

# 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.

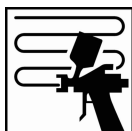


Sand with P500 dry or P1000 wet sanding paper

Abrade the edges and corners by using 3M SFN Copper or 3M UFN Grey (or similar) abrasive pad



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.

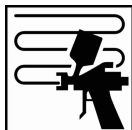
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## Preparation of sensitive pre-primed plastic parts cont'd

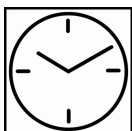


Colorbuild Plus Non Sanding, Autosurfacers Optima Non Sanding or Autosurfacers WB application  
Apply a thin coat and allow for a minimum flash-off time of 15 minutes at 20°C.  
See TDS for detailed product information.



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

## Untreated plastic parts

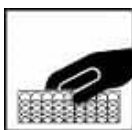


Always check for existing OEM primer on the new thermoplastic part; if not:

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



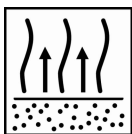
While the plastic part is still warm, thoroughly wash the surface with warm water and detergent and rinse with clean water.



Abrade the plastic part with a wet scuffing pad (grey) in conjunction with an abrasive compound detergent and (warm) water to scuff the untreated plastic surface, finally rinse sufficiently with clean water.

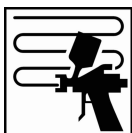


Clean the surface using M700, Anti Static Degreaser or M200



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

*Optimum adhesion is achieved when virgin plastic is coated within 30 minutes at 20°C. If this window is exceeded, repeat the degreasing and flash-off process, then apply the primer within the 15-30 minute flash-off window.*



For primer application and process handling see product TDS:

|                                                   |              |
|---------------------------------------------------|--------------|
| *1K All Plastics Primer                           | TDS S2.06.02 |
| 2K Plastic Primer                                 | TDS 2.4.4    |
| 2K Plastic Primer New                             | TDS S2.06.10 |
| Colorbuild Plus (with Plastic Additive / HT)      | TDS S2.02.02 |
| Autosurfacers Optima (with Plastic Additive / HT) | TDS S2.02.12 |

*\*When using 1K All Plastics Primer, apply a non-sanding (wet-on-wet) primer surfacer, such as Colorbuild Plus or Autosurfacers Optima, before topcoat application.  
This improves color accuracy, system durability, and chip resistance.*

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| Primer                  | Substrates                                                |
|-------------------------|-----------------------------------------------------------|
| 1K All Plastics Primer  | All plastics with the exception of those made of pure PE  |
| 2K Plastic Primer       | All plastics with the exception of soft PU thermoplastics |
| 2K Plastic Primer (new) | All plastics with the exception of soft PU thermoplastics |

| Filler/Autosurfacer mixed with dedicated plastic additive    | Substrates                                              |
|--------------------------------------------------------------|---------------------------------------------------------|
| Colorbuild Plus with Plastic Additive / HT (only wet on wet) | All plastics, with the exception of PE and PP-EP blends |
| AS Optima with Plastic Additive / HT (only wet on wet)       | All plastics, with the exception of PE and PP-EP blends |

### Plasticizing fillers materials and topcoats

| Fillers "sanding"     | Plasticizer/Additive                                                     | Hard | Flexible | Soft |
|-----------------------|--------------------------------------------------------------------------|------|----------|------|
| Colorbuild Plus       | Elast-O-Activ*<br>*Add % to A component before adding B and C components | -    | 30%      | X    |
| Multi Use Filler Xcel |                                                                          | -    | 30%      | X    |
| Multi Use Filler Pro  |                                                                          | 50%  | 50%      | 150% |
| Autosurfacer HB       |                                                                          | 50%  | 50%      | 50%  |
| Autosurfacer Rapid    |                                                                          | -    | 33%      | 33%  |
| Autosurfacer Optima   |                                                                          | -    | 15%      | 15%  |

