

Plastic Parts

FOR PROFESSIONAL USE ONLY

Description

If new plastic car parts are to be painted, it is essential to know the type or category of plastic involved. If the part is coated in an OEM primer, direct topcoat application after recommended preparation is possible. In case of untreated plastic, specific preparation steps are required, followed by application of the correct adhesion primer before any topcoat can be applied.

Primer check

This check consists of two steps:

1. Check for OEM primer: sand the surface with sanding paper (P500). If the sanding paper reveals a powder, one can assume that the plastic part is pre-primed, if not proceed to the **untreated plastic parts** section.

2. Solvent sensitivity check OEM primer: Wet a cloth with M700 Degreaser and gently rub the pre-primed part. If the OEM primer on the plastic car part dissolves directly when exposed to M700, the OEM primer is classified as sensitive.

Preparation of non sensitive pre-primed plastic parts



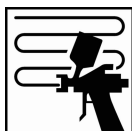
Clean the surface with warm water and detergent, rinse sufficiently with clean water.
Next use M700, Anti Static Degreaser or M200.



Sand with P500 dry or P1000 wet sanding paper



Clean the surface using M700, Anti Static Degreaser or M200



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

Preparation of sensitive pre-primed plastic parts



Clean the surface with warm water and detergent, rinse sufficiently with clean water.
Next use M200.

*Do **not** use M700 or Antistatic Degreaser*



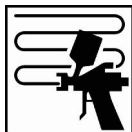
Sand with P500 dry or P1000 wet sanding paper



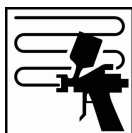
Clean the surface using M200.

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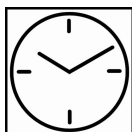


Sealer Plus or Autosurfacers WB application
Apply a thin coat and allow for a minimum flash-off time of 15 minutes at 20°C.
See TDS S2.02.03 or TDS 1.0.3 for detailed product information.



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

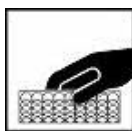
Untreated plastic parts



Heat up the untreated plastic car part for approximately 20 minutes at 60°C.



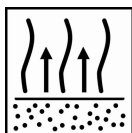
While the plastic part is still warm, thoroughly wash the surface with warm water and detergent and rinse with clean water.



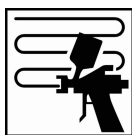
Thoroughly abrade with Sikkens Plastic Prep in combination with water.
Use a 3M VFN (Purple) abrasive pad on hard plastics and a 3M UFN (Grey) abrasive pad in case of a flexible/soft plastic part, rinse sufficiently with clean water.



Clean the surface using M700, Anti Static Degreaser or M200



Allow for a minimum flash-off time of 15 minutes at 20°C.



For primer application and process handling see product TDS:

Plastoflex Primer	TDS 1.6.3
1K All Plastics Primer	TDS S2.06.02
2K Plastic Primer	TDS 2.4.4
Colorbuild Plus with Plastic Additive	TDS S2.02.02
Primer PO	

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Primer / Additive	Substrate
Plastoflex Primer	All plastics, with the exception of PP
1K All Plastics Primer	All plastics
2K Plastic Primer	All plastics
Colorbuild Plus with Plastic Additive	All plastics, with the exception of PP
Primer PO	All plastics, with the exception of PP

Plasticizing fillers materials and topcoats

Fillers "sanding"	Plasticizer/Additive	Hard	Flexible	Soft
Colorbuild Plus	Elast-O-Actif	-	30%	X
Colorbuild		-	30%	X
Multi Use Filler Pro		50%	50%	150%
Autosurfacer HB		50%	50%	50%
Autosurfacer 940 HS		-	33%	33%
Autosurfacer Rapid		-	33%	33%

Fillers "wet-on-wet (non sanding)"				
Colorbuild Plus	Plastic Additive (HT)	Replace reducer		X
Colorbuild	Elast-O-Actif	-	30%	50%
Multi Use Filler Pro		-	30%	50%
Autosurfacer 940 HS		-	-	X
Autosurfacer Rapid Non Sanding		-	-	X

Topcoat	Plasticizer	Hard	Flexible	Soft
Autocryl	Elast-O-Actif	-	30%	50%
Autocryl Plus		-	30%	50%
Autoclear III		-	30%	50%
Autoclear		-	30%	100%
Autoclear Plus HS		-	30%	100%
Autoclear Basiq HS		-	30%	100%
Autobase		-	10%	10%
Autobase Plus	P Hardener	-	-	10%
Autobase Classic		-	-	10%

AkzoNobel Car Refinish bv. [Change in local name in case of difference; i.e. Coatings LTD / Inc.](#)
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IMPORTANT NOTE The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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