

Product Data Sheet

October 2006 – Updated 18th April 2007



INTERNATIONAL MASTER
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V0930V

EHS Turbo Plus™ P498-Line and P494-Line

Product	Description
P498 & P494-Line	EHS Turbo Plus Mixing Basics/Ready Mixes Finish
P210-982	EHS Turbo Plus Medium Hardener
P210-983	Hardener for EHS Turbo Plus Clearcoat
P210-987	Hardener for EHS Turbo Plus (Plural Mix Application)
P852-1790	EHS Turbo Plus additive Thinner – Slow
P852-1792	EHS Turbo Plus additive Thinner
P852-1794	EHS Turbo Plus additive Thinner - Fast
P275-455	EHS Turbo Plus Rapide Catalyst
P273-3200	EHS Turbo Plus Adjuster
P852-1799	Rapid Repair System Thinner

Product Description

EHS Turbo Plus is a versatile 2-pack acrylic paint system designed exclusively for painting commercial vehicles. EHS Turbo Plus gives a finish of outstanding gloss and durability, which fully meets the highest standards demanded by fleet operators today.

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



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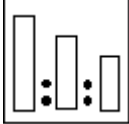




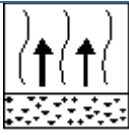

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Process

HVLP and Conventional Application		
	Standard Process	Higher Build Process
	EHS Turbo Plus P498-, P494- 3 parts EHS Turbo Plus Hardeners 2 parts P210-982/-983 EHS Turbo Plus Additive 1 part Thinner P852-179*	EHS Turbo Plus P498-, P494- 4 parts EHS Turbo Plus Hardeners 2 parts P210-982/-983 EHS Turbo Plus Additive 1 part Thinner P852-179*
	<p>Pot Life at 20°C : 2 hours</p> <p>Clean gun immediately after use</p> <p>NOTE: To remain compliant DO NOT add extra thinner</p>	<p>Pot Life at 20°C : 2 hours</p> <p>Clean gun immediately after use</p> <p>NOTE: To remain compliant DO NOT add extra thinner</p>
	25-32 secs BSB4 at 20°C (19-24 secs DIN 4 at 20°C) For optimum application ensure paint temperature is 18-25°C	29-36 secs BSB4 at 20°C (23-27 secs DIN 4 at 20°C) For optimum application ensure paint temperature is 18-25°C
	<p>Gravity / Surction 1.4 – 1.8 mm</p> <p>Pressure Feed 1.0 – 1.2 mm</p> <p>Air Cap pressure : 0.675 Bar (10psi) max</p>	<p>Gravity / Surction 1.8 – 2.2 mm</p> <p>Pressure Feed 1.2– 1.4 mm</p> <p>Air Cap pressure : 0.675 Bar (10psi) max</p>
	2 single coats 50-75 microns (2.0-3.0 thou)	2 single coats 75-100 microns (3.0-4.0 thou) Or 1 visit – 1 medium coat, followed by 1 full coat.
	10 -15 minutes minimum between coats	10 - 15 minutes minimum between coats
	<p>Air dry (20°C) :</p> <p>Dust free 40-60 mins Handleable 8 hours Recoat : 16 hours Into-Service : 16 hours</p> <p>Stoving at metal temperature of :</p> <p>40°C 90 minutes 50°C 60 minutes 60°C 30 minutes Into-Service When cool</p>	<p>Air dry (20°C) :</p> <p>Dust free : 40-60 mins Handleable : 8 hours Recoat : 16 hours Into-Service : 16 hours</p> <p>Stoving at metal temperature of :</p> <p>40°C 90 minutes 50°C 60 minutes 60°C 30 minutes Into-Service When cool</p>
RECOAT	After "Into-Service" time	After "Into-Service" time

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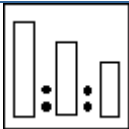





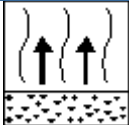

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Plural Mix Process

Plural Mix Application	
	EHS Turbo Plus P498-, 1 parts EHS Turbo Plus Hardeners 1 parts P210-987
	Pot Life at 20°C : 2 hours
	25-32 secs BSB4 at 20°C (19-24 secs DIN 4 at 20°C) For optimum application ensure paint temperature is 18-25°C
	1.0-1.4 mm Use compliant spray equipment Paint pressure: 0.3 – 1.0 bar (5 – 15psi)
	1.6 – 1.8 mm
	2 single coats 50-75 microns (2.0-3.0 thou)
	10 -15 minutes minimum between coats
	20°C 8 hours 40°C 90 minutes 50°C 60 minutes 60°C 30 minutes

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General Process Notes

SUBSTRATES AND PREPARATION

Original finish in sound condition, works primer. Fresh Turbo Plus (overnight dried/stoved) Fastbuild™ P540-line, P540-51* Build Primer 2, HS Wet-on-Wet primer P565-897, Epoxy primers P580-line, Transparent Sealer P565-755, Repaint Undercoat P595-line, Primecoat P565-625, Chromate Free etch primer P565-767, P565-1027/28

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

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

For optimum appearance and holdout EHS Turbo Plus is best applied over 2-pack primers.

