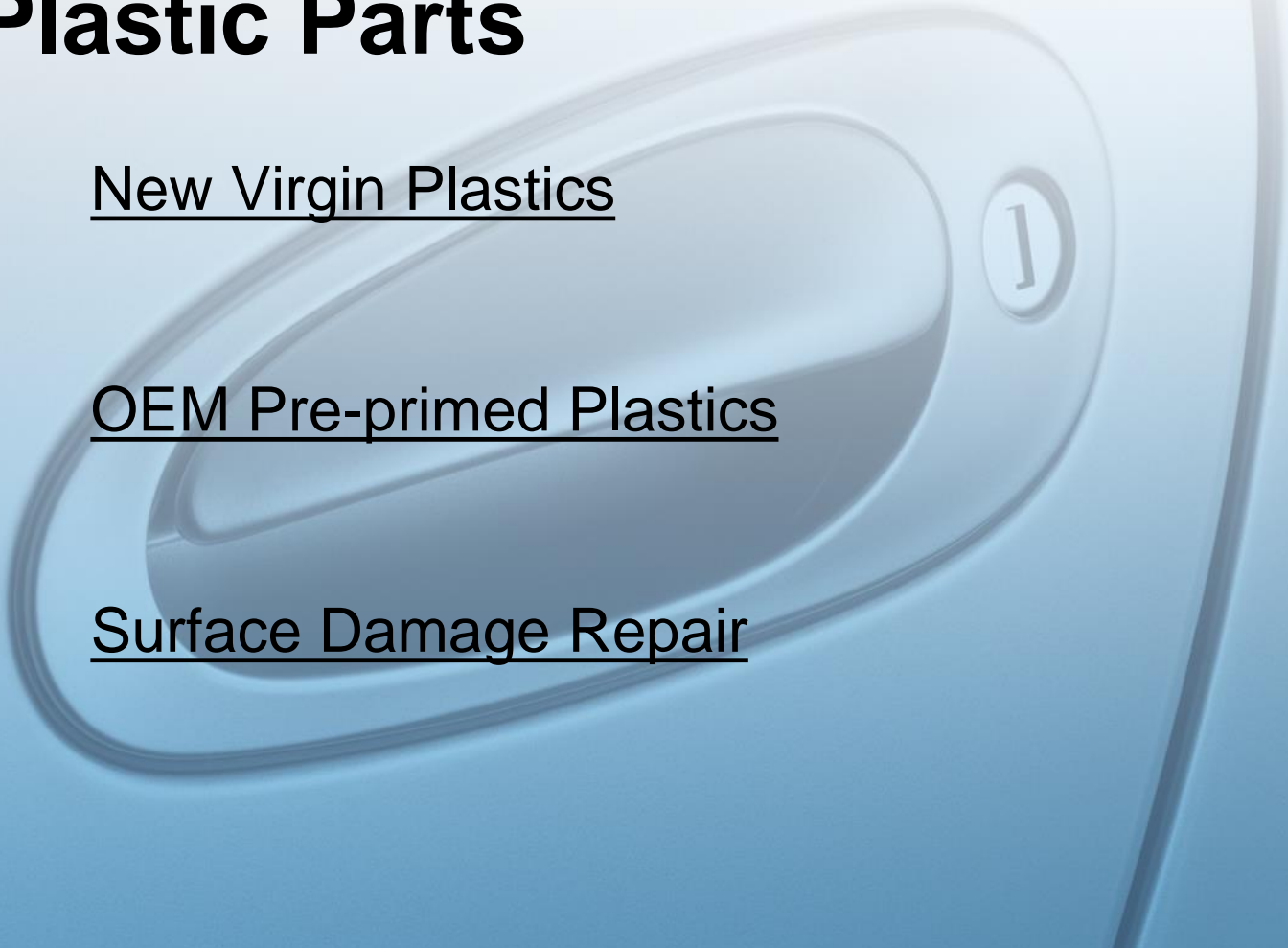


Plastic Parts

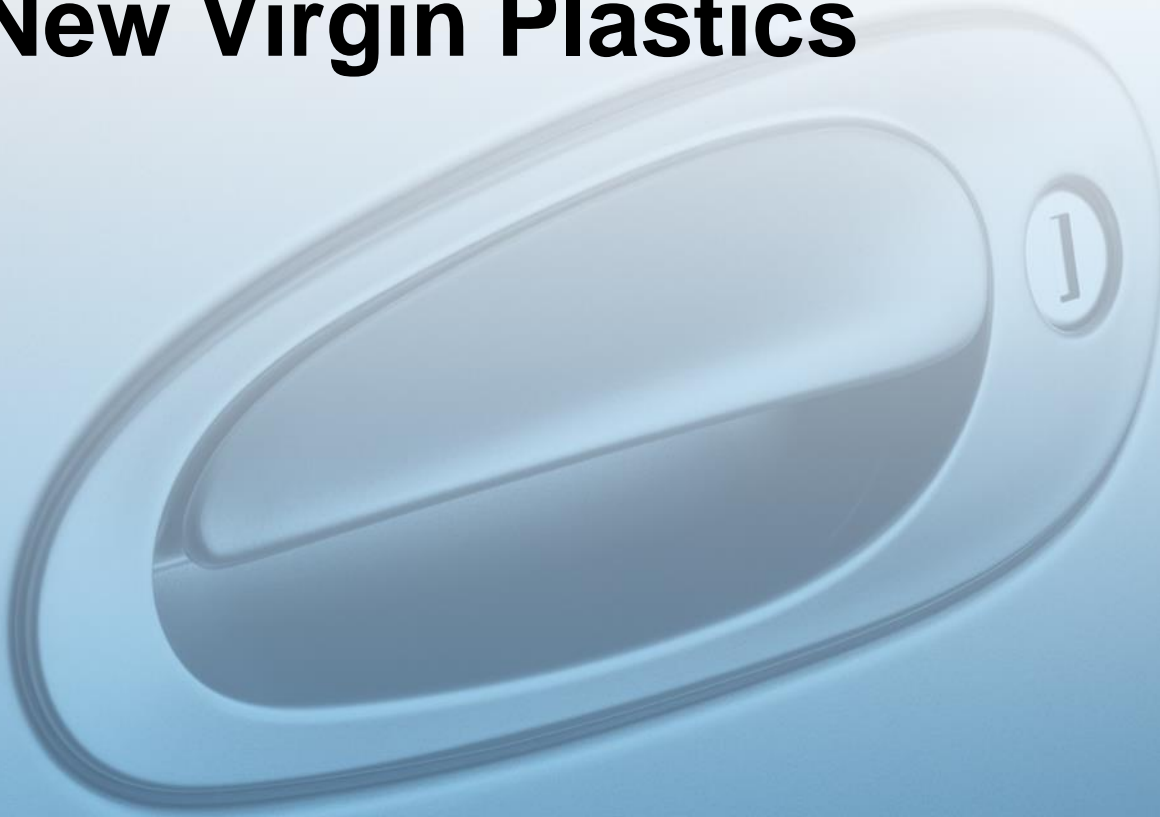
New Virgin Plastics

OEM Pre-primed Plastics

Surface Damage Repair

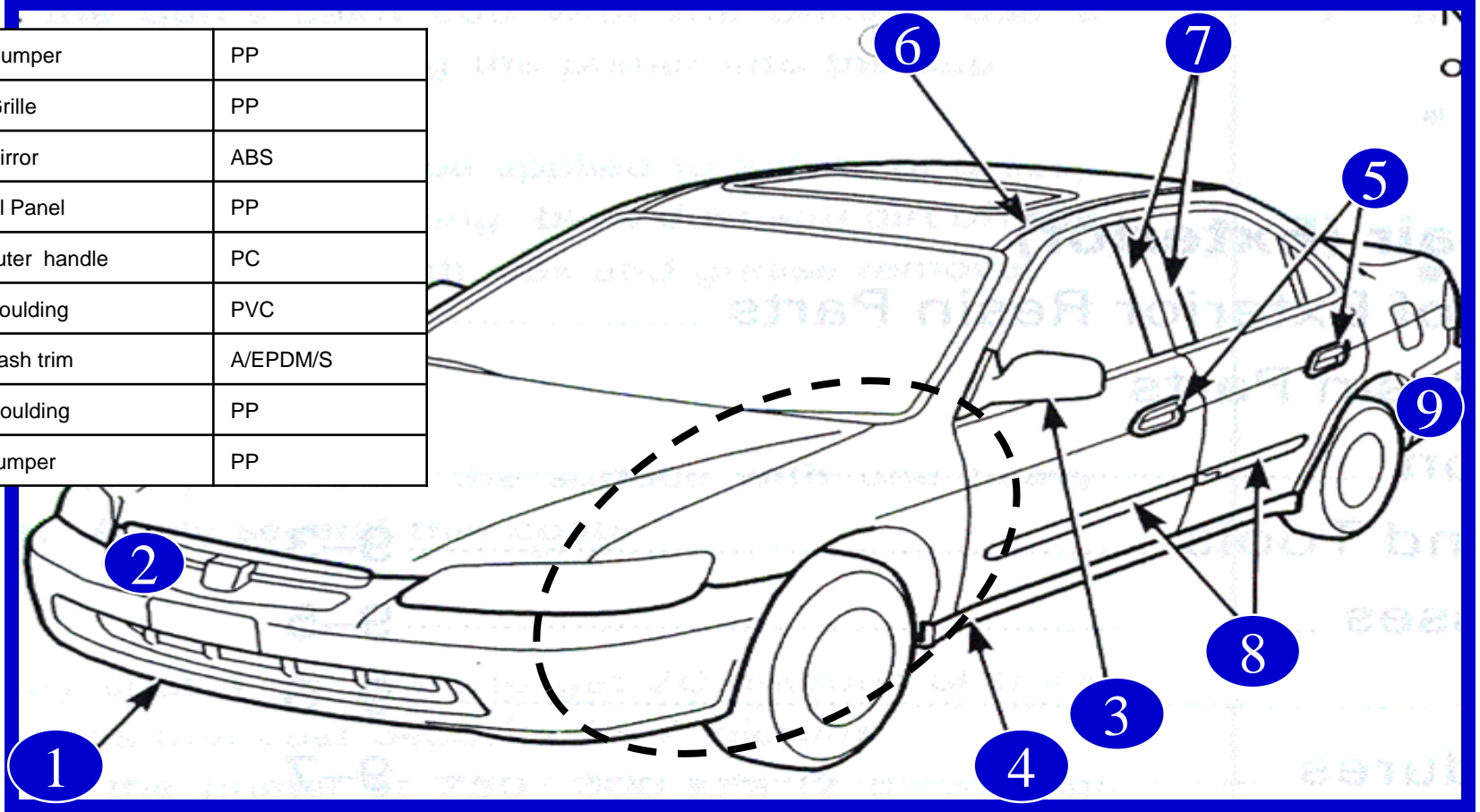


New Virgin Plastics



Types of plastic on a car

1	Front Bumper	PP
2	Front Grille	PP
3	Door Mirror	ABS
4	Side sill Panel	PP
5	Door outer handle	PC
6	Roof Moulding	PVC
7	Door Sash trim	A/EPDM/S
8	Door Moulding	PP
9	Rear bumper	PP



Car fender manufactured of various types of plastic

Types of plastic

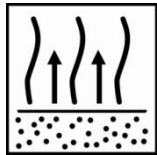
Coding	Material	Flexibility
UP-GFK	Glass fibre reinforced polyester	HARD
PUR-hard	Polyurethane	
PE	Polyethylene	
PP	Polypropylene	
ABS	Acrylonitril Butadiene Styrene	
EPDM	Ethylene Propylene Diene	FLEXIBLE
ASA	Acrylonitril Styrene Acryl	
A/EPDM/S	Acrylonitril Ethylene Styrene	
PUR-soft	Polyurethane	SOFT

