delivers outstanding final appearance and durability over either solvent or waterborne Basecoats. Formulated to make life simple, P190-1250 offers easy application, fast baking and reliable polishing.

When used in accordance with the recommendations laid down in this data sheet, P190-1250 combined with CT Aquabase (P962-line) will provide a Basecoat/Clearcoat finish with a VOC of less than 420g/l.



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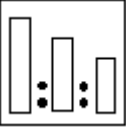




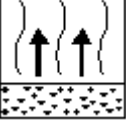

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Process

	HVLP
	<p>P190-1250 5 parts P210-983 2 parts</p>
	<p>NOTES: 1. Stir paint well before mixing and use stick to ensure correct ratio of paint hardener and thinner 2. Stir paint IMMEDIATELY after activation</p>
	<p>Pot Life at 20°C: 2 hours</p> <p>The activated paint should be applied as soon as possible after activation</p> <p>Clean gun immediately after use</p>
	<p>19-22 secs DIN @ 20°C (24-28 secs BSB4) @ 20°C</p> <p>For optimum spray application properties ensure paint temperature is 20-25°C</p>
	<p>Fluid tip: 1.0-1.4 mm (0.039-0.055 in)</p> <p>Air cap consumption : 15-17 CFM</p> <p>Pressure at cap : 0.675 bar (10 psi) maximum</p>
	<p>2 single coats</p>
	<p>Minimum of 10 minutes between coats at 20°C</p> <p>No flash-off required before stoving</p>
	<p>Air dry at 20°C Dust Free 45 minutes Handleable - 4 hours Into-Service - 16 hours</p> <p>Stoving at metal temperature of: 40°C 90 minutes 50°C 60 minutes 60°C 30 minutes 70°C 20 minutes Into-Service When cool</p>
RECOAT	<p>After "Into-Service" times</p>

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General Process Notes

SUBSTRATES

EHS Turbo Plus Multistripe basecoat (P498-)
Turbo Plus Multistripe basecoat (P488-)
Ready mixed CT Aquabase basecoat (P962-)
Turbo Plus metallic Basecoats (P482-/P492-lines)

Note: P190-1250 is not recommended for use over 2K Basecoat (P422-Line).

PREPARATION

The substrate to be painted must be dry, clean and free from grease.
Normally flattening of EHS Turbo Plus Multistripe or CT Aquabase (P962-line) is not required. However, imperfections in the basecoat may be rectified after approximately 45 minutes air-dry using P1200 or finer paper.
Basecoat areas which have been left overnight should be thoroughly Tack ragged before application of P190-1250.

PAINT TEMPERATURE

As with other paint systems, optimum spray application is achieved if the paint is allowed to reach room temperature (20-25°C) before use. This is particularly important for high solids systems. It is strongly recommended that cold paint is warmed to a minimum of 15°C before application. Below this temperature paint application performance may be adversely affected.
In order to remain VOC compliant do not add extra thinner to adjust the spraying viscosity.

HVLP APPLICATION

The most suitable HVLP gun for the application of Commercial Transport products is the pressure feed system.
Air cap pressure: 0.675 bar (10psi) 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.

RECOAT

P190-1250 can be recoated with itself or any other **Nexa Autocolor** primer, undercoat or topcoat after the Into-Service times stated.

SELECTION OF CATALYST

To reduce drying times, P275-455 EHS Turbo Plus Rapide catalyst can be used in combination with activated EHS Turbo Plus Clearcoat (P190-1250).
P275-455 can be added at up to 50mls per litre of **activated** paint.

OTHER INFORMATION

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.

DEMASKING

Care must be taken when demasking areas which have been coated with P190-1250 EHS Turbo Plus Clearcoat.

Low bake – It is recommended to demask whilst the vehicle is still warm from the oven. Demasking once the vehicle is cold may result in clearcoat delamination under certain conditions.

Air-dry: De-mask either before 6 hours drying time or after 36 hours drying time. Demasking at times between 6 and 36 hours may result in clearcoat delamination under certain conditions.

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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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