

## 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 Polyphenyloxyde
- 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

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#### 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.

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#### 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).

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#### 4. Application






























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# Technical Information

## Plastic Repair System

### Standard Paint System - Plastic repairs

**Properties:** Repair process with 21-20 1K Plastic Primer and 2K Primer filler 20U-23, 20U-24, 20U-25

























|   |   |  |   |  |  |  |   |   |   |  |  |
|---|---|--|---|--|--|--|---|---|---|--|--|
| <b>Cleaning</b>                                   | 70U-20<br>Plastic<br>Cleaner            |  1x |  Wipe<br>dry |  damaged area:<br>P80-P600<br>entire part:<br>sanding pad | 70U-20<br>Plastic<br>Cleaner   |  1x                                     |  Wipe<br>dry   | <b>Heating</b><br>PU foam and<br>polyamide (PA)<br>to remove mould<br>release agents and<br>water, respectively                                     |  1 hour at<br>140°F/60°C     |  1x<br>moistened<br>cloth |  |
|   | <b>Body Filler</b>                      | Apply appropriate body<br>filler per the manufacturer's<br>recommendations.          |   |  P80-P150<br>coarse<br>sanding                            | 70U-20<br>Plastic<br>Cleaner   |  Wipe dry                               |  P240-P320<br>fine sanding                             |   |   |  |  |
| <b>Plastic<br/>adhesion<br/>primer</b>            | 21-20<br>1K<br>Plastic<br>Primer        | Material is<br>ready for use   |   |  1-2 thin,<br>but coherent<br>coats                       |  10-15 mins. at<br>68°F/20°C before<br>filler application |  |   |   |   |  |  |
| <b>Primer filler<br/>for flexible<br/>plastic</b> | 20U-24<br>2K Grey<br>Urethane<br>Primer | 80U-10<br>Flex<br>Additive   | 50U-15<br>50U-20<br>50U-30<br>Hardener  | 60U-<br>Reducer  |  4:1:1:1  |  1.5-1.7 mm                           |  2 coats<br>2.0-3.0 mils                             |  30-40<br>mins. at<br>140°F/60°C<br>or 1-1.5 hrs.<br>68°F/20°C |  P400<br>orbital<br>sander |  |  |
| <b>Basecoat</b>                                   | 35-<br>Basecoat                         | 60U-<br>Reducer  |  2:1       |  1.3 mm   |  2 (spray to cover),<br>½ to match the effect           |  approx. 10 mins.,<br>or until matt |   |   |   |  |  |
| <b>Clear</b>                                      | 40U-420<br>Euro<br>Production<br>Clear  | 80U-10<br>Flex<br>Additive   | 50U-415<br>50U-420<br>Hardener  |  4:1:3  |  1.3-1.5 mm   |  2 coats<br>2.0-2.4 mils             |  30 mins. at<br>140°F/60°C<br>or 8 hrs.<br>68°F/20°C |   |   |  |  |
|   | 40U-430<br>Spot<br>Repair<br>Clear      | 80U-10<br>Flex<br>Additive   | 50U-15<br>50U-20<br>50U-30<br>Hardener  |  8:1:2  |  1.3-1.5 mm   |  2 coats<br>2.0-2.4 mils             |  30 mins. at<br>140°F/60°C<br>or 4 hrs.<br>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























