

# Product Data Sheet

September 2006

INTERNATIONAL MASTER  
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# Y0100

## Plastics Painting System Commercial Transport

### PROCESS DESCRIPTION

The **Nexa Autocolor** Plastics Painting System for CT gives a step by step approach to the successful painting of any plastic substrate, from cleaning and preparation through to texturing and topcoating.

The system details the fastest repair/painting process, whether the plastic type is identified or not.

Use P572-2001 1K Adhesion Primer for plastics, for all solvent paintable plastics when the plastic is unknown. For convenience an aerosol version P572-2000 is available for spot repairs or small components.

Specialist plastic primers P572-212 and P572-3500 are available when the substrate is known. In addition other **Nexa Autocolor** commercial transport primers can be used when the plastic substrate is known.

The following products are included in the system: -

<b>Preparation</b>	P273-1333	Cleaner for plastics
	P273-1050	Anti-static cleaner for plastics
	P551-1700	Porefiller for plastics
<b>Priming</b>	P572-2001	1K Adhesion primer for plastics
	P572-2000	Aerosol primer for plastics
	P565-897	HS Wet-on-Wet Undercoat
	P565-755	Transparent Sealer
<b>Topcoating Ancillaries</b>	P100-2020	Flexible additive for plastics
	P565-660	Fine texturing base for plastics
	P565-768	Coarse texturing base for plastics
	P565-98	Turbo Plus™ matting agent
	P565-9870	EHS Turbo Plus matting Agent



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### PRIMING WHEN PLASTIC IS KNOWN

As well as using P572-2001/2000, if the plastic substrate is identified, other **Nexa Autocolor** Commercial Transport primers can be used. The following table details a wide range of plastics used by vehicle manufacturers and the choice of primer available.

### PLASTIC IDENTIFICATION

ID SYMBOL	ID NAME	TRADE NAME	PRIMERS
PP/EPDM	Polypropylene / Rubber Modified Polyolefin	TPO, TPR, EPI, EPII, Nordel	P572-2001/-2000
PE	Polyethylene	Dylan, Fortifex, Marlex, Alathon, Hifax, Hosplen, Paxon	P572-2001/-2000
ABS	Acrylonitrile - Butadiene-Styrene	Cycloac, Abson, Kraslastic	P572-2001/-2000 P565-897 P565-755
PUR	Polyurethane Integral foam (RIM)	Bayflex Castethane	P657-2001/-2000 P565-897 P565-755
PBT	Polybutylene Terephthalate	Boxloy "M"	P657-2001/-2000 P565-897 P565-755
PC	Polycarbonate	Lexan, Calbre, Merlon, Macrolon	P657-2001/-2000 P565-897 P565-755
PVC	Polyvinylchloride	Geon, Vinylite, Plipvic, Vinoflex, Unichem	P657-2001/-2000 P565-897 P565-755
PA	Polyamide	GTX, Nylon, Capron, Zytel, Rilsan, Minlon, Vydyn, Wellamid	P657-2001/-2000 P565-897 P565-755
PPO	Polyphenyleneoxide	Neryl	P657-2001/-2000 P565-897 P565-755

For details of P565-897 and P565-755 please refer to relevant PDS's.

\* Some grades of PE are considered unpaintable.

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## CLEANING

Thorough preparation and cleaning are key to the successful painting of plastic parts. Remove silicone mould-release agents and other contaminants, such as traffic film, with Cleaner for plastics (P273-1333) mixed 1:1 with water. Apply using Scotchbrite™ Ultrafine and lightly scuff the surface at the same time. Rinse thoroughly with clean water and allow to dry. After using the cleaner the plastic part should be left overnight to dry or baked at 50°C for 60 minutes.

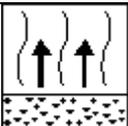
Anti-static cleaner P273-1050 is formulated specifically for plastic parts, providing the ideal clean surface for painting. The anti-static properties prevent the build-up of a static charge and ensure a dust-free finish. Apply P273-1050 to the whole of the plastic part being painted, using one lint-free cloth for application and one for wiping off contamination.

## FILLING

Porefiller for plastics P551-1700 is a stopper designed to fill the pinholes found in porous plastic components left by the moulding process. Apply by ragging onto the substrate with a lint-free cloth. Allow to air dry for 10 mins at 20°C, denib with P800 paper if necessary and apply Anti-static cleaner for plastics (P273-1050) again, as above. Care is required when using the Anti-static cleaner for plastics (P273-1050) over Porefiller for plastics (P551-1700) so that it does not wash it off.

## PRIMING WHEN PLASTIC IS UNKNOWN

### 1K Adhesion Primer for Plastic (P572-2001) Aerosol primer for plastic (P572-2000)

	Supplied ready for use		Supplied ready for use. Shake aerosol for at least one minute before use.
	1.4 - 1.8 mm 3.0 -3.7 bar (45-55 psi) Lower pressures 2.0-3.0 bar (30-45 psi) may be used when painting plastic parts of an awkward shape.		Spraying range 20 – 25 cm
	1.0 - 1.4mm, 10 psi at cap maximum		2 Single coats
	1 double coat		Allow two minutes flash-off time between coats
	<b>Air-dry (20°C):</b> 10-15 mins		<b>Air-dry (20°C):</b> 10 minutes
<b>TOPCOAT</b>	P572-2000/-2001 can be directly topcoated with the Turbo Plus™ (P488-Line), Turbo Plus HS (P496-Line) and EHS Turbo Plus (P498-Line). Over flexible plastics, Turbo Plus, Turbo Plus HS and EHS Turbo Plus topcoats and clearcoats must be modified with Flexible Additive (P100-2020) at the appropriate mixing ratio.		

