# 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)
  PP-EPDM (polypropylene/ethylene propylene diene monomer), e.g
  PPO (Polyphenylene oxide)
  PE (polyethylene)
  PUR (Hard polyurethane foam)
  e.g
  For bumpers
  e.g
  For wheel arches
  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.

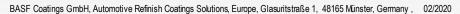
#### 3. Substrate

- 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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# **Technical Information System**



# **Standard Paint System - Plastic repairs**

Repair process with 21-20 1K Plastic Primer and **Properties:** 

2K Primerfiller 20-24 / 20-34 / 20-94

Cleaning

70-20

Cleaner **Plastic** 



1x

wipe dry



sanding pad

Sanding of damaged areas P80 – P600 Cleaner entire part **Plastic** 





to remove mould release wipe dry agents and water,



60°C



70-20 and wipe dry

**Body filler** 

12-20

Bodyfiller Universal

(only for hard plastic)

Bodyfiller Hardener

56-20

20°C 20 - 30 min.



P80 / P150 coarse sanding



respectively

wipe dry 1x



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



5 min

before filler application

Primerfiller

20-24/34/94

Primerfiller

**Additive Flex** For flexible

plastics

80-10



but coherent coats

Primerfiller

Primerfiller / 50-15 Additive

Flex

2K Hardener

60-

Reducer

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

2 (spray to cover), ½ to match the effect



approx. 10 min.,

Clearcoat

40-

40-

**Ambient Clear** 

50-2K Clear

Hardener

50-510

60-Reducer

2:1+10%

4:1

1.3 mm

1-2

2 40 – 60 µm 30 min. at 60°C or 3 h 20°C

5 min. at 60°C or 40 – 60 um 1 h 30 Mins at 20°C

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BASF Coatings GmbH, Automotive Refinish Coatings Solutions, Europe, Glasuritstraße 1, 48165 Münster, Germany, 02/2020



# **Technical Information System**



## **Standard Paint System - New Plastic Parts**

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

Cleaning Scuff the entire Heating 70-20 70-20 area with of PU foamand polyamide (PA) to Scotch-Brite™ Cleaner Cleaner remove mould **Grey Ultrafine Plastic** sanding pad. release agents and **Plastic** 1 h at 60°C wipe dry wipe dry 70-20 and wipe dry Primerfiller 21-11 50-15 60-2K Hardener Reducer Primerfiller 20 min. 30-40 µm 20°C Basecoat 45-R45 **Basecoat Dilutant** 100:70 1.4 mm 2 (spray to cover), approx. 10 min., 1/2 to match the effect or until matt Clearcoat 40-50-60-2K Clear Hardener Reducer 1 3 mm 30 min 40 – 60 µm at 60°C or

2:1+10%

4:1

### Safety instructions:

40-

**Ambient Clear** 

The products are suitable for professional use only. It cannot be ruled out that this product contains particles  $< 0.1 \mu m$ .

50-510

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3 h 20°C

5 min.

at 60°C or

1 h 30 Mins

at 20°C

1-2

40 – 60 µm