| Fillers "wet-on-wet (non sanding)" |                                 |                 |     |     |
|------------------------------------|---------------------------------|-----------------|-----|-----|
| Colorbuild Plus                    | CBP Plastic Additive (HT)       | Replace reducer |     | X   |
| Multi Use Filler Pro               |                                 | -               | 30% | 50% |
| Autosurfacer Rapid Non Sanding     |                                 | -               | -   | X   |
| Autosurfacer Optima                | AS Optima Plastic Additive (HT) | Replace reducer |     | X   |

| Topcoat             | Plasticizer | Hard | Flexible | Soft |
|---------------------|-------------|------|----------|------|
| Autocryl Plus       | P Hardener  | -    | 30%      | 50%  |
| Autoclear Expert HS |             | -    | 30%      | 100% |
| Autoclear Xcel      |             | -    | 30%      | 100% |
| Autobase Plus       |             | -    | -        | 10%  |
| Autobase Classic    |             | -    | -        | 10%  |

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## Plastic Parts Identification

| Plastic ID            | Full name                                        | Typical use                               | 1K All Plastics Primer | 2K Plastic Primer | CBP + Plastic Additive | AS Optima + Plastic Additive |
|-----------------------|--------------------------------------------------|-------------------------------------------|------------------------|-------------------|------------------------|------------------------------|
| <b>ABS<br/>ABS-PC</b> | Acrylonitrile Butadiene Styrene / -Polycarbonate | Front Grille / Spoiler trims              | X                      | X                 | X                      | X                            |
| <b>ASA</b>            | Acrylonitrile Styrene Acrylate                   | Front Grille / Spoiler Trims              | X                      | X                 | X                      | X                            |
| <b>BMC</b>            | Bulk Moulding Compound                           | Body Panels, engine bay components        |                        | X                 | X                      | X                            |
| <b>EMPP</b>           | Elastomer Modified Polypropylene                 | Front Grille                              |                        | X                 | X                      | X                            |
| <b>HP Alloy</b>       | Honda Polymer Alloy                              | Side Mouldings                            | X                      | X                 | X                      | X                            |
| <b>PA</b>             | Polyamide                                        | Various                                   | X                      | X                 | X                      | X                            |
| <b>PBT</b>            | Polybutylene Terephthalate                       | Spoilers, side moldings, wheel arch trims | X                      | X                 | X                      | X                            |
| <b>PC</b>             | Polycarbonate                                    | Bumpers, body panels                      | X                      | X                 | X                      | X                            |
| <b>PE</b>             | Polyethylene                                     | Spoilers, side moldings, wheel arch trims |                        | X                 |                        |                              |
| <b>PP</b>             | Polypropylene                                    | Spoilers, side moldings                   |                        | X                 |                        |                              |
| <b>PP/EPDM</b>        | Polypropylene / Ethylene Propylene Diene Monomer | Bumpers, spoilers                         |                        | X                 | X                      | X                            |
| <b>PP/EPM</b>         | Polypropylene / Ethylene Propylene Monomer       | Spoilers, side moldings, wheel arch trims |                        | X                 | X                      | X                            |
| <b>PPE</b>            | Polyphenylene Ether                              | Body Panels, engine bay components        |                        | X                 | X                      | X                            |

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## Plastic Parts Identification cont'd

| Plastic ID | Full name                   | Typical use                               | 1K All Plastics Primer | 2K Plastic Primer | CBP + Plastic Additive | AS Optima + Plastic Additive |
|------------|-----------------------------|-------------------------------------------|------------------------|-------------------|------------------------|------------------------------|
| PPO        | Polypropylene Oxide         | Body Panels, engine bay components        | X                      | X                 | X                      | X                            |
| PUR        | Polyurethane                | Bumpers                                   | X                      |                   | X                      | X                            |
| RIM        | Reaction Injection Moulding | Spoilers                                  | X                      | X                 | X                      | X                            |
| PVC        | Polyvinyl Chloride          | Spoilers, side moldings, wheel arch trims | X                      | X                 | X                      | X                            |
| SMC        | Sheet Moulding Compound     | Body Panels, engine bay components        | X                      | X                 | X                      | X                            |

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### FOR PROFESSIONAL USE WITH SUITABLE HS&E EQUIPMENT

**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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