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### TOPCOATING

Matted, textured and flexibilised finishes used for painting plastic parts are classified as special products under P96/34

### MATTING

Turbo Plus matting agent (P565-98) gives a smooth matt finish on plastic parts. It may be used in Turbo Plus (P488-line), and Turbo Plus Clearcoats.

EHS Turbo Plus matting Agent can be used in EHS Turbo Plus (P498-line) and EHS Clearcoats

### MATTED TOPCOAT OR CLEARCOAT

Where formulations are mixed as a result of microfiche formulations, these should be activated and thinned in the normal way.

### P488-LINE

The gloss of Turbo Plus (P488-line) can be reduced with the additions of Turbo Plus Matting agent (P565-98) as follows :-

Gloss Level	Turbo Plus	P565-98
Semi Gloss	3	1
Eggshell	2	1
Matt	1	1

**AFTER** adding the matting agent activate using hardener and thinner in the normal way (see relevant PDS)

Turbo Plus Matting Agent (P565-98) should be stirred thoroughly before use.

For full details refer to PDS V3520

### P498-LINE

The gloss of EHS Turbo Plus solid colours can be reduced by adding Turbo Plus Matting Agent (P565-98) as follows:

Finish	P498 Colour			
	P498/4- : P565-9870			
Colour	White	Black	Red/Yellow Colours	Blus / Green Colours
Semi Gloss	1 : 0.4	1 : 0.65	1 : 0.75	1 : 0.8
Eggshell	1 : 0.6	1 : 0.8	1 : 0.9	1 : 0.9
Matt	1:1	1 : 1.25	1 : 1.25	1 : 1.25

EHS Turbo Plus Matting Agent (P565-9870) should be stirred/shaken thoroughly before use.

The reduction in gloss levels varies between different colours, substrates, application/drying conditions and film thickness. It is advisable to spray a test panel before use and adjust the level of P565-98 / 9870 if necessary.

For full details refer to PDS V0930V

### FLEXIBILISING (P488-LINE AND 2 PACK PRIMERS)

Flexible additive for plastics (P100-2020) is a plasticising additive to enhance the flexibility of Turbo Plus and Turbo Plus HS topcoats, Turbo Plus clearcoats and undercoats over flexible plastics.

### Flexible Plastics

Mixing ratio:

2-pack primer, topcoat or clearcoat 5 parts

Flexible additive (P100-2020) 1 part

Activate and thin in normal way **AFTER** adding Flexible Additive (see relevant PDS)

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To reduce the gloss level of Turbo Plus when painting flexible plastics :-

Gloss Level	Turbo Plus	P100-2020	P565-98
Semi-gloss	5	1	2
Eggshell	5	1	3
Matt	5	1	6

### Very Flexible Plastics

Mixing ratio

2-pack primer, topcoat or clearcoat 2 parts

Flexible additive (P100-2020) 1 part

Activate and thin in the normal way **AFTER** adding Flexible Additive, (see relevant PDS)

To reduce the gloss level of Turbo Plus and Turbo Plus HS when painting very flexible plastics :

Gloss Level	Turbo Plus	P100-2020	P565-98
Semi-gloss	2	1	1
Eggshell	2	1	1.5
Matt	2	1	3

### FLEXIBILISING (P498-line EHS Turbo Plus)

Flexible Additive for Plastics (P100-2020) should be added to EHS Turbo Plus topcoat (P498-), when it is used over flexible plastic substrates.

To paint flexible substrates, apply a suitable **Nexa Autocolor** Primer. The primed plastic can be topcoated with EHS Turbo Plus mixed with P100-2020. If extra build is required apply the appropriate **Nexa Autocolor** 2-pack undercoat mixed with P100-2020 (please refer to Flexible Additive PDS for more information) prior to EHS Turbo Plus topcoat

P100-2020 should be added to EHS Turbo Plus in the following ratios:

### Rigid Plastics

Mixing ratios:

EHS Turbo Plus 5 parts

P100-2020 1 part

**AFTER** adding P100-2020 activate and thin in the normal way.

### Very Flexible Plastics

Mixing ratio:

EHS Turbo Plus 2 parts

P100-2020 1 part

**AFTER** adding P100-2020 activate and thin at **4:1:1**.

**NOTE:** The addition of P100-2020 to Turbo Plus topcoats, clearcoats and 2-pack undercoats will extend the normal drying time. The addition of P100-2020 will extend the drying times of EHS Turbo Plus.

High levels of matting agent in combination with flexible additive may result in low opacity with some bright colours. Additional coats or the use of a tinted undercoat may be necessary in these situations.

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**These products are for professional use only**, and are not to be used for purposes other than those specified. The information on this TDS is based on present scientific and technical knowledge, and it is the responsibility of the user to take all necessary steps in order to ensure the suitability of the product for the intended purpose.

For Health and Safety information please refer to the material Safety Data Sheet, also available at: [http://www.ppg.com/Autocolor\\_MSDS](http://www.ppg.com/Autocolor_MSDS)

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