Sweat process

Heat up the new plastic part



± 20 minutes at 60°C



Wax content will exude
from plastic part

- *Wax; molding
release agent*



Surface cleaning

Thoroughly wash with warm water and detergent

- Removing the release agent and other contamination
- Dry the plastic part
- Clean the surface thoroughly with the appropriate plastic surface cleaner



Surface preparation

Abrade the plastic surface with Plastic Prep / Plastic Fix

- Scuff pad and water

Rinse thoroughly

- Remove Plastic Prep residue

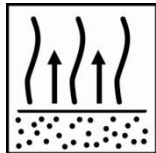
Dry the plastic part



Final surface cleaning

Clean the surface thoroughly with the appropriate plastic surface cleaner

Prior to primer application



± 15-30 Minutes at 20°C



Selection plastic adhesion primer

2K Plastic Primer

Substrates:

-PO

-TPO

-PP

-PP/EPM

-PP/EPDM

Plastoflex

Substrates:

-SMC

-PPD

-BMC

-PA

-GFK

-HP-Alloy

-PC

-PUR

-PDT

-TPU

-AB

-PP/EPM

-PP/EPDM



OEM Primer sensitivity test

Use fine sand paper

- Check for clogging/cacking

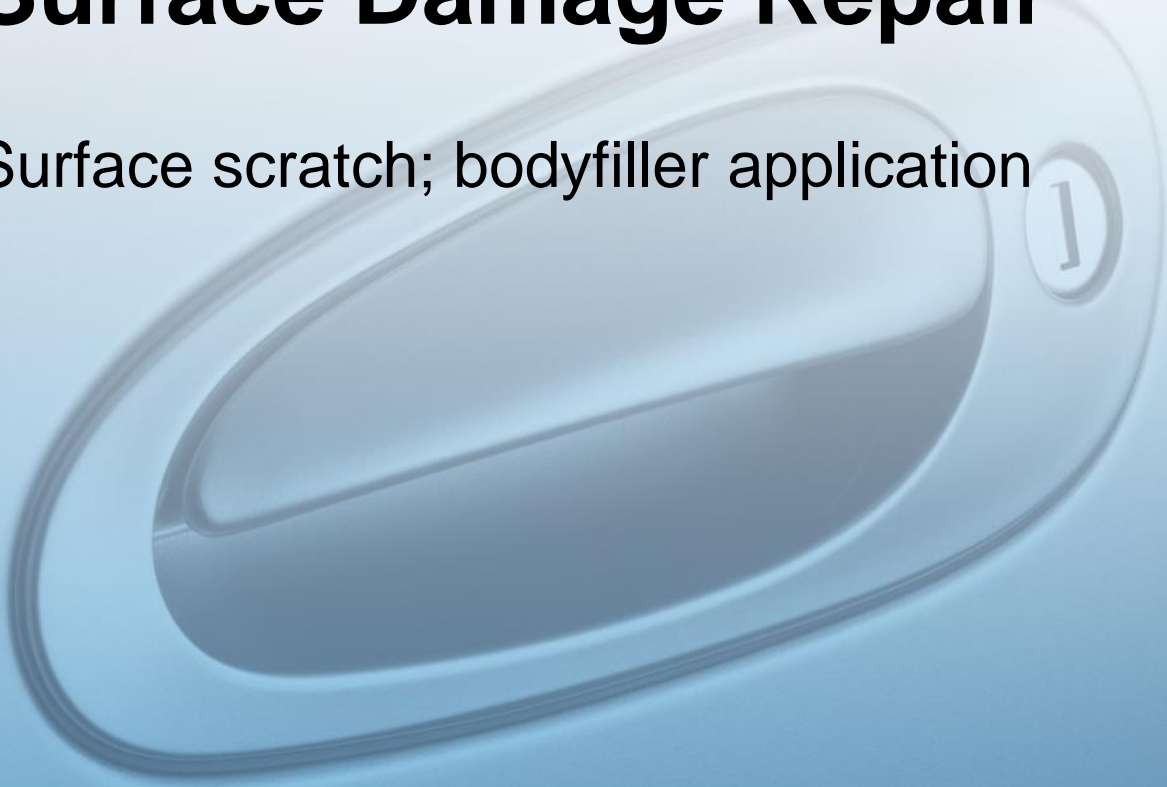
Use solvent surface cleaner

- Check for level of dissolvability



Surface Damage Repair

Surface scratch; bodyfiller application



Surface cleaning; washing

Surface damage on plastic bumper.

