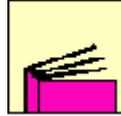


FOR PROFESSIONAL USE ONLY



# V3720

Date of issue : September 2002

## Turbo Plus™ Metallic Basecoat P487-line

Products	
P487-	Turbo Plus Metallic basecoat colours
P488-	Turbo Plus mixing basics
P850-1412	Turbo Plus Basecoat thinner
P192-611	Turbo Plus Aluminium controller
P210-820	Turbo Plus Extra slow MS hardener
P210-821	Turbo Plus Slow MS hardener
P210-822	Turbo Plus Medium MS hardener
P190-633	Turbo Plus Clearcoat

### PRODUCT DESCRIPTION

The Turbo Plus Metallic Basecoat/Clear System provides commercial vehicle painters with the means to create outstanding liveries demanded by fleet operators. The use with the well-balanced Turbo Plus Hardeners and Thinners guarantees easy application over large areas. The system has been developed to give an even greater colour offer from a single mixing scheme. Compared to conventional metallic basecoats the activated Turbo Plus System is fully cured and offers a tougher, more durable finish with significantly improved stone-chip resistance.

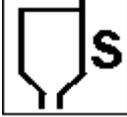
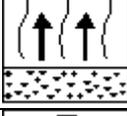
In combination with the fast and versatile Turbo Plus Multistripe System, the Turbo Plus Metallic Basecoat System provides the easy way to faster multi-colour designs.

Overcoat with Turbo Plus 2-pack clearcoat P190-633 to achieve a full gloss finish



**THESE PRODUCTS ARE FOR THE PROFESSIONAL PAINTING OF AUTOMOTIVE VEHICLES ONLY AFTER REFERENCE TO THE MANUFACTURER'S MATERIAL SAFETY DATA SHEET**

## PROCESS

HVLP Application	
	<p>Turbo Plus P487-                    6 parts            Turbo Plus MS Hardener        1 part            Turbo Plus Thinner                5 parts</p> <ol style="list-style-type: none"> <li>1. Stir the paint well before mixing and use a measuring stick to ensure the correct ratio of paint, hardener and thinner.</li> <li>2. Stir the mix thoroughly before use.</li> </ol>
	<p><b>Pot Life at 20°C :</b> 4-6 hours</p> <p><b>NOTE :</b> At the end of the pot life the material may still be liquid but should be classed as unusable.</p> <p>Clean gun immediately after use.</p>
	<p>Spray at low viscosity. Thin by volume only.</p>
	<p>Pressure Feed : 0.85-1.0 mm            Air cap pressure : 0.675 bar (10 psi) maximum</p> <p>Gravity Feed : 1.3-1.6 mm            Air cap pressure : 0.675 bar (10 psi) maximum</p>
	<p>2 single coats followed immediately by a light coat for even metallic appearance. Poor opacity or clean colours may require an additional coat.</p>
	<p>Minimum of 10 minutes between coats            Minimum of 30 minutes before application of clearcoat.</p>
	<p><b>Air dry (20°C) :</b>            Mask-up                    30-60 mins            Recoat :                    30 minutes</p>
<p><b>RECOAT</b></p>	<p>May be recoated after the above drying times with itself, Turbo Plus Multistripe or Turbo Plus Clearcoat (P190-633).</p> <p>Do <b>NOT</b> leave longer than 36 hrs before clearcoating.</p>

## GENERAL PROCESS NOTES

### SUBSTRATES AND PREPARATION

1. Cured Original finish works primer, cured **Nexa Autocolor** 2-pack finishes and 2-pack primers/undercoats.:  
Flat thoroughly with P800 grade wet and dry paper or P360 grade paper when dry machine sanding.
2. Freshly applied Turbo Plus 2-pack topcoat, (e.g. when used as a main colour in multicolour designs):  
Abrade with Scotch-Brite™ Ultrafine 'Grey' after overnight dry or stoving.
3. 2-pack etch primers, e.g. P565-625:  
Allow to hard dry prior to topcoating.
4. 2-pack acrylic Undercoats, e.g. P565-876 :  
Allow to harden thoroughly as detailed in the appropriate PDS.

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

5. Isocyanate cured alkyd primers, e.g. Fastbuild™ (P540-line) :  
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 Turbo Plus Multistripe Basecoat is not required, but the guidelines set out in the Turbo Plus Multistripe PDS must be followed.
7. 2-pack epoxy primers, e.g. P580- 2500:  
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.

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

P487-line Turbo Plus metallic basecoat colours are mixed from P488- Turbo Plus mixing basics, with P492- Turbo Plus metallic basics and P192-611 Turbo Plus Aluminium Controller.  
Many P487-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.

### APPLICATION EQUIPMENT INFORMATION

#### HVLP

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

Conventional Pressure Pot  
Activate and thin as specified.

Fluid Tip: 1.1 - 1.4 mm  
Air cap pressure : 2.7 - 4.0 bar (40-60 psi)  
Paint pressure : 0.3 - 1.0 bar (5-15 psi)

## GENERAL PROCESS NOTES

### 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 significantly longer than those of 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.

### SELECTION OF HARDENER AND THINNER

This will depend on temperature, size of job, air movement and personal preference. Generally all Turbo Plus Hardeners can be used. They are interchangeable and have less impact on the application properties than the thinners. P850-1412 Turbo Plus Basecoat Thinner is the recommended thinner for most conditions. For cold and hot conditions the other Turbo Plus Thinners can be used.

As a guideline use thinners as follows when painting

Thinner :	Temperature :
P850-1412	15°C to 25°C
P850-1392	20°C to 30°C
P850-1391	25°C to 35°C
P850-1390	Above 30°C

Do **NOT** use the Turbo Plus Multistripe Hardener P210-814/-815 in basecoat metallics.

### DECAL APPLICATION

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

## This information is given in good faith but without warranty.

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