

NEW PLASTIC APPLICATION GUIDE



Application Guide:

2022

OVERVIEW:

Germa-Tech is a two-component Polyurethane Acrylic system, developed with world leading technology, delivering premium quality, durability and finish.

Some commonly used crash repair materials are made of plastic parts. With an increasing range of plastic types and characteristics now common, Germa-Tech has developed a range of products and processes for premium coating.

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PRECAUTIONS:

- Ensure all surfaces are free from contaminants
- Refer to individually TDS sheets for specific product information
- Ensure you are working in a clean dust free environment
- Ensure coatings are properly cured
- Wear respiratory protection such as a mask and suitable other Personal Protective Equipment (PPE)




Before any application is carried out it is critical to protect yourself with the correct Personal Protective Equipment such as a mask, gloves, overalls, and glasses.




Application Details:

Application Type:	Germa-Tech, New Plastic Application Guide
Application Description:	Preparation, priming , topcoat colour, and clear of new automotive plastic parts. Front and rear bars, skirts, trim, side mirrors and more.

Substrates:

	<p>Suitable on correctly prepared surfaces including most Thermo-plastic resin parts</p> <p>WARNING - some new plastic panels are pre-coated in enamel or other primers or manufactured with materials not suitable for plastic priming. On the inside of the new plastic panel (hidden side) apply a small amount of plastic primer as a test patch and observe for any adverse reactions.</p>
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Surface Preparation:

	<p>FULL RESPRAY – BRAND NEW BAR</p> <p>WARNING – Do not degrease pre-primed parts, some plastic parts contain a pre primed coating from OEM. Plastic parts contain surface release agents which must be thoroughly cleaned prior to application of primer. Failing to properly clean release agents may lead to poor adhesion and adhesion-related issues. Steps for surface cleaning below.</p>
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Application Flow:

Prepsol Degreaser:



FULL RESPRAY – BRAND NEW BAR

WARNING – Do not degrease pre-primed parts, some plastic parts contain a pre- primed coating from OEM

- Use Germa-Tech Prepsol Degreaser to remove surface release agents, use Germa-Tech Prepsol wipes to clean and do not allow to air dry, dry with a separate Prepsol wipe.
- Using blend prep, water and Germa-Tech scotch bright (grey) scuff the plastic surface thoroughly.
- Rinse with water and dry off by air blowing the surface
- Conduct a second degrease - using Germa-Tech Prepsol Degreaser to remove surface release agents, use Germa-Tech Prepsol wipes to clean and do not allow to air dry, dry with a clean Prepsol wipe.
- During the cleaning process the plastic parts may develop a static charge. This static charge can attract dust and particles during the paint application process. It is recommended to finally clean with a suitable plastic static cleaning agent.
- Allow surface to flash off for 10 mins before next coating

IMPORTANT NOTICE - 10 min flash off time from final clean must be allowed and do not degrease any pre-coated plastic.



Application Flow:

Plastic Primer:



Tack Wipe - Remove surface dust and dirt by wiping with a Germa-Tech Tack Rag.

Plastic Prime - Germa-Tech plastic primer is a single pack adhesion promoter used to prime plastic parts for the adhesion of paint to plastic. Available in clear 'ready for use' GP3301 / GP3302, or grey GP1390 reduced 1:1 with Germa-Tech premium reducer.

Shake contents of can well before use, apply at 1.5 bar with a 1.3mm nozzle.

Spray 1 even coat or 2 medium coats with a minimum flash off time of 15 minutes before the next coating.

Refer to the Plastic Primer TDS for further details.



Wet on Wet Primer:



Wet on Wet - Sealer – (application is optional but recommended)

Germa-Tech Wet on Wet is a multi-purpose double pack 2K Sealer, with strong filling power and fine adhesion, has excellent flexibility and impact resistance which can increase gloss and build of topcoat. Smooth paint film and non-sanding application. Application of Wet on Wet Sealer is an optional process but recommended.

Mix Germa-Tech Wet on Wet Surfacer at a ratio of 3 parts surfacer : 1 part dedicated hardener and 2.5-3 parts Germa-Tech premium reducer. Note: up to 8% Germa-Tech 2K colour can be added to the surfacer component in order to achieve a tinted ground coat primer.

Spray at 1.8 bar with a 1.3mm nozzle and spray 1-1.5 film thickness to no more than 35-um. Flash off time at 25 degrees is 10 minutes, allowing additional time in cooler conditions.

Do not tack rag if next directly applying topcoat colour. If sanding allows a minimum of 30 minutes at 25 degrees or 10 min at 60 degree bake.

Refer to the Wet on Wet TDS for further details.



Application Flow:

2K / Basecoat:



1k Base-coat - Germa-Tech, 1K base-coat (metallics, solids or pearls) are reduced 1 part colour to 0.6-1 part Germa-Tech premium reducer.

Spray at 1.8-2 bar with a 1.3mm nozzle. Spray 2-3 coats 1 bar – mist coat 1-2 with coat approx. 15um. Flash off 3-5 minutes between coats allowing to flash off 10-15min before clear coating. Finally clean base coat with Germa-Tech Tack Rag before application of clear coat.

2K - Germa-Tech 2k system, is mixed 2 parts solid colour : 1 part Germa-Tech hardener and is reduced 5-20% with Germa-Tech premium reducer.

Spray at 2 bar with a 1.3mm nozzle. Spray 2 coats with coat thickness 50um. Flash off time 10-15min between coats. Curing time at 25°C degrees is 10 hours and 70°C degrees is 30 minutes to polish.

Softening Agent

Germa-Tech softening agent may be added to the 1k base-coat or 2k Colour. Softening agent will improve the flexibility of the paint colour coating. This can greatly enhance the durability and adhesion of the topcoat.

Refer relevant TDS for further details



Clear Coat:



Application of Germa-Tech clear coat is required over all 1k base-coats. 2-3 coats are to be applied by following the Technical Data Sheet.

A number of clear coats are available in the Germa-Tech providing flexibility and depth in the range and options available, please contact the stockist to discuss which clear coat best matches your needs.

Flash off time between coats is 10-15min, with curing times defined in relevant Technical Data Sheets.

For speed clear applications and no required flash off times refer specifically to Germa-Tech High Velocity Clear or Germa-Tech Fast Dry 4:1

Application details refer to relevant TDS.



Additional Information:

1. **IMPORTANT NOTICE** - if any sanding of final coatings is required to fix imperfections (i.e. sagging), exceptional care must be taken not to break-through the top coat. Sub layers may not be fully cured and any re-application of top coat may result in adverse reactions; any reworking of the product is not covered by warranties and should be referred to the manufacturer before commencing.
2. DO NOT apply degreaser to pre primed/coated OEM panels.
3. DO NOT apply plastic primer to pre primed/coated OEM panels.
4. On the inside of the new plastic panel (hidden side) apply a small amount of plastic primer as a test patch and observe for any adverse reactions.
5. Do not apply plastic primer coatings in excess of advised thickness.
6. Allow all recommended flash off and cure times.

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The information contained in this file is presented in good faith based on thorough laboratory and field testing but without warranty. As we have no control over the conditions under which these products are used, it is recommended that all products be tested by the end user to ensure the suitability of the product for the particular application and conditions.

