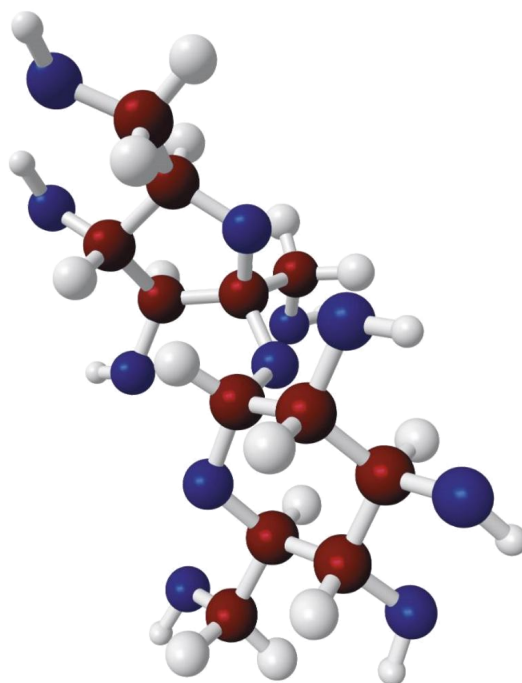


# PLASTIC PAINTING SYSTEM



## PRODUCT DESCRIPTION

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 Cromax product being used in the course of the repair process.

# TECHNICAL DATA SHEET

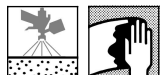


## PLASTIC PAINTING SYSTEM

### 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 3871S Plastic Prepclean / final cleaning use a cloth moistened with 3950S Anti-static Degreaser.  
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                        |                                    | 800R / 800RA*3                     | 90xR                               | NS260x / AZ9600*4                  | NS208x / AZ9700*5                  | XF308x / AZ9700*6                  | 2K Surfacers*7                     | CC6770 / VR-1120 / 3060S*11        |
|-----------------------|------------------------------------|------------------------------------|------------------------------------|------------------------------------|------------------------------------|------------------------------------|------------------------------------|------------------------------------|------------------------------------|
| PE                    | Not to be refinished at body shops | Not to be refinished at body shops |                                    |                                    |                                    |                                    |                                    |                                    |                                    |
| 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*8               | ---                                | ---                                | -                                  | -                                  | -                                  | -                                  | -                                  | x                                  | -                                  |
| Gelcoat*8             | ---                                | ---                                | -                                  | -                                  | -                                  | -                                  | -                                  | x                                  | -                                  |
| PA*9                  | 60 min                             | 60-65°C                            | x                                  | x                                  | x                                  | x                                  | x                                  | -                                  | -                                  |
| PBT                   | 60 min                             | 60-65°C                            | x                                  | x                                  | x                                  | x                                  | x                                  | -                                  | -                                  |
| PC (Headlight)        | ---                                | ---                                | -                                  | -                                  | -                                  | -                                  | -                                  | -                                  | x                                  |
| 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*10                 | 60 min                             | 60-65°C                            | x                                  | x                                  | x                                  | x                                  | 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 | Not to be refinished at body shops | Not to be refinished at body shops | Not to be refinished at body shops | Not to be refinished at body shops | Not to be refinished at body shops | Not to be refinished at body shops | Not to be refinished at body shops | Not to be refinished at body shops |

|                       | <20°C<br>bake<br>(40-45°C)         |                                    |                |      |                   |                   |                   |                |                             |
|-----------------------|------------------------------------|------------------------------------|----------------|------|-------------------|-------------------|-------------------|----------------|-----------------------------|
| Plastic Designation*1 | Not to be refinished at body shops | Not to be refinished at body shops | 800R / 800RA*3 | 90xR | NS260x / AZ9600*4 | NS208x / AZ9700*5 | XF308x / AZ9700*6 | 2K Surfacers*7 | CC6770 / VR-1120 / 3060S*11 |
| Plastic Designation*1 | Tempering*2                        | Tempering*2                        | 800R / 800RA*3 | 90xR | NS260x / AZ9600*4 | NS208x / AZ9700*5 | XF308x / AZ9700*6 | 2K Surfacers*7 | CC6770 / VR-1120 / 3060S*11 |
|                       |                                    |                                    |                |      |                   |                   |                   |                |                             |

