

# Painting of plastic parts

ONYX HD and clears

A 1.6.4



## Process description

Pretreat the surface to be painted following the instructions of PREP'ART A 1.5 – A 1.6.

**Attention:** never use FLEX in ONYX HD basecoats.

Please also observe the instructions given in the Technical Data Sheets of the products used.

## Substrates

- 1) and 2) for high-gloss, gloss-reduced and textured finishes applied to rigid plastics
- 3) high-gloss finish for PU foam






## Products required

- STARLUX CP
- SUPREMELUX CP
- CHRONOLUX CP
- CRYSTALCLEAR CP
- DIAMONTCLEAR CP
- DIAMONTOP CP
- FLEX

### 1) Rigid plastics

Do not add FLEX to the clear when applying a clear-over-base system with ONYX HD to rigid plastics.

### 2) Gloss-reduced and/or textured finish for rigid plastics

			Mat and/or textured	Gloss-reduced and/or textured
	Mixing ratio	STARLUX CP	150 (vol.)	200 (vol.)
		SPECIAL MAT 09 / MT 900	150 (vol.)*	100 (vol.)*
		H 420	100 (vol.)	100 (vol.)
		SC 820	100 (vol.)	100 (vol.)
	Mixing ratio	CHRONOLUX CP	150 (vol.)	200 (vol.)
		SPECIAL MAT 09 / MT 900	150 (vol.)*	100 (vol.)*
		H 420	100 (vol.)	100 (vol.)
		SC 820	100 (vol.)	100 (vol.)
	Mixing ratio	CRYSTALCLEAR CP	150 (vol.)	200 (vol.)
		SPECIAL MAT 09 / MT 900	150 (vol.)*	100 (vol.)*
		H 420	100 (vol.)	100 (vol.)
		SC 820	100 (vol.)	100 (vol.)
	Mixing ratio	DIAMONTCLEAR CP	150 (vol.)	200 (vol.)
		SPECIAL MAT 09 / MT 900	150 (vol.)*	100 (vol.)*
		H 420	100 (vol.)	100 (vol.)
		SC 820	100 (vol.)	100 (vol.)
	Mixing ratio	DIAMONTOP CP	200 (vol.)	270 (vol.)
		SPECIAL MAT 09 / MT 900	150 (vol.)*	100 (vol.)*
		H 420	100 (vol.)	100 (vol.)
		SC 820	50 (vol.)	30 (vol.)

- or as specified in the mixing formula


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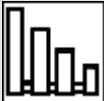
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## 3) PU foam


	Mixing ratio	STARLUX CP	300 (vol.)
		FLEX	60 (vol.)
		H 420	120 (vol.)
		SC 820	100 (vol.)

	Mixing ratio	SUPREMELUX CP	300 (vol.)
		FLEX	60 (vol.)
		H 420	120 (vol.)
		SC 850	100 (vol.)

	Mixing ratio	CHRONOLUX CP	300 (vol.)
		FLEX	60 (vol.)
		H 420	120 (vol.)
		SC 820	100 (vol.)

	Mixing ratio	CRYSTALCLEAR CP	300 (vol.)
		FLEX	60 (vol.)
		H 420	120 (vol.)
		SC 850	100 (vol.)

	Mixing ratio	DIAMONTCLEAR CP	300 (vol.)
		FLEX	60 (vol.)
		H 420	120 (vol.)
		SC 820	100 (vol.)

	Mixing ratio	DIAMONTOP CP	400 (vol.)
		FLEX	60 (vol.)
		H 420	120 (vol.)

Please refer to the EU Material Safety Data Sheet for product labelling as required by Directive 1999/45/EC and the respective national rules. The products are suitable for professional use only.

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