

PLASTIC REPAIR APPLICATION GUIDE



Application Guide:

2022

OVERVIEW:

For the application of repairing damaged plastic panels or repainting of previously painted plastic parts. For new plastic parts including plastic parts such as PP, PA, PE, please refer to the Germa-Tech New Plastics Guide.

Application Guide

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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, Plastic Repair Application Guide

Application Description:

Preparation, repairing, priming, topcoat colour, and clear of previously coated automotive plastic parts. Front and rear bars, skirts, trim, side mirrors and more.

Substrates:

Suitable on correctly prepared surfaces including most Thermo-plastic resin parts

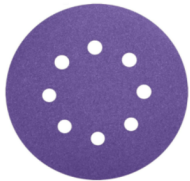
Surface Preparation:

All surfaces should be clean and thoroughly dry. Used compressed air to ensure the surface is completely dry.

Application Flow:**Prepsol Degreaser:**

Prepare the surface by removing surface contaminants with water and detergent followed by a high pressure rinse to ensure the surface is thoroughly clean. Remove remaining water with compressed air and leave to fully dry.

Once dry, clean the surface with Germa-Tech Prepsol Degreaser using one wet Germa-Tech Prepsol Wipe and followed by one dry prepsol wipe. Do not let Prepsol dry on the surface.

Sanding:

Start by dry sanding all damaged areas with P80-180 and P240-320 to remove damaged paint film, then fine sand and feather edges.

Air blow to remove all dust and dirt then degrease the surface with Germa-Tech Prepsol Degreaser and Germa-Tech Prepsol Wipes.



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 on bare plastic allowing 5 min flash off time.

Brush application for small parts.

Refer to the Plastic Primer TDS for further details.

Body Filler:


Polyester Body Filler - Germa-Tech polyester body filler can be lightly applied on any plastic primed surface.

Mix with supplied hardener 100g : 2-3g. Allow for curing 50 degrees - 5min or 25 degrees 20-30 min. Allow longer in colder conditions. Sand finish P80-P320 as required.

Wet on Wet Primer:


Wet on Wet - Sealer – (sanding application is 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 recommended on repaired plastic panels.

For non sanding applications 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.

For sanding applications Requiring Hi-Fill Build mix Germa-Tech Wet on Wet Surfacer at a ratio of 3 parts surfacer : 1 part dedicated hardener and 1.8-2 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 2-3 coats with a flash off time of 3-5min. Spray at 1.8 bar with a 1.3mm nozzle and spray 1-1.5 film thickness to no more than 35-um. Allowing curing time 25 degrees 40 min, longer in colder climates. Can force dry approx 10-15min at 60 degrees. Dry sand P400-P500, Wet Sand P600-P800. Final degrease with Germa-Tech Prepsol and Prepsol wipes. Refer to the Wet on Wet TDS for further details.

Application Flow:**2K / Basecoat:****1k Base-coat**

Germa-Tech, 1K base-coat system provides over 120,000 formulated colour options or full customisation of colours including pearls, metallics and solids. Application of base-coat is finished with a 2k clear coat over the top.

Prepare the top coat by cleaning with Germa-Tech Prepsol. Then wipe down with Germa-Tech Tack Rag. Coat 2 - 3 layers of 1k base-coat (reduced 1: 0.6-0.8 with Germa-Tech Reducer). Allow 5-10 min flash off time between coats and finish with a final mist coat if required. Wait 15-20 min for the base coat to appear matted before applying a clear coat.

2K

Germa-Tech 2k system, is supported by formulated colour options including RAL colours and Australian Standard Colours, a full tint system provides virtually unlimited colour customisation. Our 2k system provides tough durable protection, which can be further enhanced by a finished 2k clear coat over (optional).

Prepare the top coat by cleaning with Germa-Tech Prepsol, then wipe down with Germa-Tech Tack Rag. Mix 2K paint with matched Germa-Tech Hardener 2:1 and reduce with 10% Germa-Tech reducer. Spray 2 wet coats allowing 10-15 min flash off time between coats. Dry to handle time ~10-12 hours in normal weather conditions or 30min if baked. Refer relevant TDS for further details.

Blending process (2k colour or Clear)

2k - check existing paints in the spray gun mix and add 1 : 1 with Germa-Tech Blending Thinners SRA.

Spray 2-3 coats on blending areas with pressure 1.2-1.5 bar with a flash of 1 min between coats.

Final spray with 100% Germa-Tech Blending Thinners SRA. 1 - 2 coats with flash off 10 seconds.

Bake if blending 30-45min at 60 degrees or allow ~10-12 hours in normal weather conditions - 20 degrees.

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 stockist to discuss which clear coat best matches your needs.

Whilst the application of a clear coat over a 2k colour coating is not specifically required, the application of a clear coat will provide an additional layer of protection, particularly for submerged areas. Application details refer to relevant TDS.

Polishing:**Final Polishing includes**

Sanding 1500g to remove dust and sagging, taking care not to break through the final coating layer.

Degrease to check sand marks and swirl marks

Foam pad and g3 polisher to remove texture and sand marks and final clean.

Additional Information:

1. **IMPORTANT NOTICE** - if any sanding of final coatings is required to fix imperfections (ie sagging), exceptional care must be taken not to break-through the top coat. Sub layers may not be fully cured and any reapplication of top coat may result in adverse reactions, any reworking of product is not covered by warranties and should be referred to the manufacturer before commencing.
2. Do not apply plastic primer coatings in excess of advised thickness.
3. Allow all recommended flash off and cure times, in particular the full flash off times for plastic primer..

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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.

