

Plastic Parts

Technical Bulletin

09/11/2019

L8.06.03 UK & Ireland

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.

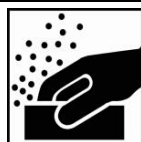
2. Solvent sensitivity check: Wet a cloth with Antistatic Degreaser SB and gently rub the primed part. When the primer dissolves, it is classified as sensitive.

PREPARATION OF NON SENSITIVE PRIMED PLASTIC PARTS



Clean the surface with warm water and detergent, rinse sufficiently with clean water.

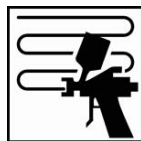
Next use Antistatic Degreaser SB.



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.



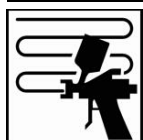
Dry sand with P500 grit sanding paper.



Clean the surface using Degreaser WB.



Apply 1K Primer WB according TDS L2.07.01.



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

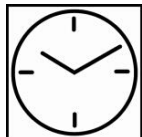
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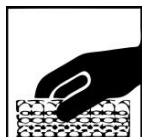
UNTREATED PLASTIC PARTS



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



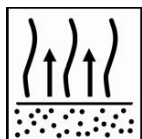
While the car part is still warm, clean the surface with warm water and detergent, rinse sufficiently with clean water.



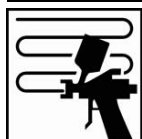
Thoroughly abrade with a liquid abrasive in combination with water.
 For hard plastics: Use a 3M VFN (Purple) abrasive pad.
 For flexible / soft plastics: Use a 3M UFN (Grey) abrasive pad.
 Rinse sufficiently with clean water.



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 / L2.01.06
 2K Universal Plastic Primer TDS L2.05.02

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PLASTICIZING FILLERS AND TOPCOATS

| Fillers "sanding" | Plasticizer/Additive | Hard | Flexible | Soft |
|----------------------|----------------------|------|----------|------|
| 2K HS Primer Filler | Flexible Additive | - | 4:1 | 2:1 |
| 2K Filler 540 | | - | 4:1 | 2:1 |
| 2K High Build Filler | | - | 4:1 | 2:1 |
| 2K Graphite Filler | | - | 4:1 | 2:1 |

| Fillers "non sanding" | Plasticizer/Additive | Hard | Flexible | Soft |
|-----------------------|----------------------|------|----------|------|
| 2K Filler 540 | Flexible Additive | - | 4:1 | 2:1 |
| 2K Graphite Filler | | - | 4:1 | 2:1 |

| Topcoat | Plasticizer/Additive | Hard | Flexible | Soft |
|-------------------------|----------------------|------|----------|------|
| 2K Topcoat HS420 | Flexible Additive | - | - | - |
| 2K HS Extra Clear | | - | 4:1 | 2:1 |
| 2K HS Fast Clear 420 | | - | - | - |
| 2K HS Premium Clear 420 | | - | - | - |

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