

System Data Sheet.

Paint System for Plastic Parts

With this universal paint system all plastic parts commonly found on vehicle exteriors can be coated easily and reliably (plastic types: PP, EPDM, ABS, PC, PPO, PBTP, UP-GF, PA, PVC, R-TPU, PUR).

For professional use only!
System Data Sheet No. 903.1/10/2007 - GB



Substrate

Substrate pretreatment:



The substrate must be free of release agents. Before cleaning plastic parts, heat them for 60 minutes at +60°C to let the release agents exude. Clean with Priomat® Plastic Reducer 8581 or the milder Permaloid® Silicone Remover 7010. The extent of cleaning required depends on the type and quantity of release agents used. To facilitate the cleaning process, we recommend the use of a sanding pad. Allow the reducer to evaporate completely (e.g. air dry overnight at ambient temperature or low bake for 30-40 minutes at +60°C).



Before applying the primer, clean lightly one more with: Priomat® Plastic Reducer 8581 or Permaloid® Silicone Remover 7010

Paint system for unprimed plastic parts:

Primer:

To achieve good adhesion, plastic parts must be primed after they have been thoroughly cleaned. The painter can choose between A) and B) as described below.

- A) Apply Permacron® 1:1 Elastic Primer Surfacer 3300 (for application see Technical Data Sheet). Permacron® 1:1 Elastic Primer Surfacer 3300 is a primer surfacer that can be recoated directly with top coats.
- B) Apply Priomat® Elastic Primer 3304 / Permacron® 1K Elastic Primer 3410 * (for application see Technical Data Sheet) and then recoat with an elastified Permasolid® 2K surfacer. Then recoat with top coat.

For flash-off and drying times see respective TDS.

Special notes

Damaged surfaces:



Small scratches can be filled with Raderal® Fine Putty 0911 after a primer has been applied. After sanding, the putty spot must be isolated with:

- A) Permacron® 1:1 Elastic Primer Surfacer 3300
- B) Priomat® Elastic Primer 3304 / Permacron® 1K Elastic Primer 3410 * and then apply an elastified Permasolid® 2K surfacer

* for small parts / areas or sanded-through spots

Use of Permasolid® Elastic Additive 9050 in Permasolid® 2K HS surfacer:

15% for halfrigid + rigid types of plastic

30% for very flexible types of plastic

(for application see Technical Data Sheet of the respective surfacer)

Coated plastic parts may not be washed with a high-pressure jet cleaner within the first 6 weeks. After this period, the nozzle must be held at a distance of no less than 30 cm from the object.

1. One-stage finish

Top coat:



Mix Permasolid® HS Automotive Top Coat Series 275 with 15% Permasolid® Elastic Additive 9050*, then mix this mixture with hardener.



3:1 with Permasolid® VHS hardener + 15% Permacron® reducer (see Technical Data Sheet)

Application:



1 spray operation = 1.5 coats
(see Technical Data Sheet)

Drying:



Air dry overnight at +20°C or low bake for 30-40 minutes at +60°C after a final flash-off of 5-10 minutes

*Allow for longer drying times when Permasolid® Elastic Additive 9050 is used.

2. Two-stage finish

Solid, metallic, pearl colours:

Base coat:



Permahyd® Base Coat Series 280/285 and 10% Permahyd® Demineralised Water 6000
(see Technical Data Sheet)

Application:



1 spray operation = 1.5 coats
(see Technical Data Sheet)

Clear coat:



Mix Permasolid® HS clear coat with Permasolid® Elastic Additive 9050* (for application see Technical Data Sheet of the respective clear coat).

Application:



According to the Technical Data Sheet of the respective clear coat.

Drying:



Air dry overnight at +20°C or low bake for 40-45 minutes at +60°C after a final flash-off of 10 minutes

*Allow for longer drying times when Permasolid® Elastic Additive 9050 is used.

