































Technical Information System 5



Standard Paint System Plastic repair

Properties: Repair process with 21-20 1K Plastic Primer and 2K Primerfiller
20-24 can be replaced/mixed with 20-34 or 20-94

Cleaning	70-20 Cleaner Plastic	 1x	 wipe dry	Sanding of damaged areas P80 – P600 entire part sanding pad	70-20 Cleaner Plastic	 1x	 wipe dry	Heating of PU foam and polyamide (PA) to remove mould release agents and water, respectively	 1 h at 60°C	 1x moistened cloth
Body filler	12-20 Bodyfiller Universal (only for hard plastic)	56-20 Bodyfiller Hardener	 + 2 – 3 %		 20°C 20 – 30 min.	 P80 / P150 coarse sanding	 70-10 1x	 wipe dry	 P240 / P 320 fine sanding	
Adhesion Primer	21-20 1K Plastic Primer	Shake the bottle for 2 min. Material is ready for use	 21-20	 1 – 2 thin, but coherent coats	 5 min. before filler application					
Primerfiller	20-24/34/94 2K Primerfiller	80-10 Additive Flex For flexible plastics	 4 : 1							
Primerfiller	Mixture 2K Primerfiller / Additive Flex	50-10 2K Hardener	60- Reducer	 4 : 1 : 1	 1.6 – 1.8 mm	 2 50 – 70 µm	 30 min. at 60°C or 3 h 20°C	 P 400 orbital sander		
Basecoat	45- Basecoat	45-R45 Dilutant	 100 : 70	 1.4 mm	 2 (spray to cover), ½ to match the effect	 approx. 10 min., until mat				
Clearcoat	40- 2K Clear	50- Hardener	60- Reducer	 2 : 1 or 2 : 1 + 10%	 1.3 mm	 2 40 – 60 µm	 30 min. at 60°C or 3 h 20°C			

The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our products, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the products for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein are for general information purpose only; they may change without prior information and do not constitute the agreed contractual quality of the products (product specification). It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed.



















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Technical Information System 5



Standard Paint System New Plastic

Properties: Repair process with 21-11 2K Plastic Primer VOC

Cleaning	70-20 Cleaner Plastic	 1x	 wipe dry	Sanding of damaged areas P80 – P600 entire part sanding pad	70-20 Cleaner Plastic	 1x	 wipe dry	Heating of PU foam and polyamide (PA) to remove mould release agents and water, respectively	 1 h at 60°C	 1x moistened cloth
	Primerfiller	21-11 2K Primerfiller	50-15 2K Hardener		60- Reducer	 4 : 1 : 1	 1.3 mm		 1 ½ 30-40 µm	 20 min. 20°C
Basecoat	45- Basecoat	45-R45 Dilutant	 100 : 70	 1.4 mm	 2 (spray to cover), ½ to match the effect	 approx. 10 min., until mat				
Clearcoat	40- 2K Clear	50- Hardener	60- Reducer	 2 : 1 or 2 : 1 + 10%	 1.3 mm	 2 40 – 60 µm	 30 min. at 60°C or 3 h 20°C			

Safety instructions:

The products are suitable for professional use only.
It cannot be ruled out that this product contains particles < 0.1 µm.

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