

Product Data Sheet

March 2009

INTERNATIONAL MASTER
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V4130

EHS Turbo Plus™ Metallic Basecoat P482-Line

<i>Product</i>	<i>Description</i>
<i>P482-</i>	<i>EHS Turbo Plus Metallic Basecoat colours</i>
<i>P192-611</i>	<i>Turbo Plus Aluminium controller</i>
<i>P210-982</i>	<i>EHS Turbo Plus medium hardener</i>
<i>P850-1610</i>	<i>Turbo Plus HS Thinner</i>
<i>P850-1412</i>	<i>Turbo Plus Basecoat Thinner</i>
<i>NEDP190-1280</i>	<i>EHS Turbo Plus Premium Clearcoat</i>

Product Description

The EHS Turbo Plus Metallic Basecoat / EHS Clear system provides commercial vehicle painters with the means to create outstanding liveries demanded by fleet operators.

The system has been developed to give an even greater colour offer from a single mixing scheme. The activated EHS Turbo Plus System is fully cured and offers a tougher, more durable finish with significantly improved stone chip resistance.

In combination with the fast and versatile EHS Turbo Plus Multistripe System, the EHS Turbo Plus Metallic Basecoat system provides the easy way to faster multi-colour designs.

Overcoat with EHS Turbo Plus Clearcoat NEDP190-1280 to achieve a full gloss finish.



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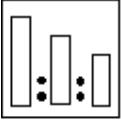




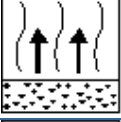

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Process

HVLP Application	
	P482- 10 parts P210-982 1 part P850-1610/-1412 9 parts
NOTES	<ol style="list-style-type: none"> 1. Stir paint well before mixing and use a measuring stick to ensure the correct ratio of paint, hardener and thinner. 2. Use ONLY P210-982 hardener. 3. Use ONLY P850-1610/-1412 thinners. 4. Stir the mix thoroughly before use.
	Pot Life at 20°C : 4-6 hours
NOTES	At the end of the Pot life the material may still be liquid, but should be classed as unusable. Clean gun immediately after use.
	Sprayed at low viscosity. Thin by volume only. For optimum spray application properties ensure paint temperature 20-25°C
	Pressure Feed : Gravity Feed : 0.85-1.0 mm 1.3-1.6 mm Use compliant spray equipment
	2 single coats followed immediately by a light coat for even metallic appearance. Poor opacity or clean colours may require additional coats
	Minimum of 10 minutes between coats Minimum of 30 minutes before application of clearcoat.
	Air dry (20°C) : Mask-up 60 mins Recoat : 30 mins
RECOAT	May be recoated after the above drying time with itself, EHS Turbo Plus Multistripe or EHS Turbo Plus Clearcoat (NEDP190-1280). Do NOT leave longer than 36 hours before clearcoating. (Basecoated areas which have been left overnight should be tack ragged before clearcoating.)

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General Process Notes

SUBSTRATE AND PREPARATION

- 1. Cured original finish, works primer, cured Nexa Autocolor 2-pack finishes, 2-pack primers/undercoats:**
Flat thoroughly with P800 grade wet and dry paper or P360 grade paper when dry machine sanding.
- 2. Freshly applied EHS Turbo Plus 2-pack topcoat (e.g. when used as a main colour in mult – colour designs):**
Abrade with Scotch-Brite™ Ultrafine 'Grey' after overnight dry or stoving.
- 3. 2-pack etch primers, e.g. P565-767 / P565-625:**
Allow to hard dry prior to topcoating.
- 4. 2-pack acrylic undercoats, e.g. P565-897 / P565-1027/8 / P565-755:**
Allow to harden thoroughly, as detailed in the appropriate PDS.

Note. When 2-pack undercoats are used over an etch primer (e.g. P565-767, P565-625) the undercoat MUST be left for a minimum of 4-6 hrs before topcoating, otherwise lifting may occur.

- 5. Isocyanate cured synthetic undercoats:**
Allow to dry overnight prior to topcoating. May be used to seal old (non-bleeding) synthetic finishes. However, care must be taken to allow each stage to dry thoroughly before overcoating.
- 6. Multistripe Basecoat:**
When used as part of a multi-colour design, wherever possible, the metallic basecoat should be the last colour applied. Flattening of EHS Turbo Plus Multistripe basecoat is not required, but the guidelines set out in the EHS Turbo Plus Multistripe PDS must be followed.
- 7. 2-pack Epoxy Primers, e.g. P580-350*/-3005:**
Air-dry overnight or stove at temperatures specified in the appropriate PDS before flattening or topcoating. Flattening is recommended to give a smooth surface for topcoating.

EHS Turbo Plus Metallic Basecoat is NOT recommended for use over air-drying alkyd primers / undercoats.

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

COLOUR MIXING

Many P482- colours contain Turbo Plus Aluminium controller (P192-611). To ensure that P192-611 is properly dispersed the mix must be stirred thoroughly immediately after adding the last component of the microfiche formulation.

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APPLICATION EQUIPMENT INFORMATION

The most suitable HVLP gun for the application of Commercial Transport products is the pressure feed system, however, EHS Turbo Plus Metallic basecoat may be applied by gravity feed.

Pressure feed

Air cap pressure : 0.675 bar (10 psi) maximum

Paint pressure : 0.3-1.0 bar (5-15 psi) maximum

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

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.

Mask-up times of metallic basecoat colours are longer than those of EHS Turbo Plus Multistripe colours. Care must be taken if masking-out metallic basecoat colours. Use the correct type of masking tape to produce clean, straight edges, e.g. low tack tape.

PAINT TEMPERATURE

As with other paint systems, optimum spray application is achieved if the paint is allowed to reach a temperature of 20-25°C before use. This is particularly important for high solids systems. Below this temperature paint application performance will be adversely affected.

DECAL APPLICATION

It is **NOT** recommended to apply self adhesive decals directly over basecoats. They should be applied over the fully cured clearcoat.

OTHER POINTS TO NOTE

1. Do **NOT** add P275-455 (EHS Turbo Plus Rapide) to P482-line.
2. Do **NOT** add P852-line (Additive thinners) to P482-line.

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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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