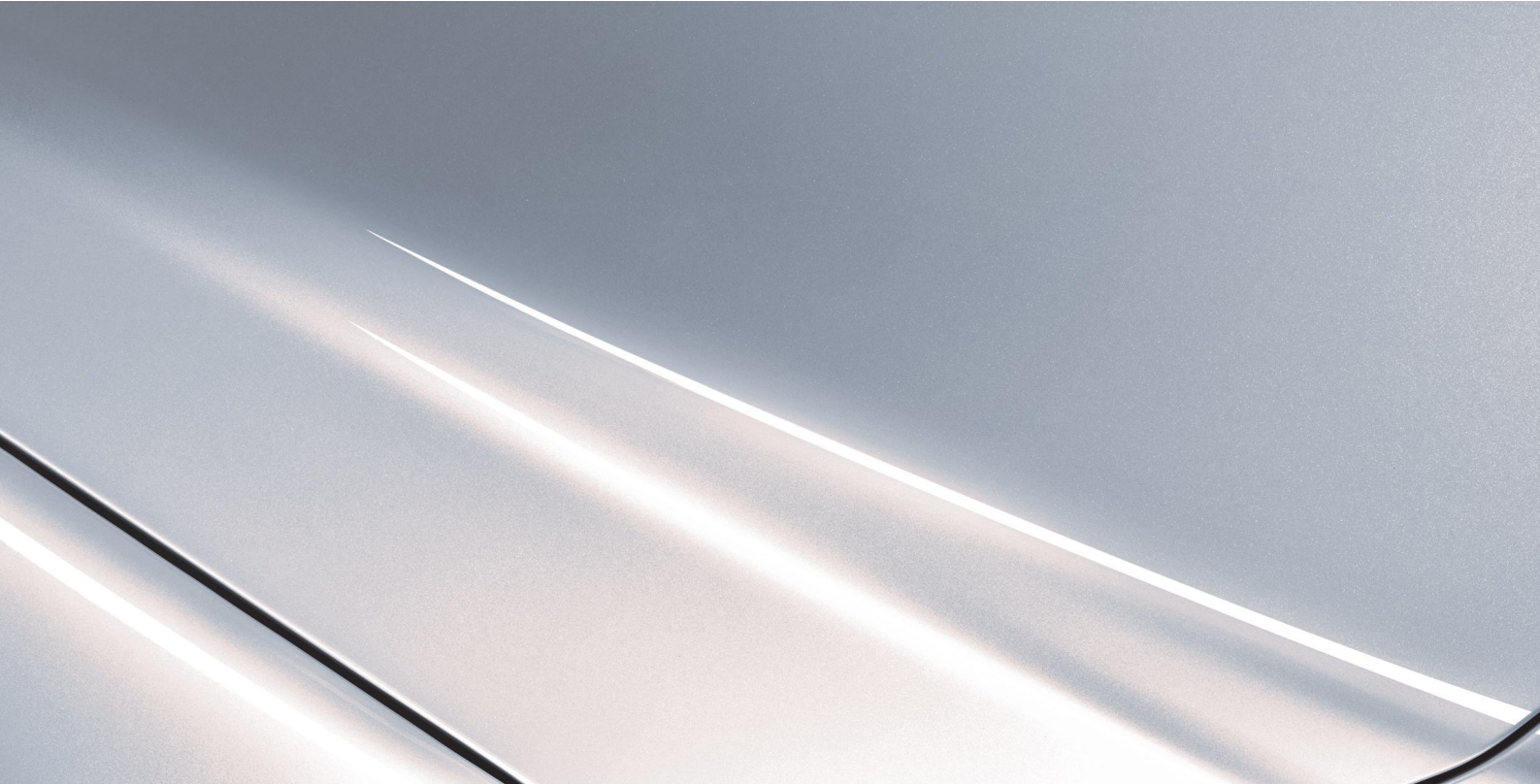
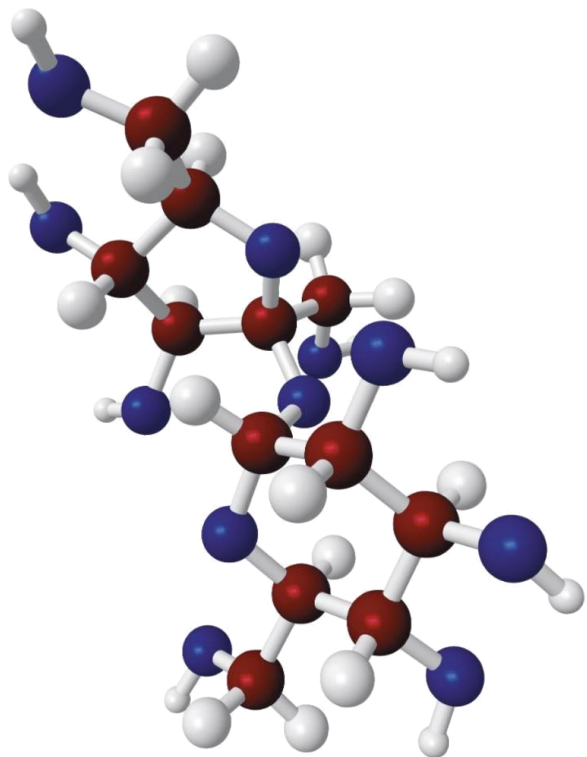




Plastic Painting System



There are many reasons for using plastics in automotive engineering. Most importantly, they help reduce vehicle weight and consequently also emissions and fuel consumption, without compromising on safety. In addition to purely functional aspects, however, plastics also play a major part with regard to the shape and design of a car.

