

# 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
- 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

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### 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.

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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

- 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

<b>Cleaning</b>	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.	1h 60°C	1x moistened cloth
<b>Bodyfiller</b>	12-20 Bodyfiller Universal (Only for fine scratches on hard plastic)	56-20 Bodyfiller Hardener	+2-3%		20°C 20-30 min	P80/P150 coarse sanding	1x 70-10	wipe dry	P240/P320	
<b>Plastic adhesion primer</b>	21-10 1K Plastic Primer	Material is ready for use	1-2 thin but coherent coats	15 min 20°C before filler application						
<b>Primerfiller for flexible plastic</b>	20-24,-34,-94 2K Primerfiller	80-10 Additive FLEX (For flexible plastics)	4:1							
<b>Primerfiller</b>	Mixture 2K Primerfiller / Additive FLEX	50-05 50-15 2K Hardener	60-Reducer	4:1:1	1.6-1.8	2 50-70 µm	30 min 60°C or 3 h 20°C	P400 orbital sander		
<b>Basecoat</b>	35 Line Basecoat	60-Dilutant	2:1	1.3	2 (spray to cover), ½ to match the effect	approx. 10 min or until matt				
<b>Clear coat</b>	40-2K Clear	50-Hardener	60-Reducer	2:1 or 2:1+10%	1.3	2 40-60 µm	30 min 60°C or 3 h 20°C			
	40-510 Ambient Clear	50-510/530 Ambient Clear Hardener		4:1		1-2 40-60 µm	5 min 60°C or 90 min 20°C			





















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# Technical Information Plastic Repair System



## Standard Paint System – New Plastic parts

Properties: Wet-on-Wet process with 21-10 1K Plastic Primer or 80-30 Additive Plast

<b>Cleaning</b>	70-20 Cleaner Plastic	 1x	 Wipe dry	70-20 Cleaner Plastic	 1x	 Wipe dry	Heating of PU foam and polyamide (PA) to remove mould release agents and water, respectively.	 1h 60°C	 1x moistened cloth
<b>Plastic adhesion primer</b>	21-10 1K Plastic Primer OR Use 80-30 in wet-on-wet system.	Material is ready for use	 1-2 thin but coherent coats	 15 min 20°C before filler application					
<b>Primerfiller</b>	20-35, -95 2K Primerfiller	50-15 2K Hardener fast	60-Reducer	 3:1:1	 1.3-1.4	 20-25 µm	 35 min 20°C		
<b>Basecoat</b>	35 Line Basecoat	60-20 Reducer Universal	 2:1	 1.3	 2	 approx. 10 min			
<b>Clear coat</b>	40-2K Clear	50-Hardener	60-Reducer	 2:1 or 2:1+10%	 1.3	 2 40-60 µm	 30 min 60°C or 3 h 20°C		
	40-510 Ambient Clear	50-510/530 Ambient Clear Hardener		4:1		1-2 40-60 µm	5 min 60°C or 90 min 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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