

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
- ASA Acrylonitrile styrene acrylate
- 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 **70-20** 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

- Apply **70-20** to the whole of the plastic part to be painted. Use one clean lint free cloth for application and one for wiping off.
- Do not allow 70-20 Cleaner Plastic to dry on the surface of the plastic, wipe off thoroughly.

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Standard Paint System - Plastic repairs

Properties: Repair process with 21-10 1K Plastic Primer and 2K Primerfiller 20-24 / 20-34 / 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	
Plastic adhesion Primer	21-10 1K Plastic Primer	Material is ready for use		1 – 2 thin, but coherent coats	15 min. At 20°C before filler application			
Primerfiller for flexible plastic	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., or until matt	
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	
	40- Ambient Clear	50-510		4 : 1		1-2 40 – 60 µm	5 min. at 60°C or 1 h 30 Mins at 20°C	

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












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Technical Information



Standard Paint System - New Plastic Parts

Properties: Wet on Wet process with 21-10 1K Plastic Primer

Cleaning	70-20 Cleaner Plastic	 1x	 wipe dry	70-20 Cleaner Plastic	 1x	 wipe dry	Heating of PU foamed polyamide (PA) to remove mould release agents and water, respectively	 1 h at 60°C	 1x moistened cloth
Plastic adhesion Primer	21-10 1K Plastic Primer	Material is ready for use				1 – 2 thin, but coherent coats		15 min. At 20°C before filler application	
Primerfiller	20-35/95 50-15 2K Hardener	60- Reducer	 3 : 1 : 1	 1.3 1.4 mm	 20 – 25 µm	 20 min. at 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., or until matt			
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		
	40- Ambient Clear	50-510		4 : 1		1-2 40 – 60 µm	5 min. at 60°C or 1 h 30 Mins at 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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