

Technical Information System



Painting of plastic parts

1. Use

baslac plastic cleaner 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 (acrylnitrile 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, i.e. 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.
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























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Technical Information System



Standard Paint System - Plastic repairs

Properties: Repair process with 21-20 1K Plastic Primer and 2K Primerfiller 20-24 / 20-34 / 20-94

Cleaning	70-20 Cleaner Plastic	 70-20 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 70-20 and wipe dry
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	Primerfiller / 50-15 Additive Flex	60- 2K Hardener 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 System



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	 1 h at 60°C	 1x 70-20 and wipe dry
	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., 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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