

## Painting of plastic parts

### ONYX HD and clears

#### A 1.6.4

#### Process description

Pre-treat 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

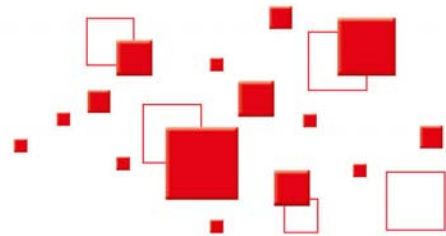
Do not add FLEX to the clear when applying a clear-over-base system with ONYX HD to rigid plastics.

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

		Mat and / or textured	Gloss-reduced and / or textured
	STARLUX CP SPECIAL MAT 09 / MT 900 H 420 SC 820	150% by vol. 150% by vol.* 100% by vol. 100% by vol.	200% by vol. 100% by vol.* 100% by vol. 100% by vol.
	CHRONOLUX CP SPECIAL MAT 09 / MT 900 H 420 SC 820	150% by vol. 150% by vol.* 100% by vol. 100% by vol.	200% by vol. 100% by vol.* 100% by vol. 100% by vol.

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




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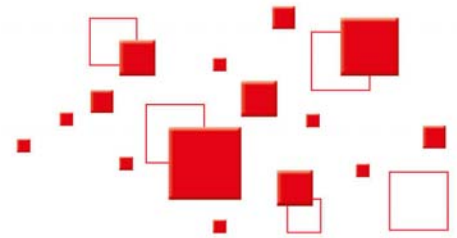
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### 2. Gloss-reduced and / or textured finish for rigid plastics

		Mat and / or textured	Gloss-reduced and / or textured
	CRYSTALCLEAR CP SPECIAL MAT 09 / MT 900 H 420 SC 820	150% by vol. 150% by vol.* 100% by vol. 100% by vol.	200% by vol. 100% by vol.* 100% by vol. 100% by vol.
	DIAMONTCLEAR CP SPECIAL MAT 09 / MT 900 H 420 SC 820	150% by vol. 150% by vol.* 100% by vol. 100% by vol.	200% by vol. 100% by vol.* 100% by vol. 100% by vol.
	DIAMONTOP CP SPECIAL MAT 09 / MT 900 H 420 SC 820	200% by vol. 150% by vol.* 100% by vol. 50% by vol.	270% by vol. 100% by vol.* 100% by vol. 30% by vol.

\* or as specified in the mixing formula









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#### 3. PU foam

	STARLUX CP FLEX H 420 SC 820	300% by vol. 60% by vol. 120% by vol. 100% by vol.
	SUPREMELUX CP FLEX H 420 SC 850	300% by vol. 60% by vol. 120% by vol. 100% by vol.
	CHRONOLUX CP FLEX H 420 SC 820	300% by vol. 60% by vol. 120% by vol. 100% by vol.
	CRYSTALCLEAR CP FLEX H 420 SC 850	300% by vol. 60% by vol. 120% by vol. 100% by vol.
	DIAMONTCLEAR CP FLEX H 420 SC 820	300% by vol. 60% by vol. 120% by vol. 100% by vol.
	DIAMONTOP CP FLEX H 420	400% by vol. 60% by vol. 120% by vol.

#### Safety instructions

It cannot be ruled out that these products contain particles < 0.1 µm.

The products are suitable for professional use only.

For the use of these products please adhere to the actual safety recommendations and the personal protective equipment.