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|--|--|--|--|--|---|--|---|--|--|--|
| <b>Cleaning</b>                        | 70U-20<br>Plastic<br>Cleaner                           |  1x |  Wipe dry | 70U-20<br>Plastic<br>Cleaner   |  1x  |  Wipe dry                               | <b>Heating</b><br>PU foam and<br>polyamide (PA)<br>to remove mould<br>release agents and<br>water, respectively                           |  1 hour at<br>140°F/60°C  |  1x<br>moistened<br>cloth |  |
|  |  |  |  |  |   |  |   |  |  |  |
| <b>Plastic<br/>adhesion<br/>primer</b> | 21-20<br>1K<br>Plastic<br>Primer                       | Material is<br>ready for use   |  |  1-2 thin,<br>but coherent<br>coats |  10-15 mins. at<br>68°F/20°C<br>before sealer<br>application |  |   |  |  |  |
|  |  |  |  |  |   |  |   |  |  |  |
| <b>Primer sealer</b>                   | 20U-23<br>20U-24<br>20U-25<br>2K<br>Urethane<br>Primer | 80U-10<br>Flex<br>Additive   | 50U-15<br>50U-20<br>50U-30<br>Hardener   | 60U-<br>Reducer  |  4:1:1:2   |  1.3-1.5 mm                             |  1.0-1.5 mils  |  30 mins. at<br>68°F/20°C |  |  |
|  |  |  |  |  |   |  |   |  |  |  |
| <b>Basecoat</b>                        | 35-<br>Basecoat  | 60U-<br>Reducer  |  2:1    |  1.3 mm                           |  2 (spray to cover),<br>½ to match the effect              |  approx. 10 mins.,<br>or until matt |   |  |  |  |
|  |  |  |  |  |   |  |   |  |  |  |
| <b>Clear</b>                           | 40U-420<br>Euro<br>Production<br>Clear                 | 80U-10<br>Flex<br>Additive   | 50U-415<br>50U-420<br>Hardener   |  4:1:3                            |  1.3-1.5 mm  |  2 coats<br>2.0-2.4 mils             |  30 mins. at<br>140°F/60°C<br>or 8 hrs.<br>68°F/20°C |  |  |  |
|  | 40U-430<br>Spot Repair<br>Clear                        | 80U-10<br>Flex<br>Additive   | 50U-15<br>50U-20<br>50U-30<br>Hardener   |  8:1:2                            |  1.3-1.5 mm  |  2 coats<br>2.0-2.4 mils             |  30 mins. at<br>140°F/60°C<br>or 4 hrs.<br>68°F/20°C |  |  |  |

# Technical Information

## Plastic Repair System

### Standard Paint System - New Plastic Parts

Properties: Wet on Wet process #2 with 21-11 AdPro/Sealer

|                     |  |   |   |  |   |   |  |  |   |  |
|---------------------|--|---|---|--|---|---|--|--|---|--|
| <b>Cleaning</b>     | 70U-20<br>Plastic<br>Cleaner           | <br>1x | <br>Wipe dry | 70U-20<br>Plastic<br>Cleaner   | <br>1x   | <br>Wipe dry                             | <b>Heating</b><br>PU foam and<br>polyamide (PA)<br>to remove mould<br>release agents and<br>water, respectively                              | <br>1 hour at<br>140°F/60°C | <br>1x<br>moistened<br>cloth |  |
|                     |  |   |   |  |   |   |  |  |   |  |
| <b>AdPro/Sealer</b> | 21-11<br>AdPro/<br>Sealer              | 50U-15<br>50U-20<br>50U-30<br>Hardener  | 60U-<br>Reducer   | <br>4:1:1   | <br>1.2-1.3 mm                                   | <br>1.0 mils                            | <br>30 mins. at<br>68°F/20°C                              |  |   |  |
|                     |  |   |   |  |   |   |  |  |   |  |
| <b>Basecoat</b>     | 35-<br>Basecoat                        | 60U-<br>Reducer   | <br>2:1      | <br>1.3 mm  | <br>2 (spray to cover),<br>½ to match the effect | <br>approx. 10 mins.,<br>or until matt |  |  |   |  |
|                     |  |   |   |  |   |   |  |  |   |  |
| <b>Clear</b>        | 40U-420<br>Euro<br>Production<br>Clear | 80U-10<br>Flex<br>Additive  | 50U-415<br>50U-420<br>Hardener  | <br>4:1:3  | <br>1.3-1.5 mm                                  | <br>2 coats<br>2.0-2.4 mils            | <br>30 mins. at<br>140°F/60°C<br>or 8 hrs.<br>68°F/20°C  |  |   |  |
|                     | 40U-430<br>Spot<br>Repair<br>Clear     | 80U-10<br>Flex<br>Additive  | 50U-15<br>50U-20<br>50U-30<br>Hardener  | <br>8:1:2 | <br>1.3-1.5 mm                                 | <br>2 coats<br>2.0-2.4 mils           | <br>30 mins. at<br>140°F/60°C<br>or 4 hrs.<br>68°F/20°C |  |   |  |
|                     |  |   |   |  |   |   |  |  |   |  |
|                     |  |   |   |  |   |   |  |  |   |  |

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