| Common Plastic-Blends | Tempering*2 |         | 800R / 800RA*3 | 90xR | NS260x / AZ9600*4 | NS208x / AZ9700*5 | XF308x / AZ9700*6 | 2K Surfacers*7 | CC6770 / VR-1120 / 3060S*11 |
|-----------------------|-------------|---------|----------------|------|-------------------|-------------------|-------------------|----------------|-----------------------------|
| 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 (Noryl GTX)  | 60 min      | 60-65°C | x              | x    | x                 | x                 | x                 | -              | -                           |
| 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-\*11 see remarks



Not applicable

VOC compliant

This product mix is not VOC compliant.



## PLASTIC PAINTING SYSTEM

### Products

3871S Plastic Prepclean  
3950S Anti-Static Degreaser

800R Plastic Adhesion Promotor  
800RA Plastic Adhesion Promotor  
901R 2K Plastic Primer-Surfacer - VS1  
907R 2K Plastic Primer-Surfacer - VS7

AZ9600 Plastic Additive  
NS2601 Non-Sanding Primer-Surfacer - VS1  
NS2604 Non-Sanding Primer-Surfacer - VS4  
NS2607 Non-Sanding Primer-Surfacer - VS7

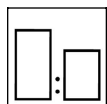
805R Flexible Additive  
PS1061 Cromax® Pro Surfacer - VS1  
PS1064 Cromax® Pro Surfacer - VS4  
PS1067 Cromax® Pro Surfacer - VS7

AZ9700 Ultra Performance Plastic Additive  
NS2081 Ultra Performance Non-Sanding Surfacer - VS1  
NS2084 Ultra Performance Non-Sanding Surfacer - VS4  
NS2087 Ultra Performance Non-Sanding Surfacer - VS7  
XF3081 Ultra Performance Surfacer - VS1  
XF3084 Ultra Performance Surfacer - VS4  
XF3087 Ultra Performance Surfacer - VS7

3060S High Efficiency Clear  
CC6770 Ultra Performance Energy System Clear  
VR-1120 ValueClear VOC

## PLASTIC PAINTING SYSTEM

### Product mix



The choice of activator 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                   |
| 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 3871S Plastic Prepclean / final cleaning use a cloth moistened with 3950S Anti-static Degreaser.  
Wipe surface to loosen and lift contaminants. Immediately, thoroughly wipe off with a clean cloth. Change cloths often, never use dirty cloths.
- \*3 Cromax Plastic Adhesion Promotor 800R/800RA needs to be overcoated with an elastified Cromax 2K Surfacer.
- \*4 Cromax NS 2601/NS2604/NS2607 Non-Sanding Primer Surfacer used in the plastic setting with Cromax Plastic Additive AZ9600.
- \*5 Cromax NS2081/NS2084/NS2087 Ultra Performance Non-Sanding Surfacer used in the plastic setting with Cromax AZ9700 Ultra Performance Plastic Additive.
- \*6 Cromax XF3081/XF3084/XF3087 Ultra Performance Surfacer used in the plastic setting with Cromax AZ9700 Ultra Performance Plastic Additive.
- \*7 Cromax PS1061/PS1064/PS1067 Cromax Pro Surfacer or Cromax NS2601/NS2604/NS2607 Non-Sanding Primer Surfacer are preferred.
- \*8 Depending on the surface quality of the substrate, Cromax VOC Spray Putty 799R can be applied upfront.
- \*9 Polyamide parts (PA) which have been tempered and oven-dried after painting should not be assembled immediately (risk of fracture).
- \*10 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.
- \*11 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 PP0480 Special Putty Kit for Plastic 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.

# TECHNICAL DATA SHEET



## 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 Cromax 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 Cromax product range, unless explicitly indicated otherwise.

For professional use only! 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 intellectual property in this Information, including patents, trademarks and copyrights, is protected. All rights reserved. The relevant Material Safety Data Sheet and Warnings displayed on the product label need to be observed. 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.