



Plastics painting *

CV 5

Application: Application of plastic parts of commercial vehicles
 Substrates: various plastic types

Pre-treatment

Cleaning - Sanding - Cleaning (See Technical Information Sheet A 4)

1) Plastic: **ABS, PC, GRP, SMC**

Surfacer

284-45

Hardener:
922-180 PRO
Reducer : 352-216

} **2:1+10-30%**

Equipment : gravity-feed spraygun
 Spray coats : 1½
 Film thickness: **40 – 60 µm**
 Drying : 60 min. 20°C or
 30 min. at 60°C
 panel temp

2) Plastic: **PA, PP-EPDM, PP T16 / T20, TPE**

Adhesion promoter

284-45

Hardener:
922-180 PRO
Reducer : 568-20

} **2 : 1 + 30%**

Equipment : gravity-feed spraygun
 Spray coats : **1**
 Film thickness: **ca. 20 - 30 µm**
 Drying : 60 min. 20°C or
 30 min. at 60°C

3) Plastic: **PP, PE****

Adhesion promoter

284-45

Hardener:
922-180 PRO
Reducer : 568-20

} **2 : 1 + 30%**

Equipment : gravity-feed spraygun
 Spray coats : **1**
 Film thickness: **ca. 20 - 30 µm**
 Drying : 60 min. 20°C or
 30 min. at 60°C

Afterwards on 1, 2, or 3)

Topcoat

68-

Hardener: 922-138
Reducer : 352-216

} **4 : 1 : 1**

Equipment : gravity-feed spraygun *
 Spray coats : 1½
 Film thickness: **40 - 60 µm**
 Drying : overnight air drying
 (16 h at 20°C) or
 30 min. at 60°C

* = See product data sheet for other equipment.

** = The adhesion on PE and PP can't be guaranteed.

* Due to different raw material supplier the quality of the different plastics can be differ from time to time.
 The adhesion should be checked before painting.

Safety instructions

- It cannot be ruled out that this product contains particles < 0.1 µm.
- The products are suitable for professional use only.
- For the use of this product please adhere to the actual safety recommendations and the personal protective equipment.