



PLASTIC COMPONENTS

CLASSIFICATION AND ELASTICITY DEGREE

Plastic components are classified according to their type, composition, family. It is important to identify the family to which they belong (rigid, flexible or soft materials) in order to choose the suitable coating:

1) RIGID MATERIALS (e.g. compartment, bonnet)

The treatment of these substrates does not differ from that of other car body components.

2) FLEXIBLE (e.g. bumper, lateral bands)

Once being slightly sanded by using Scotch Brite fine sandpaper, they must be degreased with AQUASTAR Waterborne Degreaser. Then coat them with Primer Plast-O-Prim, or Plastic Adhesion Promoter (clear-grey) according to the modalities specified in the technical sheet and apply the finish chosen.

3) SOFT MATERIALS (e.g. spoiler)

Once degreased with AQUASTAR Waterborne Degreaser, they must be treated with Primer Plast-O-Prim, or Plastic Adhesion Promoter (clear-grey) according to the relative technical sheet, then coat with the filler chosen and add 2K Elasticizer, in conformity with the relative technical sheets. In case of accurate works, we recommend to wait at least 24 hours before applying the finish in order to make the products applied be absorbed and to correct imperfections if any.

SUBSTRATES

RIGID		FLEXIBLE		SOFT
"A"		"B"		"C"
SMC	Reinforced polyester with fiberglass	ABS	Styrene of acrylonitrile butadiene	PUR Soft polyurethane
BMC	Reinforced polyester with fiberglass	PP/EPDM	modified Polypropylene	
GFK	Reinforced polyester with fiberglass	PA	Polyamide	

Tab. No. 1 Examples of plastic components




COATING PROCEDURES OF PLASTIC COMPONENTS

CYCLE


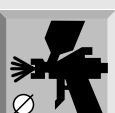

SUBSTRATE TYPE

A* B* C*

PREPARATION

	Sand using Scotch Brite sandpaper type "A" Very fine or "S" Ultra Fine	•	•	
	Degrease with AQUASTAR Waterborne Degreaser	•	•	•
	Apply Primer Plast-O-Prim or Plastic Adhesion Promoter (clear-grey)		•	•
	Apply the filler: 1015/513/511/311/HP Primer	•		
	Apply the filler: 1015/513/511/311/HP Primer + 5% Elasticizer 2K		•	
	Apply the filler: 1015/513/511/311/HP Primer + 10% Elasticizer 2K			•
	Apply DTM Primer	•	•	•

FINISHES

1K FINISH				
	1K Enamel	•		
2K FINISH				
	2K Enamel	•		
	2K Enamel + 5% 2K Elasticizer		•	
	2K Enamel + 10% 2K Elasticizer			•
2/3 COAT FINISH				
	Base 2/3 Coat	•	•	•
	111-622-421 Clear	•		
	111-622-421 Clear + 5% 2K Elasticizer		•	
	111-622-421 Clear + 10% 2K Elasticizer			•
	420 UHS Clear	•	•	•

NOTE

Reinforce polyester with fiberglass, composite materials such as carbon fibres, already treated substrate do not need Plast-O-Prim or Plastic Adhesion Promoter (clear-grey).

The addition of 2K Elasticizer to filler and finishes causes a 30% delay in drying times.

A* B* C* see the table on the previous page.