

# PPG Car Repair Process for Plastics

## New Plastics

### Car Parts & Substrate

New car parts supplied in Primer

Bumper  
e.g. PP / TPO / PP-EPDM

Wheel trim  
e.g. PA / LEXAN

Wing mirror  
e.g. ABS / NORYL / PC-PBT

Spoiler  
e.g. PUR  
Glass Reinforced Substrates  
e.g. SMC

### Preparation

#### Clean & Scuff

Abrade gently with a grey weave pad and wipe with Waterborne Pre-Cleaner (Anti-Static Wipe will remove many OE plastic primers)

D8434  
Cleaner for Plastics

Clean and scuff.  
Wash off thoroughly with clean water and dry.

Mix: 1:1 Water



#### Anti-Static Wipe

D846  
Anti-Static Agent

Wipe on and wipe off.

Ready for use



### Undercoat

#### Primer Plastic Additive

D8740 Primer Plastic Additive

Replaces the thinner in DP4000 2K Primer



#### Plastic Adhesion Promoter

D820 or D8420  
Aerosol Adhesion Promoter for Plastics

Ready for use  
LEXAN does not require an adhesion promoter



#### Wet-on-Wet

D8501/5/7  
DP4000 2K Primer



Mix: 4 : 1 : 2  
Hardener: D8302  
Thinner: D8740



D8521/5/7  
DP5000 2K Primer

Can be applied with a roller  
Mix: 7:1:1.2  
Hardener: D8302  
Thinner: D8718 (Medium)  
D8719 (Slow)



### Topcoat

#### Colour

D60xx  
DELTRON® Progress UHS Direct Gloss



Mix: 2.5 : 1 : 0.7  
Hardener: D8302  
Thinner: D8714/8/9



T4xx  
ENVIROBASE® High Performance



Mix: 100 Parts Colour  
10 Parts T492  
5-10 Parts T494



#### Clearcoat

D8135  
Deltron UHS Rapid Clearcoat



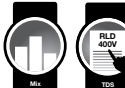
Mix: 3 : 1 : 0.6  
Hardeners: D8302  
Thinners: D8714/8/9



D8175  
Deltron Rapid Performance Clearcoat



Mix: 2:2:0.5  
Hardeners: D8305  
Thinner: D8745 (IR)  
D8746 (IR)



Thorough preparation and cleaning are essential for the successful refinishing of plastic parts. The PPG plastic cleaning and preparation system is designed to produce the best performance from the primer and topcoat systems. Refer to the DELTRON® Cleaning and Preparation of Plastic Substrates TDS (RLD241V).

## Repair Plastics

### Car Parts & Substrate

All car parts except 1K PUR  
e.g. PP / TPO / PP-EPDM / ABS / NORYL / PC-PBT / SMC / LEXAN / PA

### Preparation

#### Clean & Scuff

D8434  
Cleaner for Plastics

Clean and scuff.  
Wash off thoroughly with clean water and dry.

Mix: 1:1 Water



#### Anti-Static Wipe

D846  
Anti-Static Wipe

Anti-Static Agent.  
Wipe on and wipe off.

Ready for use



### Undercoat

#### Plastic Adhesion Promoter

D820 or D8420  
Aerosol Adhesion Promoter for Plastics

Ready for use



#### Primer Surfacer

Optional Phase  
Apply a Highbuild Primer Surfacer and flexibilise if required

D8531/5/7  
Deltron DP6000 2K Rapid Primer

Mix: 7:1:2  
Hardener: D8302  
Thinner: D8725 (Air Dry)  
Thinner: D8719 (IR)



### Topcoat

#### Colour

T4xx ENVIROBASE® High Performance

Mix: 100 Parts Colour  
10 Parts T492  
5-10 Parts T494



D60xx DELTRON® UHS Direct Gloss

Mix: 2.5 : 1 : 0.7  
Hardener: D8302  
Thinner: D8714/8/9



#### Clearcoat

D8135 Deltron UHS Clearcoat

Mix: 3 : 1 : 0.6  
Hardeners: D8302  
Thinners: D8714/8/9



D8175 Deltron Rapid Performance Clearcoat

Mix: 2:2:0.5  
Hardener: D8305  
Thinner: D8745 (IR)  
D8746 (IR)

