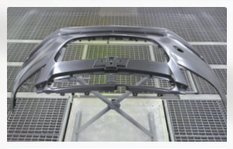
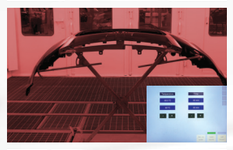
STANDOX PLASTIC REFINISH SYSTEM

Plastic Car Parts
NEW AND UNPRIMED



New exterior common plastic car parts made from:
ABS, AS, ASA, EPDM, PA, PBT, PC, PMMA, PPE, PPO, PP*, PUR, PVC, ABS+PBT, ABS+PC, ABS+PPO, ABS+TPU, PA+PPE, PBT+PC, PMMA+ABS, PMMA+PP, PP+EPDM, PUR+PVC, PUR+RIM

*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.



Tempering 60 min./60-65°C. Depending on the heat resistance of the plastic or plastic-blend, suitable support must be used for the add-on parts to avoid deformation.

First cleaning: use an ultrafine pad 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.
Thoroughly wipe off with a clean cloth immediately.
Change cloths often. Never use dirty cloths.
Remove thoroughly all traces of release agents!

Tack rag and blow with anti-static gun.

For improved adhesion properties on critical plastic substrates such as PP, the use of Standoflex Plastic Adhesion Primer U3060/U3070 prior to the application of VOC Xtreme Wet-on-Wet Filler U7650 mixed with VOC Xtreme Plastic Additive U7660 is recommended.

Apply Standox VOC Nonstop Primer Surfacer U7580
+ Standox VOC Plastic Additive U7590 or
Standox VOC Xtreme Wet-on-Wet Filler U7650
+ Standox VOC Xtreme Plastic Additive U7660.
Flash-off. Denibbing possible after flash-off.
Use P1000 abrasive or similar.

Apply Standoblue Basecoat with elastified Standocryl VOC Clears*
or elastified VOC Topcoat*.
Dry according to Technical Data Sheet.

*In countries without VOC legislation Standox Basecoat with elastified Standocryl 2K Clears can be used as well.

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.

Plastic Car Parts
NEW AND FACTORY PRIMED

Exterior common plastic car parts factory primed.

Clean carefully with Standox Precleaner 6800. Sand with P1000, Scotchbrite grey pad or similar.

Re-clean carefully with Standox Precleaner 6800.
Note: Depending on the quality of the factory primer, the use of Standox Silicone Remover 6600 or Standoflex Plastic Cleaner 6500 can cause swelling or redissolving issues while cleaning.

Tack rag and blow with anti-static gun.

Apply Standox VOC Nonstop Primer Surfacer U7580
+ Standox VOC Plastic Additive U7590 or
Standox VOC Xtreme Wet-on-Wet U7650
+ Standox VOC Xtreme Plastic Additive U7660.
Flash-off. Denibbing possible after flash-off.
Use P1000 abrasive or similar.

Apply Standoblue Basecoat with elastified Standocryl VOC Clears*
or elastified VOC Topcoat*.
Dry according to Technical Data Sheet.

*In countries without VOC legislation Standox Basecoat with elastified Standocryl 2K Clears can be used as well.

Plastic Car Parts
DAMAGED

Painted exterior common plastic car parts made from:
ABS, AS, ASA, EPDM, PA, PBT, PC, PMMA, PPE, PPO, PP, PUR, PVC, ABS+PBT, ABS+PC, ABS+PPO, ABS+TPU, PA+PPE, PBT+PC, PMMA+ABS, PMMA+PP, PP+EPDM, PUR+PVC, PUR+RIM

Inspect and clean damaged area with Standoflex Plastic Cleaner 6500 or Standox Silicone Remover 6600.

Major damage (cracks or deep scratches) must be repaired initially with special plastic repair kits (e.g. 3M, Tersoson, etc) provided that the effort required does not exceed the cost of a new part.

Sand damaged area with P280-P360. If stopper needs to be applied, sand damaged area with P180-P240.

Re-clean damaged area with Standoflex Plastic Cleaner 6500 or Standox Silicone Remover 6600.

If required apply UPOL PLAS/6 Plastic Bumperfill to the damaged area.

Optional: Prior to the stopper apply Standoflex Plastic Adhesion Primer U3070.

Sand to shape with P180-P240.
Refine the repair surface with P280-P360.
Hand sand corners and edges with P500-P600.
Feather the repair area with P360-P400.
Clean sanded areas with Standoflex Plastic Cleaner 6500 or Standox Silicone Remover 6600.

Apply Standoflex Plastic Adhesion Primer U3060/U3070.
Flash-off.
Apply a suitable elastified Standox VOC Filler
e.g. Standox VOC Xtra Filler U7560
Dry according to Technical Data Sheet.

Hand sand corners and edges with P800-P1000.
Machine sand with P500-P600 with suitable soft backing pad.
Remove sanding dust and clean with Standox Precleaner 6800.

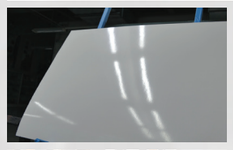
Tack rag and blow with anti-static gun.

Apply Standoblue Basecoat with elastified Standocryl VOC Clears*
or elastified VOC Topcoat*.
Dry according to Technical Data Sheet.

*In countries without VOC legislation Standox Basecoat with elastified Standocryl 2K Clears can be used as well.

Follow the particular OEM process/guidance on bumper repair. Pay attention to the film build limitations/sensor requirements. Follow relevant Standox product TDS's. Please refer also to the Standox Plastic Painting System TDS – SXPlasticSystem.
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 30cm from the object.

UP COMPOSITES
GELCOATED OR FACTORY PRIMED



Composites based on unsaturated polyester resin*:
UP-GF Fibreglass reinforced plastic
BMC Bulk Moulding Compound
SMC Sheet Moulding Compound

*Usually coated with Gelcoat protection layer (UP-GF) or factory primed by manufacturer (BMC/SMC).

