

Technical Information

Plastics Painting System

**B
10**

General:

Today you will find a variety of plastics on vehicles which require a special painting process. The following system allows a universal treatment of all coatable plastics. Polypropylene (PP) and Polyethylene (PE) in pure form are not paintable. These plastics are used almost exclusively in modified form however. They are then paintable, for example: PP/EPDM.

Processing:

1. Preparation

Crucial for the adhesion to plastic is the basic preparation and removal of mold release agent. Scrub with soap and warm water, then

Clean with:	Universal Cleaner for plastics Waterbased Cleaner	541-30 or 700-1
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Dry sand with 360/P600 or with a coarse sanding pad (in combination with 541-30)

Clean again with	Universal Cleaner for plastics Waterbased Cleaner	541-30 or 700-1
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PUR-Foam and PA (Polyamide) should be tempered for 1 hour at 140°F/60°C to allow mold release and water to leave the pores.

Clean again with	Universal Cleaner for plastics Waterbased Cleaner	541-30 or 700-1
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Dry with a lint free rag.

2. Adhesion Promoter

Spray plastic part with 1 full coat:	1K Plastics Adhesion Primer 2K Transparent Filler	934-0 or 285-0
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Flash off for 15 min. at 68°F/20°C.

NOTE: Refer to Glasurit's Plastic Painting Brochure (AD1612G) for choice of adhesion promoter.

Apply fillers.

3. Body Filler

If required, small scratches or scrapes on the plastic parts can be filled with: (see System B 10a)	Plastic Body Filler	839-90
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4. Spray Filler

Filler that has been elastified for plastic painting is now applied.

Spray entire part with 2 coats of	HS Primer	285-50 or
	HS Primer	285-51 or
	Universal HS Primer	285-60 or
	HS Tintable Primer	285-95 or
	Rapid Filler	285-100 or
	2.1 VOC Primer	285-21

To elastify the filler, Elastifier Additive must be added before the addition of the hardener. Generally, 25% by Volume (4:1) will be added, except for PUR soft foam parts, where 50% by Volume (2:1) Elastifier Additive must be added.

Elastifier Additive	522-111
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Drying time

The filler is applied in 2 coats. When 25% 522-111 is used, the dry time is 2-3 hours. When using 50% 522-111, the dry time is 3-4 hours.

After drying wet sand with 400/600; P800-P1200.

Clean with water and dry thoroughly.

5. Sealing

If the filling of defects is not required a wet-on-wet elastified sealer may be applied instead of a filler.

Spray 1-2 coats of elastified	2K Transparent Filler	285-0
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Wet on wet application is also possible with the following elastified primers: 285-60, 285-95 and/or 285-100. Allow 30 min. flash before top coat.

6. Topcoat

The following topcoats can be used:

Urethane Acrylic	22-
Base Coat	55-, 90-
Clear Coat	923-*

In the 22- line and the Clear 923-, Elastifier Additive **must be put in before** the hardener. Generally 25% is okay (same as above). On plastic parts as well as all PUR soft foam parts, the **total film thickness should not exceed 4 mils**; when this thickness is exceeded, the flexibility of the paint decreases.

No Elastifier Additive is added to basecoats, the Additive will only be added to the filler and the clear.

For **PUR Soft foam parts**, filler and topcoat need **50 %** Elastifier Additive 522-111.

Fiberglass parts which are easily identifiable do not need Plastics Adhesion Primer. Filler and topcoat are applied without Elastifier Additive.

* **Refer to specific clearcoat information in section EC to determine the appropriate clearcoat for each topcoat system.**