Technical Information

Plastic Repair System

Painting of plastic parts

1. Use

baslac® plastic cleaner and primers can be used on most common plastics used in the automotive industry.

- PRFV-GFK, SMC, BMC, ZMC Glass fibre reinforced polyester prepreg
- PFO-NORYL Polyphenyloxide
- PC (suitable for car field) Polycarbonate. Avoid using adhesion primer for refinishing helmets in PC
- ABS Acrylic-Butadiene-Styrene
- PP-EPDM Modified polypropylene
- PUR Hard polyurethane foam
- PUR FLEX Flexible polyurethane foam
- RIM Integral polyurethane
- PVC Polyvinyl chloride
- PA-NYLON Polyamide
- PBTF-POCAN Polybutylene Terephthalate

2. Properties

- Use 70U-20 as Cleaner for paintable plastic vehicle parts.
- Removes all types of contaminants (e.g. mould release agents and traffic film).
- Use as the first step in the preparation process to ensure excellent adhesion of subsequent coatings.

3. Substrate

- Thorough preparation and cleaning are essential for the successful refinishing of plastic parts. The plastic cleaning and preparation system is designed to produce the best performance from the primer and topcoat systems.
- Pure Polypropylene (PP) and Polyethylene (PE) cannot be painted.
- Special Note Some grades of PE are considered unpaintable, and some primers are not suitable for use on very solvent sensitive substrates such as Polystyrene (PS).

4. Application

- Thorough preparation and cleaning are essential for the successful refinishing of plastic parts. The plastic cleaning and preparation system is designed to produce the best performance from the primer and topcoat systems.
- Pure Polypropylene (PP) and Polyethylene (PE) cannot be painted.
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Plastic Repair System

Standard Paint System - Plastic repairs

Repair process with 21-20 1K Plastic Primer and 2K Primer filler 20U-23, 20U-24, 20U-25 **Properties:** 70U-20 70U-20 Cleaning Heating $\overline{\bigcirc}$ T T T Plastic Plastic PU foam and Q-Cleaner Cleaner polyamide (PA) damaged area: to remove mould Wipe Wipe 1 hour at 1x 1x 1x P80-P600 release agents and 140°F/60°C dry dry moistened entire part: water, respectively cloth sanding pad **Body Filler** Apply appropriate body 70U-20 Ξų filler per the manufacturer's Plastic Cleaner recommendations. P80-P150 Wipe dry P240-P320 coarse fine sanding sanding 21-20 **Plastic** Material is (1)1 Î 1K ready for use adhesion Plastic primer 1-2 thin, 10-15 mins. at Primer but coherent 68°F/20°C before coats filler application 20U-24 80U-10 50U-15 60U-**Primer filler** >1 54 =¥ 2K Grev Flex 50U-20 Reducer 0:0:0:0 for flexible Urethane Additive 50U-30 plastic Hardener Primer 4:1:1:1 1.5-1.7 mm 2 coats 30-40 P400 2.0-3.0 mils mins. at orbital 140°F/60°C sander or 1-1.5 hrs. 68°F/20°C 35-60U-**Basecoat** >= (1)1 R Basecoat Reducer : 2:1 1.3 mm approx. 10 mins., 2 (spray to cover), or until matt 1/2 to match the effect 40U-420 80U-10 50U-415 Clear >**1** Ħ \sim Euro Flex 50U-420 Production Additive Hardener Clear 4:1:3 1.3-1.5 mm 30 mins. at 2 coats 140°F/60°C 2.0-2.4 mils or 8 hrs. 68°F/20°C 40U-430 80U-10 50U-15 R 50U-20 Spot Flex R Repair Additive 50U-30 8:1:2 1.3-1.5 mm 30 mins. at Clear Hardener 2 coats 2.0-2.4 mils 140°F/60°C or 4 hrs. 68°F/20°C

