




Technical Data Sheet

Y0104V

March 2018

INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY

TURBO VISION® Multistripe Process

<i>Product</i>	<i>Description</i>
P650-1000	Premium High Flow Binder
P600-9xxx	Coloured Tinters
P210-7644	EHS Hardener - Standard
P852-6448	EHS Thinner - Extra Fast

Process Description

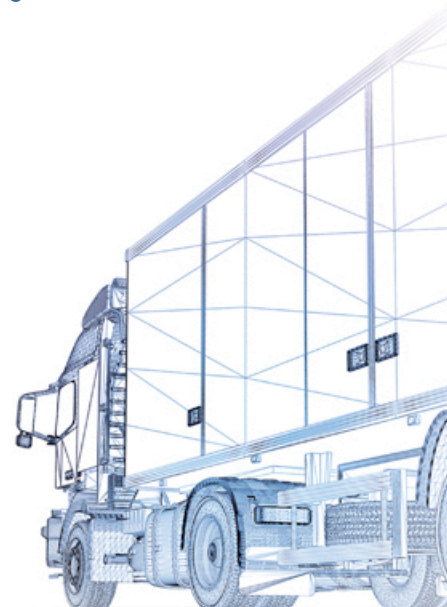
Turbo Vision Multistripe Process is a fast Direct Gloss system for producing multicolour drawings and effects on commercial vehicles.

Extra Fast Thinner will give a very fast drying topcoat which can be masked with tape and paper after just 45 minutes at room temperature.

If required to smooth the interlayer edge Turbo Vision EHS Premium High Flow Binder activated in a multistripe process can be recoated within 24 hours with P190-1280 CT Clearcoat without flattening.

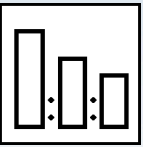
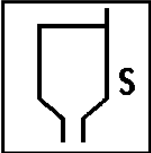
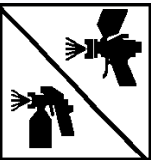

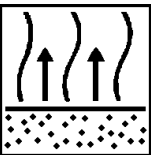
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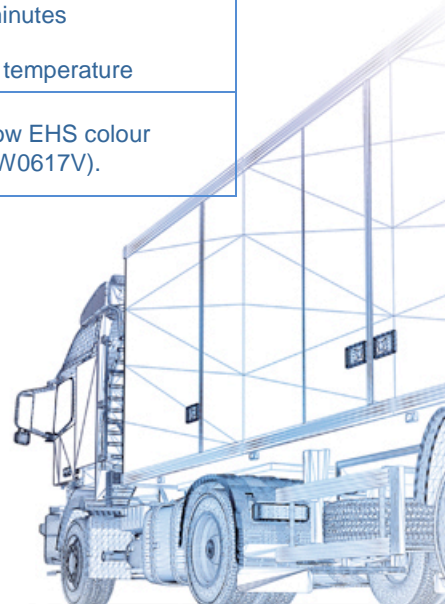


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Process							
Conventional or HVLP Application							
	<p>Mixing Ratio by Volume:</p> <table border="0"> <tr> <td><i>Turbo Vision</i> Premium High Flow EHS Topcoat</td> <td>2</td> </tr> <tr> <td>P210-764x hardener (*)</td> <td>1</td> </tr> <tr> <td>P852-6446 Extra Fast Thinner (**)</td> <td>1</td> </tr> </table>	<i>Turbo Vision</i> Premium High Flow EHS Topcoat	2	P210-764x hardener (*)	1	P852-6446 Extra Fast Thinner (**)	1
<i>Turbo Vision</i> Premium High Flow EHS Topcoat	2						
P210-764x hardener (*)	1						
P852-6446 Extra Fast Thinner (**)	1						
	<p>Spray Viscosity at 20°C: 18-22 seconds DIN4</p>						
	<p>1,3-1,4 mm Gravity or 1,6 mm suction feed at 2.0-2,4 bars</p> <p><u>IMPORTANT: Potlife at 20°C is maximum 20 minutes</u></p> <p><u>Clean spraygun immediately after use</u></p>						
	<p>Number of Coats</p> <p><u>1 Visit:</u></p> <p>1 very light coat + 1 Full coat</p> <p>Dry Film Thickness: 40 – 50 µm (higher build might extend drying time)</p>						
	<p>Flash-Off between coats: 1 minute Flash-Off before bake: 10 minutes when baked</p> <p>MASKING UP</p> <p>45 (*) minutes at 20°C or 10 minutes at 60°C and cool down 20 minutes</p> <p>(*) times may vary according to spaybooth temperature</p>						
	<p>Recoatability</p> <p>Between 45 minutes and 24 hours By another <i>Turbo Vision</i> Premium High Flow EHS colour or with P190-1280 Clearcoat (see TDS N°W0617V).</p>						

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General Process Notes

SUBSTRATE AND PREPARATION

1. **Freshly applied Turbo Vision** Premium High Flow EHS Topcoat (e.g. when used as a main colour in multicolour designs):

Abrade with Scotch-Brite™ Fine after overnight dry or stoving.

2. **Wet-on-Wet Undercoats or Transparent Undercoat**

Allow to get a fully dried and even surface before topcoating.

3. **1-pack or 2-pack epoxy primers:**

Air-dry overnight or stove at temperatures specified in the PDS before flattening or topcoating. Flattening is recommended to give a smooth surface for topcoating.

If not possible to get a smooth surface, spray a light coat of wet-on-wet undercoat and let it dry properly prior recoating with topcoat activated for multistripe process.

RECOAT

The topcoat may be left up to a maximum of 24 hours before application of another colour or of a clearcoat. Topcoated areas sprayed in a multistripe process which have been left overnight should be lightly tak-ragged before being recoated.

DRYING

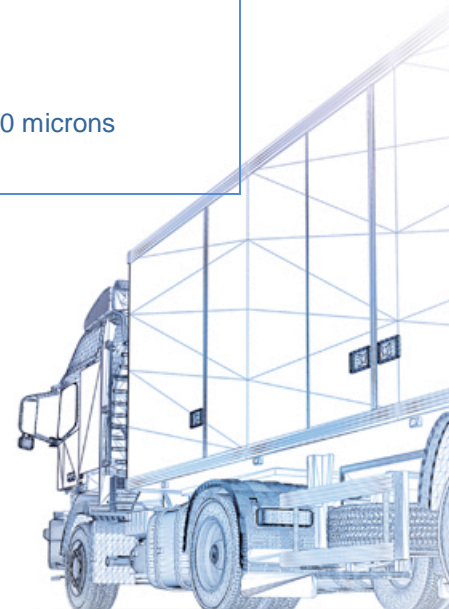
It is recommended to leave the topcoat air drying at least 45 minutes at 20°C prior recoating. Cooler conditions and high film builds might extend the drying and mask up time.

DECAL APPLICATION

It is recommended that TURBO VISION® Premium High Flow EHS Topcoat is allowed to cure for at least one week prior to any decal application.

COVERAGE

Approximately 12-13 m² per litre of ready for use paint at a dry film thickness of 50 microns depending on thinning ratio used.



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Colour

COLOUR MIXING

All Tinters should be thoroughly hand stirred when first opened, and then stirred on a mixing machine for 10 minutes before use. Thereafter all tinters should be machine stirred twice a day for at least 10 minutes.

COLOUR CHECKING

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

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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