- Wash the repair area with warm water and detergent.
- Rinse the object with sufficient clean water.



Surface cleaning

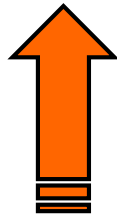
Use the appropriate surface cleaner.

- Use two clean high quality absorbent cloths.
- Wipe the panel dry before evaporation.

Wear solvent
resistant gloves.



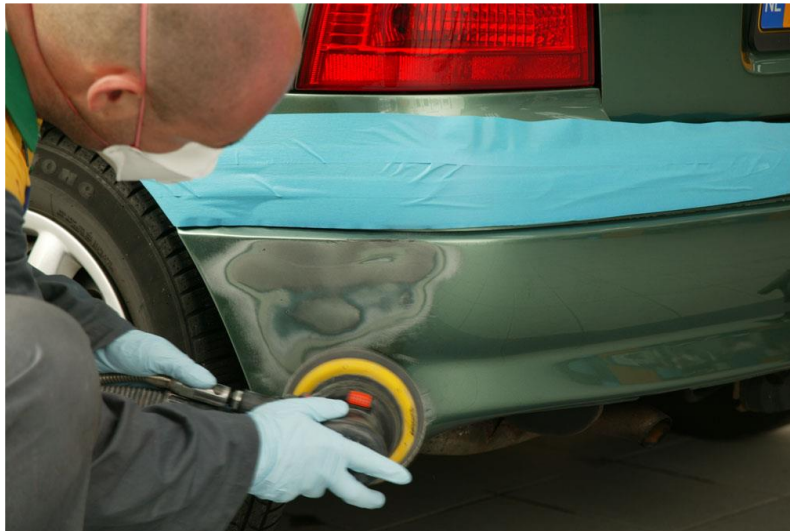
Surface cleaning; when?



Remove existing finish

Do not use too coarse abrasive material.

1. P120 – P220 (dependent of the damaged area).
2. P320



Surface cleaning

Remove contamination prior to bodyfiller application.

Use the appropriate surface cleaner.

- Use two clean high quality absorbent cloths.
- Wipe the panel dry before evaporation.

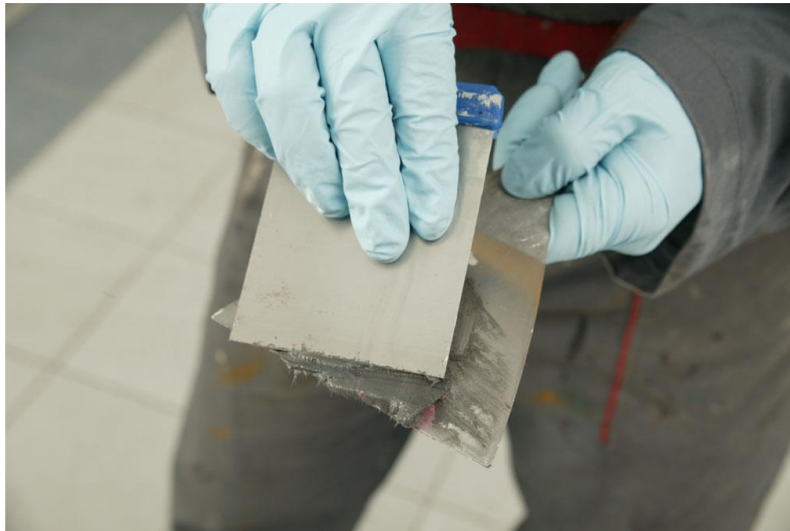
Wear solvent
resistant gloves.



Polyester bodyfiller application

Select the appropriate polyester bodyfiller.

- *See TDS for detailed information!
- Polykit



Polyester bodyfiller sanding

Recommended sanding steps.