Materials described are for application by professional trained personnel only using proper equipment. Products may be hazardous & should be used according to label directions & technical data information. Appropriate respiratory protection should be worn at all times while products are in use — read product label and Safety Data Sheet (SDS) for specific details. Statements & methods described are based upon the latest standard of technology known to the manufacturer. Application procedures cited are suggestions only & are not to be interpreted as warranty for events resulting from their use. Dilution ratios are intended to provide maximum performance within the typical Volatile Organic Compound (VOC) restriction for product use. Specific VOC limits need to be referenced to verify local compliance. Altering the solvent or dilution ratio may impact VOC compliance. User is solely responsible to ensure product use and application is in accordance with all applicable regulatory, legislative, and municipal requirements.

Plastic Repair System



Standard Paint System - New Plastic Parts

Properties: Wet on Wet process #1 with 21-20 1K Plastic Primer

Cleaning	70U-20 Plastic Cleaner	1x	Wipe dry	70U-20 Plastic Cleaner	1x	Wipe dry	Hea PU fo polyam to remo release a water, re	ating am and hide (PA) eve mould agents and espectively	1 hour at 140°F/60°C	1x moistened cloth
Plastic adhesion primer	21-20 1K Plastic Primer	Material is ready for t	suse	2 thin, 1 coherent coats	()+)+) 0-15 mins. a 68°F/20°C before sealer application	at r				
Primer sealer	20U-23 20U-24 20U-25 2K Urethane Primer	80U-10 Flex Additive	50U-15 50U-20 50U-30 Hardener	60U- Reducer	4:1:1:2	▶1 ,3-1,5	mm 1.0-	1.5 mils	30 mins. at 68°F/20°C	
Basecoat	35- Basecoat	60U- Reducer	2:1	▶ ∎∰ 1.3 mm	2 (spray ½ to matc	2 (spray to cover), ½ to match the effect		<u>↑ /</u> 0 mins., I matt		
Clear	40U-420 Euro Production Clear	80U-10 Flex Additive	50U-415 50U-420 Hardener	4:1:3] ▶ ∎ 3 1.3-1	5 mm 2.0	2 coats)-2.4 mils	30 mins. 140°F/60 or 8 hrs 68°F/20	at)°C s. °C	
	40U-430 Spot Repair Clear	80U-10 Flex Additive	50U-15 50U-20 50U-30 Hardener	8:1:2	. 1 .3-1	5 mm 2.0	2 coats 0-2.4 mils	30 mins. 140°F/60 or 4 hrs 68°F/20	at)°C S. °C	

Plastic Repair System

Standard Paint System - New Plastic Parts

Wet on Wet process #2 with 21-11 AdPro/Sealer **Properties:** 70U-20 70U-20 Cleaning Heating T T T T Plastic Plastic PU foam and Cleaner Cleaner polyamide (PA) to remove mould Wipe dry Wipe dry 1 hour at 1x 1x 1x release agents and 140°F/60°C moistened water, respectively cloth 21-11 50U-15 60U-AdPro/Sealer >₩ Ę AdPro/ 50U-20 Reducer Uaal Sealer 50U-30 Hardener 4:1:1 1.2-1.3 mm 1.0 mils 30 mins, at 68°F/20°C 35-60U-**Basecoat** >**1** <u>(†(†(</u> R Basecoat Reducer : 2:1 1.3 mm approx. 10 mins., 2 (spray to cover), 1/2 to match the effect or until matt 40U-420 80U-10 50U-415 Clear >**1** $\overline{}$ Ħ Euro Flex 50U-420 Production Additive Hardener Clear 4:1:3 2 coats 30 mins. at 1.3-1.5 mm 2.0-2.4 mils 140°F/60°C or 8 hrs. 68°F/20°C 40U-430 80U-10 50U-15 K 50U-20 Spot Flex 0:0 Repair Additive 50U-30 1.3-1.5 mm 30 mins. at 8:1:2 2 coats Clear Hardener 2.0-2.4 mils 140°F/60°C or 4 hrs. 68°F/20°C

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