

System Data Sheet.

The Paint System for plastic parts

Using this universal paint system, most plastic parts found on motor vehicles can be easily refinished.

(Types of plastic: PP, PP/EPDM, ASB, SAN, PC, PPO, PBTP, GRP, PA, PVC, R-TPU, PUR, PUR-RIM, PUR soft, T.PO, UP-GF.)

This product is for professional painting of vehicles only.
13 V.1



Substrate Primed Plastic

- Substrate Pretreatment:
- Perform a solvent test to check if primer is reversible.
1. If the primer is reversible, then strip and treat as raw plastic.
 2. If the primer is not reversible
 - a. Wash with soap and water, clean with Permaloid[®] Silicone Remover 7010 Slow, Permahyd[®] Silicone Remover 7085 or Permahyd[®] Silicone Remover 7096. Sand primer (with P500-800 dry or wet with P600-800). Make sure to scuff all of the edges and hard to reach area with a gray or gold scotch pad.
 - b. Re-clean with Permaloid[®] Silicone Remover 7010 Slow, Permahyd[®] Silicone Remover 7085, Permahyd[®] or Permahyd[®] Silicone Remover 7096.
 - c. Use the appropriate surfacer and/or topcoat.

Substrate Raw Plastic

- Substrate Pretreatment:
- The substrate must be free from release agents.
- Clean with Permahyd[®] Plastic Cleaning Paste 7081 using hot water and a gray or gold scuff pad.
- Rinse thoroughly and bake for 15-30 minutes at a surface temperature of 140°F.
- Once the bumper has cooled, scrub once more with Permahyd[®] Plastic Cleaning Paste 7081 using hot water and a gray or gold scuff pad.
Rinse thoroughly and dry.
- Now the appropriate primer/surfacer systems can be applied.

Paint System

Primer:

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

For new or undamaged plastic:

- A)** Apply Permacron[®] 1:1 Elastic Primer Surfacers 3300 (for application see VR Data Sheet 310.1). Top coats can be applied wet on wet on top of this primer surfacer.

For new, repaired or undamaged plastic:

- B)** Apply Priomat[®] Elastic Primer 3304 Transparent or Priomat[®] Elastic Primer 4190 Gray. See appropriate TDS for each product.
- a. An elastified surfacer must be applied over 3304 or 4190 prior to topcoat. Some may be used wet on wet, other surfacers may require sanding.

Recoat with:

- Elastified Permasolid[®] Vario Surfacers 8590
- Elastified Permasolid[®] Spectro Surfacers 5400
- Elastified Permacron[®] 2.1 Surfacers 5155
- Elastified Permasolid[®] 2.1 Surfacers 5157
- Elastified Permasolid[®] Spectro Sealers 5450

*See TDS for each surfacer for special mixing and application instructions for use over plastic substrates.

Finish with a top coat system.

Special Notes

	When using VHS Hardeners, be sure the mixture is stirred very thoroughly.
	See Wizard [®] product retrieval or specific TDS for mixing with VHS Hardeners
	No elastic additive is required in Permacron [®] Series 293/295, Permahyd Hi-TEC [®] 480, Permacron [®] Semi-Gloss Elastic Clear Coat 8070 or Permasolid [®] Clear Coat Additive 8091

Important Regulatory Information

- **For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components. Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates. Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.**
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