



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>

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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
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 ① ②	or	90-Line Basecoat	923- Clearcoat ① ②
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- 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
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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
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Materials described are for application by professional trained personnel only using proper equipment. Products may be hazardous and should be used according to label directions and technical data information. Appropriate respiratory protection should be worn at all times while products are in use - read product label and Material Safety Data Sheet (MSDS) for specific details. Statements and methods described are based upon the latest standard of technology known to the manufacturer. Application procedures cited are suggestions only and are not to be interpreted as warranty for events resulting from their use. Dilution ratios are intended to provide maximum performance within the typical Volatile Organic Compound (VOC) restriction for product use. Specific VOC limits need to be referenced to verify local compliance. Altering the solvent or dilution ratio may impact VOC compliance. User is solely responsible to ensure product use and application is in accordance with all applicable regulatory, legislative, and municipal requirements.