

Standox[®] Plastic Painting Systems

Repairing & Painting New, Unprimed Plastic Parts



Pretreatment / Cleaning	
<ul style="list-style-type: none"> • Clean the plastic 2-3 times with Standoflex[®] Low VOC Plastic Cleaner (16010) and clean, gold scuff pads each time. For hard to reach areas the included brush should be used. DO NOT let the cleaner dry on the part. Rinse thoroughly until the residue is removed. • Final clean with or Standohyd[®] Cleaner (16155/16166) or Standox Silicone Remover Antistatic (11654/15099). 	
Painting Option 1	Painting Option 2
<ul style="list-style-type: none"> • Mix Standoflex 2K Plastic Primer Surfacer (11816) 1:1 with Standoflex 2K Plastic Hardener (11824). Apply 2 coats. Flash off for 20 minutes at 68°F (20°C). 	<ul style="list-style-type: none"> • Apply 1 coat of ready to spray Standoflex 1K Plastic Primer (12065 or 14408). Flash off 10 minutes at 68°F (20°C). • Apply Standox 2K Nonstop Primer Filler (15331/16153/16154) with 15% Standox 2K Plasticiser (15260). Mix ratio is 3+15%:1+30%. Apply 1- 1.5 coats (1.2-1.6 mil). Flash off 20 minutes at 68°F (20°C).
<ul style="list-style-type: none"> • Single Stage: Mix 2K Standocryl[®] or 2K HS Standocryl with 15% 2K Plasticiser (15260). Then, mix according to the appropriate TDS. • Basecoat/Clearcoat: Apply Standox Basecoat or Standohyd Basecoat. Mix Standox 2K Clear with 15% 2K Plasticiser (15260). Then, mix according to the appropriate TDS. <p>Note: Up to 30% Standox 2K Plasticiser may be added for extremely flexible plastic parts.</p>	

Important Technical Remarks:

- Cleaning is the most important task in plastic refinishing and should be observed for optimum adhesion for most types of plastics, i.e. PUR and GRP. Do not clean with soap and water. Use **Standoflex** Low VOC Plastic Cleaner (16010).
- **Standoflex** 1K Plastic Primer (14408) is not compliant under the California Aerosol Products limitation.
- For extremely flexible parts and for vehicles subject to extremely high chipping environments, up to 30% **Standox** 2K Plasticiser must be added to **Standox** 2K Nonstop Primer Filler. Use as a sanding system.
- Addition of 15% Hardener to **Standox** Basecoat will improve chip performance on plastic parts.
- Using a gold scuff pad during the cleaning and sanding process improves adhesion.
- Allow six weeks to pass before cleaning the finished part with a high-pressure washer.
- Always prime raw plastic parts before using **Standosoft[®]** Fine Plastic for minor repairs. Re-prime repair areas.

Important Legislative Remarks:

- **For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components. Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.**
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