

### Painting of Factory-Primed Plastic Parts

**Properties:**

New plastic hang-on parts are often factory-primed at the manufacturer's plant. Field tests have shown that the quality of such OEM primer coats varies significantly and may result in deficiencies with regard to adhesion as well as stone-chip and solvent resistance. In order to achieve the quality standards of OEM finishes, we recommend the use of a filler on all new plastic hang-on parts to ensure sufficient stone-chip resistance.

<b>Solvent resistance test</b>	352-91 Glasurit® Reducer normal	 1 x	Primer coat swells, becomes sticky, softens?	no = solvent-resistant	yes = solvent-sensitive

**extremely solvent-sensitive**

(complete dissolution or wrinkling during solvent resistance test) This indicates that the undercoat is not sound. Remove it completely before painting the part and then apply the desired paint system as described in process S 3.

**solvent-sensitive**

Clean the part with Glasurit 700-1 Cleaner using a grey sanding pad. Carry out a second cleaning step also with 700-1 and wipe the part dry with a clean cloth. Allow the part to flash off for at least 10 minutes. Before topcoating, apply a "mild" Glasurit 285- sanding primer filler or filler plasticised with Glasurit 522-111 Softface Additive. Spray several thin coats with long intermediate flash-off intervals. Attention! Any sand-throughs must then first be primed with Glasurit 934-10 1K Plastic Primer.

<b>Primer filler</b>	285-505, -555, -655 Glasurit® HS Primer Filler	522-111 Glasurit® Soft face Additive	 4:1

Mixture: HS Primer Filler / Softface Additive	929- Glasurit® HS Filler Hardener	352- Glasurit® Reducer	 4:1:1 mixing stick	 HVLP 1.7-1.9 mm 2.0-3.0 bar	 2 thin coats 40 - 60 µm	 flash off until matt between spraycoats	 4 h at 20 °C or 40 min. at 60 °C	 P 800
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**Alternatively:**

285-95 Glasurit® HS Tintable Filler

<b>solvent-resistant</b>	700-1 Glasurit® Cleaner	 wipe dry	 1x with a grey sanding pad	700-1 Glasurit® Cleaner	 1 x	 wipe dry

**Safety advice:**

The products are suitable for professional use only.

It cannot be ruled out that this product contains particles < 0.1 µm.

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<b>Primer filler</b>	285-31 Glasurit® HS Non-Sanding Filler light grey	929-56 Glasurit® HS VOC Primer Hardener normal	522-10 Glasurit® plastic additive	 3:1:1 mixing stick	 HVLP 1.3 mm 2.0-3.0 bar	 1/2 + 1 20 - 35 µm	 20 min at 20°C
	or alternatively: Glasurit 285-38 or -49 Non-Sanding Filler.						

<b>Topcoat</b>	22 Line Glasurit® HS 2K Topcoat VOC (1)	or	90 Line Glasurit® Basecoat	923- Glasurit® Clear VOC (1)
	(1) Topcoats and clears must be plasticised by adding Glasurit 522-111 Soffface Additive before being applied to soft plastics (soft PU foam).			

22 Line Glasurit® HS 2K Topcoat VOC or 923- Glasurit®	522-111 Glasurit® Soft face Additive	 4:1
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Mixture of HS 2K Topcoat + Soffface Additive or VOC Clear + Soffface Additive	929- Glasurit® Hardener VOC	352- Glasurit® Reducer	 2:1+10% mixing stick	 HVLP 1.3 mm 2.0-3.0 bar	 2 50-70 µm	 16 h at 20 °C or 45 min. at 60 °C
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