Car manufacturers use a wide range of plastics and plastic blends, so the challenges facing refinishers are consequently growing, together with the need for detailed information on the use of plastics on cars and how to treat them correctly when repairing and painting.

This Plastic Painting System is the guideline for first time right plastic refinishing and has to be combined with the Technical Data Sheet of the relevant Standox product being used in the course of the repair process.



Plastic Painting System

Product preparation - application Plastic Substrates



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Repairs to exterior common plastic car parts, sanded and cleaned.
New exterior common plastic car parts, tempering 60 min. 60-65°C / first cleaning use a pad ultrafine soaked in Standoflex Plastic Cleaner antistatic 6500 / final cleaning use a cloth moistened with Standoflex Plastic Cleaner antistatic 6500.
Wipe surface to loosen and lift contaminants. Immediately, thoroughly wipe off with a clean cloth.
Change cloths often, never use dirty cloths.
Remove thoroughly all traces of release agents.



Plastic Designation*1	Tempering*2		U3070*3	U3200	U7580 / U7590*4	U7650 / U7660*5	U7670 / U7660*6	U3300*7	2K Filler*8	K9720 / K9510 / K9070*12
ABS	60 min	60-65°C	x	x	x	x	x	-	-	-
AS	60 min	60-65°C	x	x	x	x	x	-	-	-
ASA	60 min	60-65°C	x	x	x	x	x	-	-	-
BMC	60 min	60-65°C	x	x	x	x	x	-	-	-
CFK	---	---	-	-	-	-	-	-	X	-
EPDM	60 min	60-65°C	x	x	x	x	x	-	-	-
UP GF*9	---	---	-	-	-	-	-	-	X	-
Gelcoat*9	---	---	-	-	-	-	-	-	X	-
PA*10	60 min	60-65°C	x	x	x	x	x	-	-	-
PBT	60 min	60-65°C	x	x	x	x	x	-	-	-
PC	---	---	-	-	-	-	-	-	-	x
PC (Headlight)	---	---	-	-	-	-	-	-	-	-
PC	60 min	60-65°C	x	x	x	x	x	-	-	-
PMMA	60 min	60-65°C	x	x	x	x	x	-	-	-
PPE	60 min	60-65°C	x	x	x	x	x	-	-	-
PPO	60 min	60-65°C	x	x	x	x	x	-	-	-
PP*11	60 min	60-65°C	x	x	x	x	x	-	-	-
PS	---	---	-	-	-	-	-	X	-	-
PUR	60 min	60-65°C	x	x	x	x	x	-	-	-
PVC	60 min	60-65°C	x	x	x	x	x	-	-	-
PE	Not to be refinished at body shops									

Common Plastic-Blends	Tempering*2		U3070*3	U3200	U7580 / U7590*4	U7650 / U7660*5	U7670 / U7660*6	U3300*7	2K Filler*8	K9720 / K9510 / K9070*12
ABS + PBT	60 min	60-65°C	x	x	x	x	x	-	-	-
ABS + PC	60 min	60-65°C	x	x	x	x	x	-	-	-
ABS + PPO	60 min	60-65°C	x	x	x	x	x	-	-	-
ABS + TPU	60 min	60-65°C	x	x	x	x	x	-	-	-
PA + PPE	60 min	60-65°C	x	x	x	x	x	-	-	-
(Noryl GTX)	---	---	-	-	-	-	-	-	-	-
PBT + PC	60 min	60-65°C	x	x	x	x	x	-	-	-
PMMA + ABS	60 min	60-65°C	x	x	x	x	x	-	-	-
PMMA + PP	60 min	60-65°C	x	x	x	x	x	-	-	-
PP + EPDM	60 min	60-65°C	x	x	x	x	x	-	-	-
PUR + PVC	60 min	60-65°C	x	x	x	x	x	-	-	-
PUR + RIM	60 min	60-65°C	x	x	x	x	x	-	-	-

*1-*12 see remarks

Not applicable



VOC compliant

This product mix is not VOC compliant.