Inspect surface for any damage or imperfections and clean with Standoflex Plastic Cleaner 6500 or Standox Silicone Remover 6600.
Sand with P180-P240 when coated with gelcoat.
Sand with P320-P360 when pre-primed by manufacturer.
Clean again with Standoflex Plastic Cleaner 6500 or Standox Silicone Remover 6600.

Apply a putty if required, e.g. UPOL Gold Fine Filler.
If required for Gelcoat surfaces, apply Standox Polyester Spray Filler U1100.
Adjust and apply products according to the Technical Data Sheet.
Coarse dry sanding P120-P220, refine by dry sanding P240-P360.
Remove dust and clean surface.

Apply a suitable Standox VOC Filler, e.g. VOC Xtra Filler U7560.
Dry according to Technical Data Sheet.

Hand sand corners and edges with P800-P1000.
Machine sand with P500-P600.

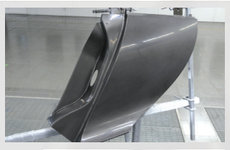
Remove sanding dust and clean with Standox Precleaner 6800.

Tack rag and blow with anti-static gun.

Apply Standoblue Basecoat with Standocryl VOC Clears*
or VOC Topcoat*.
Dry according to Technical Data Sheet.

*In countries without VOC legislation Standox Basecoat with Standocryl 2K Clears can be used as well.

CARBON FIBRE REINFORCED PLASTIC (CFRP)
FULL COVER BUILD



Composites made of Carbon Fibre Reinforced Plastic (CFRP)
Important remark: If the complex part structure of a load-bearing carbon fibre part is damaged, the part must be replaced. Failure to do so may lead to an increased safety risk.

Inspect surface for any damage or imperfections and clean with Standoflex Plastic Cleaner 6500 or Standox Silicone Remover 6600.
Sand with P180-P240.
Clean again with Standoflex Plastic Cleaner 6500 or Standox Silicone Remover 6600.

For small imperfections apply a putty if required,
e.g. UPOL Gold Fine Filler.
Adjust and apply according to the Technical Data Sheet.
Dry sanding P180-P240.
Remove dust and clean surface.

Adjust a suitable Standox VOC Filler, e.g. VOC Xtra Filler U7560.
Apply in 2 coats with intermediate flash-off to achieve approx 80 µm.
Dry according to Technical Data Sheet.
Machine sand with P240-P320.
Remove dust and clean with Silicone Remover 6600.

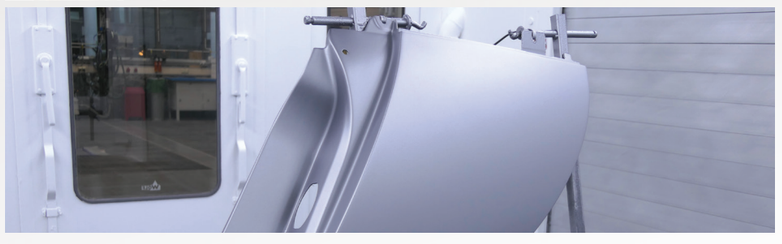
Re-apply the same Standox VOC Filler, e.g. VOC Xtra Filler U7560 again in 2 coats with intermediate flash-off to achieve approx 80 µm.
Dry according to Technical Data Sheet.
Hand sand corners and edges with P800-P1000.
Machine sand with P500-P600.

Remove sanding dust and clean with Standox Precleaner 6800.

Tack rag and blow with anti-static gun.

Apply Standoblue Basecoat with Standocryl VOC Clears*
or VOC Topcoat*.
Dry according to Technical Data Sheet.

*In countries without VOC legislation Standox Basecoat with Standocryl 2K Clears can be used as well.



CARBON FIBRE REINFORCED PLASTIC (CFRP)
WEAVE EFFECT LOOK

Composites made of Carbon Fibre Reinforced Plastic (CFRP) obtaining the carbon weave effect look
Important remark: If the complex part structure of a load-bearing carbon fibre part is damaged, the part must be replaced. Failure to do so may lead to an increased safety risk.

Inspect surface for any damage or imperfections and clean with Standoflex Plastic Cleaner 6500 or Standox Silicone Remover 6600.

Sand with sanding pad grey ultrafine or suitable soft backed pad. Sand carefully in order to avoid any damage to the carbon fibre weave.
Clean again with Standoflex Plastic Cleaner 6500 or Standox Silicone Remover 6600.

Use Axalta Carbon Fibre Sealer AXT505 to eliminate imperfections and to achieve a smooth surface to apply the clear coat on.
Apply first coat of Axalta Carbon Fibre Sealer. Flash-off.
Please consider specific product preparation for first and second coat.
Apply second coat of Axalta Carbon Fibre Sealer.
Dry according to Technical Data Sheet.

Sand with machine and P400-P600.
Remove dust and clean with Silicone Remover 6600.

Tack rag and blow with anti-static gun.

Apply a suitable Standox Clear*, e.g. Standox VOC Xtra Clear K9560.
Dry according to Technical Data Sheet.

*The use of Standox Clear Coat Additives is possible to achieve coloured effects. Depending on the required effect, 2-4% of Clear Coat Additive can be mixed to the clear, before adding hardener/thinner. In such cases finally finish the application with the same clear coat non-tinted.

Follow the particular OEM process/guidance on bumper repair. Pay attention to the film build limitations/sensor requirements. Follow relevant Standox product TDS's. Please refer also to the Standox Plastic Painting System TDS – SXPlasticSystem.
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 30cm from the object.

STANDOX
The Art of Refinishing.

An Axalta Coating Systems Brand