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

COLOUR MIXING

All pigmented paint products should be thoroughly hand-stirred when opened. In addition mixing basics should be stirred for 10 minutes by machine before use. Thereafter mixing basics should be machine stirred twice a day for a maximum of 10 minutes each time.

COLOUR CHECKING

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

APPLICATION EQUIPMENT INFORMATION

HVLP

The most suitable HVLP gun for the application of Commercial Transport products is the pressure feed system. (if long pressure lines are used, pressure will need to be increased)

Air Cap Pressure : 0.675 bar (10psi) Max

Paint Pressure : 0.3-1.0 bar (5-15 psi)

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 System. Please refer to the EHS Rapide Catalyst PDS W1200V for more information.

RAPID REPAIR SYSTEM : Please refer to TDS – Z0100V

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REDUCTION OF GLOSS LEVELS

The gloss of EHS Turbo Plus solid colours can be reduced by adding Turbo Plus Matting Agent (P565-98) as follows :-

Finish	Colour			
	Black P498/4- : P565-98	Blue P498/4- : P565-98	Red P498/4- : P565-98	Yellow P498/4- : P565-98
Semi-Gloss	1 : 0.75	1 : 1	1 : 1	1 : 0.5
Eggshell	1 : 1	1 : 1.25	1 : 1.25	1 : 0.75
Matt	1 : 1.75	1 : 1.75	1 : 1.75	1 : 1.75

After adding P565-98 activate and thin at 4:1:1, please refer to the Matting Agent PDS W1100 for more information.

P565-98 should be stirred thoroughly before use.

The reduction in gloss levels varies between different colours, substrates, application/drying conditions and film thickness. It is advisable to spray a test panel before use and adjust the level of P565-98 if necessary.

Do **NOT** exceed the stated maximum level of P565-98 addition.

SIGNWRITING (BY BRUSH)

Signwriting on EHS Turbo Plus can be carried out using P383-line EHS Hi-Gloss 383. Refer to P383-line V1900V PDS for more information.

Scuff areas before Signwriting using Scotch-Brite Ultrafine.

USE OF P210-983 HARDENER

If using P210-983 (hardener for EHS Turbo Plus Clearcoat) it is essential that the flash off time between coats are not greater than 40 minutes or longer than 6 hours. Flash off times between 40 minutes and 6 hours can lead to film lifting under certain conditions.



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General Process Notes

PAINTING PLASTICS

Flexible Additive for Plastics (P100-2020) should be added to EHS Turbo Plus topcoat (P498-, P494-), when it is used over flexible plastic substrates.

To paint flexible substrates, apply a suitable **Nexa Autocolor** Primer. Please refer to PDS Plastics Painting Systems for more information. The primed plastic can be topcoated with EHS Turbo Plus mixed with P100-2020. If extra build is required apply the appropriate **Nexa Autocolor** 2-pack undercoat mixed with P100-2020 (please refer to the Flexible Additive PDS W1100V for more information) prior to EHS Turbo Plus topcoat.

P100-2020 should be added to EHS Turbo Plus in the following ratios:

Rigid Plastics

Use standard EHS Turbo Plus at the required gloss level.

Flexible Plastics

Mixing ratio:

EHS Turbo Plus	5 parts
P100-2020	1 part

AFTER adding P100-2020 activate and thin in the normal way.

Very Flexible Plastics

Mixing ratio:

EHS Turbo Plus	2 parts
P100-2020	1 part

AFTER adding P100-2020 activate and thin at **4 : 1 : 1**

Additional information

The addition of P100-2020 will extend the drying times of EHS Turbo Plus.

DECAL APPLICATION

It is recommended that P498-line is allowed to cure for at least one week prior to any decal application.

COVERAGE

Approximately 13-14m² per litre of ready for use paint at a dry film thickness of 50 microns (2 thou) depending on thinning ratio used.

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.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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