Plastic Painting System

Products

Standoflex Plastic Cleaner Antistatic 6500

Standoflex 2K Plastic Primer Surfacer U3200 Light Grey
Standoflex Plastic Adhesion Primer U3070
Standox Stone Chip Primer U3300 White

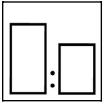
Standox VOC Nonstop Primer Surfacer U7580 Black
Standox VOC Nonstop Primer Surfacer U7580 Grey
Standox VOC Nonstop Primer Surfacer U7580 White
Standox VOC Plastic Additive U7590

Standox Plasticiser 5660
Standox VOC Xtra Filler U7560 Black
Standox VOC Xtra Filler U7560 Grey
Standox VOC Xtra Filler U7560 White

Standox VOC Xtreme Filler U7670 Black
Standox VOC Xtreme Filler U7670 Grey
Standox VOC Xtreme Filler U7670 White
Standox VOC Xtreme Plastic Additive U7660
Standox VOC Xtreme Wet-on-Wet Filler U7650 Black
Standox VOC Xtreme Wet-on-Wet Filler U7650 Grey
Standox VOC Xtreme Wet-on-Wet Filler U7650 White

Standocryl 2K Classic Pro Clear K9070
Standocryl VOC Easy Clear K9510
Standocryl VOC Xtreme Plus Clear K9720

Plastic Painting System



Product mix

The choice of hardener and Thinner should be made according to application temperature and size of repair.

ABS	Acrylonitrile butadiene styrene
AS	Acrylonitrile styrene
ASA	Acrylonitrile styrene acrylate
BMC	Bulk Moulding Compound
CFK	Carbon fiber reinforced plastic
EPDM	Ethylene propylene dienes
UP GF	Fiberglass reinforced plastic
PA	Polyamide
PBT	Polybutylene terephthalate
PC	Polycarbonate (Headlights)
PC	Polycarbonate
PE	Polyethylene
PMMA	Polymethylmethacrylate
PPE	Polyphenylene ether
PPO	Polyphenylene oxide
PP	Polypropylene
PS	Polystyrene
PUR	Polyurethane
PVC	Polyvinyl chloride

Plastic Painting System

Remarks

- . *1 Due to the increasing variety of plastic substrates present on the market, even the quality of the same plastic type (e.g. PP+EPDM) can differ a lot from brand to brand and type of car e.g. using different polymer blends and ratios thereof. Also release agents used during the production have a huge impact on the adhesion of the applied paint film. For this reason, a pre-test should be performed to ensure that the pre-treatment is sufficient for proper adhesion. The given build up recommendations should only be used as a reference guideline.
 - . *2 Depending of the heat resistance of the plastic or plastic-blend, suitable support must be used for the add-on parts to avoid deformation.
New exterior common plastic car parts, tempering 60 min. 60-65°C / first cleaning use a pad ultrafine soaked in Standoflex Plastic Cleaner antistatic 6500 / final cleaning use a cloth moistened with Standoflex Plastic Cleaner antistatic 6500.
Wipe surface to loosen and lift contaminants. Immediately, thoroughly wipe off with a clean cloth. Change cloths often, never use dirty cloths.
 - . *3 Standoflex Plastic Adhesion Primer U3070 needs to be overcoated with an elastified Standox 2K Filler.
 - . *4 Standox VOC Nonstop Primer Surfacer U7580 used in the plastic setting with VOC Plastic Additive U7590.
 - . *5 Standox VOC Xtreme Wet-on-Wet Filler U7650 used in the plastic setting with Standox VOC Xtreme Plastic Additive U7660.
 - . *6 Standox VOC Xtreme Filler U7670 used in the plastic setting with Standox VOC Xtreme Plastic Additive U7660.
 - . *7 Standox Stone Chip Primer U3300 must be applied in 2-3 thin coats.
 - . *8 Standox VOC Xtra Filler U7560 or VOC Nonstop Primer Surfacer U7580 are preferred.
 - . *9 Depending on the surface quality of the substrate, Standox Polyester Spray Filler U1100 can be applied upfront.
 - . *10 Polyamide parts (PA) which have been tempered and oven-dried after painting should not be assembled immediately (risk of fracture).
 - . *11 Pure Polypropylene (PP) is a critical substrate. Depending on the PP substrate quality, additional pre-treatment steps (e.g. flame pre-treatment) might be necessary to ensure proper adhesion of the subsequent paint build up.
 - . *12 For detailed information, please refer to the Headlight Repair System Data Sheet.
 - . For detailed usage recommendation and guideline please refer to the relevant TDS of the selected product.
 - . In order to limit dust enclosures in the paint film and to reduce the electric charging of the plastic car part being painted, the use of an antistatic gun like the Axalta Stat Gun should be considered.
 - . Refinished plastic car parts should not be washed with a high-pressure jet cleaner within the first six weeks. After this period, the nozzle must be held at a distance of no less than 30 cm from the object.
 - . If required and to remove minor imperfections in the course of repairs to exterior common plastic car parts, the usage of Standoflex Plastic Stopper U1030 should be considered. Please refer to relevant TDS.
 - . Follow the particular OEM process/ guidance on bumper repairs.
Pay attention on the film build limitations/ sensor requirements.
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Plastic Painting System

Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

All other products referred to in the refinish build up are from our Standox product range. System properties will not be valid when the related material is used in combination with any other materials or additives which are not part of our Standox product range, unless explicitly indicated otherwise.

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