3. Semi-gloss finish

1st option: Two-stage finish

Base coat:



Permahyd® Base Coat Series 280/285 and
10% Permahyd® Demineralised Water 6000
(see Technical Data Sheet)

Application:



1 spray operation = 1.5 coats (see Technical Data Sheet)

Clear coat:



Mix Permacron® Elastic Clear Coat 8070 satin-gloss
3:1 with Permasolid® HS hardener + 10% Permacron® reducer
(see Technical Data Sheet)

or

5:1 mit Permasolid® VHS hardener + 20% Permacron®
reducer (see Technical Data Sheet)

Application:



2 coats with 5-10 minutes intermediate flash-off

Drying:



Air dry overnight at +20°C or low bake for 45-50 minutes
at +60°C after a final flash-off of 5-10 minutes

2nd option: One-stage finish

Top coat:



Mix Permasolid® HS Automotive Top Coat Series 275 1:1 with
Permasolid® Matt Component MA 100, then mix this mixture
with hardener.



4:1 with Permasolid® VHS hardener
+ 15% Permacron® reducer
(see Technical Data Sheet)

Application:



Apply 2 coats with an intermediate flash-off time of 5-10
minutes to achieve an even paint film surface.

Drying:



Air dry overnight at +20°C or low bake for 30-40 minutes at
+60°C after a final flash-off of 5-10 minutes

4. Textured finish

1st option:
Two-stage finish

Textured finish:



Mix Permasolid® HS Transparent Sealer 5180 1:1 with Permasolid® Texture Component SA 101 coarse / SA 102 fine, then mix this mixture with hardener.



5:1 with Permasolid® VHS hardener + 40-45% Permacron® Reducer 3380

Application:



2 coats with 5-10 minutes intermediate flash-off

Flash-off:



30 minutes at +20°C before recoating

Base coat:



Permahyd® Base Coat Series 280/285 and 10% Permahyd® Demineralised Water 6000 (see Technical Data Sheet)

Application:



Apply a tack coat followed by a normal full coat. With effect colours it may be necessary to apply another coat.

Clear coat:



Mix Permasolid® HS clear coat with Permasolid® Elastic Additive 9050* (for application see Technical Data Sheet of the respective clear coat).
Or as an alternative,
Permacron® Clear Coat 8070, 8075, 8085 (for application see Technical Data Sheet).

Application:



According to the Technical Data Sheet of the respective clear coat.

Drying:



Air dry overnight at +20°C or low bake for 45-50 minutes at +60°C after a final flash-off of 5-10 minutes

**2nd option:
One-stage finish**

Top coat:



Mix Permasolid® HS Automotive Top Coat Series 275 1:1 with Permasolid® Texture Component SA 101 coarse / SA 102 fine, then mix this mixture with hardener.



4:1 with Permasolid® VHS hardener
+ 15% Permacron® reducer
(see Technical Data Sheet)

Application:



2 coats:
Apply a normal full coat, flash-off for 5-10 minutes.
Apply the second coat to produce the desired textured effect.

Drying:



Air dry overnight at +20°C or low bake for 30-40 minutes at +60°C after a final flash-off of 5-10 minutes

The information provided in this documentation has been carefully selected and arranged by us. It is based upon our best knowledge on the subject at the date of issuance. The Information is given for information purposes only. We are not liable for its correctness, accuracy and completeness. It is up to the user to check the information with regard to up-to-dateness and suitability for his intended purpose.

The relevant Material Safety Data Sheet and Warnings displayed on the product label need to be observed.

The intellectual property in this Information, including patents, trademarks and copyrights, is protected. All rights reserved.

We may modify and/or discontinue operation of all or portions of this information at any time in our sole discretion, without notice and assume no responsibility to update the Information. All rules set forth in this clause shall apply accordingly for any future changes and amendments.

SPIES HECKER GMBH
Horbeller Straße 17
D-50858 Köln
Phone ++49 (0)2234 - 6019-06
Fax ++49 (0)2234 - 6019-4100
www.spieshecker.com

Spies Hecker.
A member of DuPont
Performance Coatings.

