

# PLASTIC REPAIR



01

## PREPARATION

- Inspect small plastic repair damage.
- Degrease and clean repair area & adjacent area.
- Cleaning:
  - Air blow.

02

## COLOUR CHECK

- Option 1: Use the Valspar Spectrophotometer.
- Option 2: Check for identification plate colour code.
- Refer to Valspar Color Box.
- Check for the best match.
- Mix the formulation in the required quality and quantity.
- Make spray out for colour match.

03

## SAND & ROUGH MASK

- Sanding with limited step increments e.g. P120-P240-P320.
- Area where blending, sand with P1000 - P2000 Trizact or equivalent.
- Clean and degrease.
- Rough masking application.
- Clean and degrease once more.
- Cleaning:
  - Air blow and tack rag.

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## FINAL MASKING

- For small repairs, mask directly for basecoat application.
- Place masking paper over the top of this for priming.
- Degrease:
  - Anti static degreaser
  - Airblow and tack rag.

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## PLASTIC PRIMER

- Apply 1 coat of plastic primer on the repair area.
- Flash off.

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## SURFACER APPLICATION

- Apply 1-3\* coats of surfacer allowing for flash off in between.
- \*Depending on final sanding & filling requirements.
- If repairing a flexible plastic part, you will be required to add the elastic additive when mixing to give the primer filler more flexibility over a plastic part, this can be added from 5-30% depending on how flexible the part is, consult TDS for more detailed information.
- Drying:
  - Infra Red or
  - Force drying at 60°C/140°F.

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## FINAL SAND & CLEAN

- Sand carefully using P400 or P500 for final sand.
- Final degreasing, cleaning and tack rag before basecoat application.
- Cleaning:
  - Air blow and tack rag.

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## BASECOAT APPLICATION

- Apply 1-2 coats, or until dropcoat is covered.
- Spray at lower pressure and overlap each coat.
- Flash off as required.

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## CLEAR COAT APPLICATION

- If repairing a flexible plastic part, you will be required to add the elastic additive when mixing to give the clearcoat more flexibility and stone chip resistance over a plastic part, this can be added from 5-30% depending on how flexible the part is, consult TDS for more detailed information.
- Apply 2 overlapping coats with flash off.

## FADE-OUT CLEAR COAT

- Over reduce the clear with 100% spot repair thinner and extend the area. Once more over reducing can be done for very smooth repairs (no orange peel).
- Or use the aerosol DeBeer Refinish 1-231 Fade-Out Thinner.

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## DRYING

- Infra Red drying has the preference as that is the most economical and fastest way or
- Force drying at 60°C/140°F.
- **TIP** - Points to take care of when using Infra Red: distance, half or full bake cycle, time & temperature (max 70°C/158°F). Keep enough distance between plastic parts and Infra Red to prevent deformation (check instructions Infra Red).

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## POLISHING

- Before starting to polish - check for through hardening.
- If areas still soft, IR dry once more.
- Polish with a fine compound at low speed to avoid generating heat.
- Complete with a finishing polish.

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## FINISH

- Hand over vehicle to happy & satisfied customer.