

Standox[®] Plastic Painting Systems

Repairing Plastic Parts (Minor & Major Repairs)



Pretreatment / Cleaning Option 1		Pretreatment / Cleaning Option 2	
<ul style="list-style-type: none"> Sand the damaged repair area. Clean bare plastic with Standoflex[®] Thinner 11000 (16160) and a clean, gold scuff pad. 		<ul style="list-style-type: none"> Sand damaged repair area. Clean the undamaged area (BC/CC area) 1 time with Standoflex Low VOC Plastic Cleaner (16010), water and a clean, gold scuff pad. Do not let the cleaner dry on the part. Rinse thoroughly until the residue is removed. 	
Painting			
<ul style="list-style-type: none"> For sand-throughs, apply 1 coat of Standoflex 1K Plastic Primer (12065/14408). Flash off for 10 minutes @ 68°F (20°C). 			
<ul style="list-style-type: none"> Apply Standox 2K Nonstop Primer Filler (15331/16153/16154) with 30% Standox 2K Plasticiser (15260). Mix ratio is 3+30%:1+30%. Apply 2-3 coats (2.4-3.6 mil). Dry and sand. 	<ul style="list-style-type: none"> Apply Standox 2.1 Filler (11999) with 30% Standox 2K Plasticiser (15260). Mix ratio is 2+30%:1+30%. Apply 2 coats (3.0 mil). Dry and sand. 	<ul style="list-style-type: none"> Apply Standox 2K HS System Filler (15161/16170) with 30% Standox 2K Plasticiser (15260). Mix ratio is 2+30%:1+30%. Apply 2 coats (3.0 mil). Dry and sand. 	
<ul style="list-style-type: none"> Basecoat/Clearcoat: Apply Standox Basecoat or Standohyd Basecoat. Mix Standox 2K Clear with 15% 2K Plasticiser (15260). Then, mix according to the appropriate TDS. Single Stage: Mix 2K Standocryl[®] or 2K HS Standocryl 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:

- Standoflex** 1K Plastic Primer (14408) is not compliant under the California Aerosol Products limitation.
- Addition of 15% Hardener to **Standox** Basecoat will improve chip performance on plastic parts.
- Using a gold scuff pad during the cleaning 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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