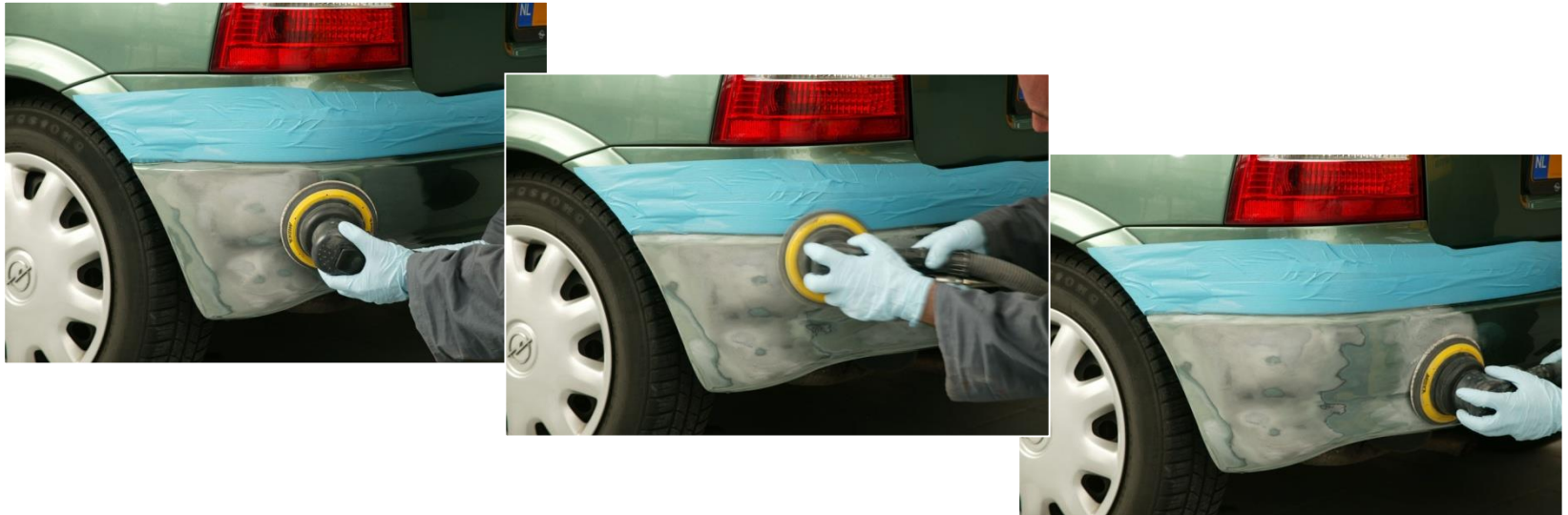
- P120-P220.
- Sand cross-wise for optimum flattening.



Sanding the featheredge

P220-P320-P400.

- Removing previous block sanding scratches.
- Extending the featheredge.



Surface cleaning

Removing all surface contamination.

- Prior to the application of the plastic adhesion primer.
- Allow for sufficient flash-off before primer application.
- Wear solvent resistant gloves.



Plastic Adhesion primer application

Primer application on bare areas only.

- *See TDS for detailed information!
- Plastoflex Primer
- Plastoflex Aerosol
- 2K Plastic Primer



Primer Surfacer application

Apply the appropriate Primer Surfacer.

- *See TDS for detailed information!
- Apply from out-side in.



Block sanding the repair area

Block sanding to level irregularities;

- P320-P400 (sand cross-wise for optimum leveling)
- Use flexible rubber, following surface contours.



Final sanding the repair area

Recommended sanding steps.

- P400-P500.



Blend area preparation

Removing surface texture, Abrade surface with:

- I.e.; 3M P1000.
- Use in combination with a soft back-up pad.

Abrade surface with:

- Abrasive pad, i.e.; 3M UFN (Grey).
- Water and Blend Prep.



Surface cleaning

Surface cleaning.

- Use two clean high quality absorbent cloths.
- Wipe the panel dry before evaporation.



Masking

Dust removing before spraying

- Appropriate tack rag



Paint application

Basecoat application



Clearcoat application

- *See clearcoat TDS for detailed information!



Happy Customer!

