

Plastic Parts

Technical Bulletin

05/08/2023

L8.06.03

DESCRIPTION

This document describes painting processes for exterior plastic car parts.

PRIMER CHECK

1. Check for OEM primer: Sand the surface with sanding paper P500 grit. When the sanding paper reveals a powder, the plastic part is primed.

2. Solvent sensitivity check: Wet a cloth with Antistatic Degreaser SB and gently rub the primed part. When the primer dissolves, it is classified as sensitive.

PREPARATION OF NON SENSITIVE PRIMED PLASTIC PARTS



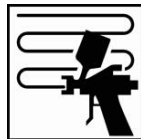
Clean the surface with warm water and detergent, rinse sufficiently with clean water. Next use Antistatic Degreaser SB.



Dry sand with P500 grit sanding paper.



Clean the surface using Antistatic Degreaser SB.



Apply the selected topcoat.
See product TDS for detailed product information.

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PREPARATION OF SENSITIVE PRIMED PLASTIC PARTS



Clean the surface with warm water and detergent, rinse sufficiently with clean water.
Next use Degreaser WB.



Dry sand with P500 grit sanding paper.



Clean the surface using Degreaser WB.



Apply 1K Primer WB according TDS L2.07.01.



Apply the selected topcoat.
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UNTREATED PLASTIC PARTS



Heat the plastic car part for 20 minutes at 60°C



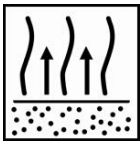
While the car part is still warm, clean the surface with warm water and detergent, rinse sufficiently with clean water.



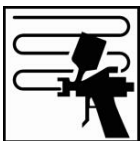
Thoroughly abrade with a liquid abrasive in combination with water.
For hard plastics: Use a 3M VFN (Purple) abrasive pad.
For flexible / soft plastics: Use a 3M UFN (Grey) abrasive pad.
Rinse sufficiently with clean water.



Clean the surface using Antistatic Degreaser SB.



Allow for a minimum flash off time of 15 minutes at 20°C



Apply an adhesion primer:
1K Multi Plastic Primer TDS L2.01.05

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PLASTICIZING FILLERS AND TOPCOATS

Fillers "sanding"	Plasticizer/Additive	Hard	Flexible	Soft
2K PU Primer 488	Flexible Additive	-	4:1	2:1

Fillers "non sanding"	Plasticizer/Additive			
2K PU Primer 488	Flexible Additive	-	4:1	2:1

Topcoat	Plasticizer/Additive	Hard	Flexible	Soft
2K Topcoat 320	Flexible Additive	-	4:1	2:1
2K Clearcoat 288 HS		-	4:1	2:1
Basecoat SB	728C/728CC hardeners	-	-	10%

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FOR PROFESSIONAL USE WITH SUITABLE HS&E EQUIPMENT

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