



PLASTICS GUIDE



PLASTICS FLEXIBLE PARTS

PRODUCT

SURFACE PREPARATION

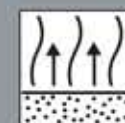
PLASTIC SEMI FLEXIBLE

PRODUCT

SURFACE PREPARATION



	Bake Substrate
1-951 Silicone Remover	Clean substrate
Grey Scotch Brite	Scuff surface with grey scotch brite in combination with anti-static degreaser 1-851 or plastic prep
1-851 Anti Static Degreaser	Clean substrate with anti static degreaser
1-60 Plastic Primer	Apply 1-2 coats 1-60 Plastic Primer
	10 minute flash off then recoat with
2000 Series BeroMix	Apply 2-3 coats
	Bake 30 minutes
500 Series BeroBase	Apply 2-3 coats to achieve colour Note: Use ground colour if recommended IN ICRIS
1-204 MS Clear coat Add 2K elastic 47-39 if necessary	Apply 2 coats
	Bake 30 minutes
8-104 HS Clear coat Add 2K elastic 47-39 if necessary	1 coat application: apply one tack coat followed by a finishing closed coat 2 coat application add thinner and apply two closed coats 5-10 min flash between coats
	Bake 30 -40 minutes



	Clean surfaces of all dirt. Wash with warm soapy water or cleaner. Rinse with water.
1-851 Anti Static Degreaser	Clean with Anti Static degreaser
Scotch Brite Grey	Key substrate with scotch brite grey
1-851 Anti Static Degreaser	Re-clean substrate
1-60 Plastic Primer	Apply 1-2 coats 1K plastic primer
	5 minute flash off or until matt
2000 Series BeroMix	Apply 2-3 coats
	Bake 30 minutes
500 Series BeroBase	Apply 2-3 coats to achieve colour Note: Use recommended ground colour if recommended in ICRIS
1-204 MS Clear coat Add 2K elastic 47-39 if necessary	Apply 2 coats
	Bake 30 minutes
8-104 HS Clear coat Add 2K Elastic 47-39 if necessary	1 coat application: apply 1 tack coat followed by a finishing closed coat. 2 coat application: add thinner and apply two closed coats 5-10 min flash between coats
	Bake 30-40 minutes

• Add 2-25% 2K elastic to 2K products on a flexible or semi rigid substrate.
• Mix 2K elastic 47-39 into topcoat prior to adding hardener.
Use this system on the following plastics. ABS acrylonitrile, butadiene styrene, PC polycarbonate, PA polyamide, EPDM ethylene propylene dien mixed polymer, PUR

• Add 5-25% 2K elastic to 2K products on a flexible or semi rigid substrate.
• Mix 2K elastic 47-39 into 2K topcoat prior to adding hardener.