

# Technical Information

## System 5



### Painting of plastic parts

#### 1. Use

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

- BMC (bulk moulding compound) e. g. for spoilers
- PP-EPDM (polypropylene/ethylene propylene diene monomer) e. g. for bumpers
- PPO (polyphenylene oxide) e. g. for fenders
- PE (polyethylene) e. g. for wheel arches
- PUR (hard polyurethane foam) e. g. for bumpers
- ABS (acrylonitrile butadiene styrene) e. g. for grills or mirror housings
- PP (polypropylene) and some off PE (Polyethylene) cannot be painted.
- PU foam and polyamide (PA) must be pre-treated very meticulously. Heating for 60 minutes at 60°C can prevent adhesion problems by eliminating the release agents or moisture from the substrate.

#### 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.
- \*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.

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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### Standard Paint System - Plastic repairs

Properties: Repair process with 21-20 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>Body filler</b>	12-20 Bodyfiller Universal (Only for small 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>Adhesion primer</b>	21-20 1K Plastic Primer	Shake the bottle for 2 minutes. Material is ready for use	21-20	1-2 thin but coherent coats	15 min 20°C before filler application					
<b>Primerfiller</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>	45 Line Basecoat	45-R45 Reducer	100:70	1.4	2 (spray to cover), ½ to match the effect	app. 10 min, or until mat				
<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	90 min 20°C			

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













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## System 5



### Standard Paint System – New Plastic parts

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

Cleaning	70-20 Cleaner Plastic	 1x	 wipe dry	Scuff the entire area with Scotch-Brite™ Grey Ultrafine 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 70-20 and wipe dry
	Primerfiller	20-35, -95 2K Primerfiller	50-15 2K Hardener fast	80-30 Additive Plast	 3:1:1	 1.3	 1 ½ 20-30 µm	 20 min 20°C		
Basecoat	45 Line Basecoat	45-R45 Reducer	 100:70	 1.4	 2 (spray to cover), ½ to match the effect	 app. 10 min, or until mat				
	Clear coat	40-2K Clear	50-Hardener	60-Reducer	 2:1 or 2:1+10% 4:1	 1.3	 2 40-60 µm 1-2 40-60 µm	 30 min 60°C or 3 h 20°C 90 min 20°C		
		40-510 Ambient Clear	50-510/530 Ambient Clear Hardener							

#### 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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