BASF AUTOMOTIVE REFINISH COATINGS

Brands of BASF – We create chemistry

The importance of using a flexible additive/product when painting flexible parts.

Clearcoats and undercoats are both essential components of the paint system that protect the vehicle from weathering, UV radiation, and physical damage. While invisible once repaired, the undercoat provides adhesion and prevents corrosion. The clearcoat layer provides the physical protection and UV resistance. When these components are applied to flexible parts such as plastic bumpers, they need to have the same ability to flex and bend as the part they are applied to. Flexibility is also critical for preventing stone chipping. If the undercoat/clearcoat is not flexible, they will fail, causing cracking, delamination, and chipping.

To address this issue, BASF offers a range of directly flexible products as well as additives that are specially formulated for the refinishing of plastic/flexible parts. The products improve the flexibility of the paint system, allowing it to flex with the underlying flexible substrate without cracking or delaminating. They also ensure the coating system has the flexibility to handle stone chips. This ensures that the coating maintains its protective properties over the lifetime of the part.

Below is an example of our technical process information that provides detailed information about the procedures and requirements of using a flexible undercoat and an additive for our clearcoat when refinishing plastic/flexible parts. We encourage you to review this information and review the Glasurit technical manual to find the specific process for the products available to you and follow the process and requirements for a quality repair when refinishing vehicles with flexible parts. As a final note, a requirement for the Glasurit lifetime warranty is that all proper products and processes are followed as documented in the technical manual, including using the proper products and products for flexible substrates.

If you have any further questions or would like to learn more about our products, please contact us at: 1.800.758.2273, and visit our website - https://refinish.basf.us

Tim Shrewsburg

Technical Director – Automotive Refinish

Painting of Plastics on Cars (1 step priming)

Properties: Multi-purpose system suitable for all paintable plastic materials on cars. Pure polypropylene (PP) and polyethylene (PE) cannot be painted. In order to guarantee paintability, modified plastic materials are used for vehicle parts that shall be painted. Although these plastic parts are often labelled PP, the material is nevertheless paintable.

Note: No tempering (or baking) necessary prior to painting plastic parts.

Cleaning	**541-30 Universal Cleaner for Plastics**	 1x	 Wipe dry	 damaged area: 80-360 entire part	**541-30 Universal Cleaner for Plastics**	 1x	 Wipe dry	
Fine Body Filler	**839-90 Plastic Body Filler**	**948-36 Hardener Paste**	 + 2-3%	 25-35 mins. at 68°F/20°C	 8 mins.	 80-150 coarse sanding	 240-320 fine sanding	 541-30 1x	 Wipe dry
Adhesion Promoter	**934-70 2K One Step Plastics Adhesion Promoter**	**929-53 HS Hardener**	**352-50,-91 Reducer**	 4:1:1	 HVLP 1.2-1.3 mm	 1 coat minimum 0.5 mil minimum	 20 mins. at 68°F/20°C		
						or			
						 >1 coat	 30 mins. at 140°F/60°C		

Topcoats	**22-Line Urethane Acrylic** ②	**or**	**55-Line Basecoat**	**923- Clearcoat** ①②	**or**	**90-Line Basecoat**	**923- Clearcoat** ①②	

① **see Matrix B 10 for a list of clearcoats which may be used with the selected basecoat.**

② **Topcoats or clears must be elastified by adding Glasurit® 522-111 Elastifier Additive or 522-333 Low VOC Elastifier Additive before being applied to plastic materials.**

22-Line Urethane Acrylic or 923- Clearcoat	**522-111 Elastifier Additive or 522-333 Low VOC Elastifier Additive**	 4:1

Mixture: 22-Line / 522-111 or 522-333 or 923- / 522-111 or 522-333	**929- HS Hardener**	**352- Reducer**	 2:1+10%	 HVLP 1.3 mm	 2 coats 22-line: 2.0-2.8 mils 923-: 2.0-2.5 mils	 16 hrs. at 68°F/20°C or 40 mins. at 140°F/60°C