

## 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 Polyphenyloxyde
- 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

### 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.
- 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).

### 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 21-10 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	1 h at 60°C	1x moistened cloth
<b>Body filler</b>	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
<b>Plastic adhesion Primer</b>	21-10 1K Plastic Primer	Material is ready for use		1 – 2 thin, but coherent coats	15 min. At 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>	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	
<b>Basecoat</b>	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		
<b>Clearcoat</b>	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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# Technical Information



## Standard Paint System - New Plastic Parts

Properties: Wet on Wet process with 21-10 1K Plastic Primer

<b>Cleaning</b>	70-20 Cleaner Plastic	1x	wipe dry	70-20 Cleaner Plastic	1x	wipe dry	Heating of PU foamed polyamide (PA) to remove mould release agents and water, respectively	1 h at 60°C	1x moistened cloth		
<b>Plastic adhesion Primer</b>	21-10 1K Plastic Primer	Material is ready for use				1 – 2 thin, but coherent coats			15 min. At 20°C before filler application		
<b>Primerfiller</b>	20-35/95	50-15 2K Hardener	60- Reducer		3 : 1 : 1		1.3 1.4 mm		20 – 25 µm		20 min. at 20°C
<b>Basecoat</b>	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
<b>Clearcoat</b>	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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