


Glasureit® Repair of Thermoplastic Acrylic Factory Finishes

General information:

Thermoplastic acrylic (TPA) finishes are very solvent-sensitive factory finishes which will deform when exposed to warmth. In order to check the solvent resistance of the factory finish, take a cloth soaked with acrylic thinner (such as 352-50) and wipe the repair area. Damit wird das Anlöseverhalten der Werkslackierung getestet. If the finish swells, becomes sticky or softens, it should be treated like a TPA finish which must not be recoated with polyester, wash primer or synthetic resin products.






Pre-treatment:

Old paintwork	Do a solvent resistance test on a sand-through	Glasureit® 352-50 Reducer	 1x	Finish swells, becomes sticky, softens?	no = solvent-resistant	yes = solvent-sensitive

solvent-resistant

Refer to standard processes







solvent-sensitive

Glasureit® 541-5 Wax and Silicone Remover	 1X	 Wipe dry	Remove all rust from damaged areas / scuff sand old paintwork with P240/320	 P80-P150 or blasting	Glasureit® 541-5 Wax and Silicone Remover	 1X	 Wipe dry
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If the finish is dissolved by Glasureit® 541-5 Wax and Silicone Remover, use Glasureit® 700-1 Degreasing and Cleansing Agent.

No use of IR drying in the whole process, since the TPA finish would deform!

Body filling work and undercoat materials:

Body filler (coarse & fine) Use only on bare metal!	Glasureit® Multi Purpose Body Filler 839-20/20K	Glasureit® Hardener Paste, red 948-36	 + 2-3%	 20-30 min. at 20°C	 P80/P150 coarse sanding	Glasureit® 581-40 Guide Coat	 P240/P320 fine sanding	 541-5 1X	 Wipe dry

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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Primer Use only on bare metal!	Glasurit® 283-150 VOC Etch Primer Filler	Glasurit® 352-228 Activator	Glasurit® 352- Reducer	 1:1+30% mixing stick	 HVLP 1.9 mm 2.0-3.5 bar	 1 thin coat 10-15µm	 10 min. at 20°C	
	Glasurit® 285-100 VOC Rapid Filler, white	Glasurit® 929-51, -53 HS Filler Hardener, normal	Glasurit® 352 Reducer	 4:1:1 mixing stick	 HVLP 1.9 mm 2.0-3.5 bar	 3 or 4 thin coats	 Flash off until mat after each spraycoat.	 30 min. at 60°C

or alternatively: Glasurit® 76-71 Primer Filler or Glasurit® 285-95 HS Tintable Filler VOC

Topcoating:

Basecoat/ clearcoat system:

Basecoat	Glasurit® 90 Line Basecoat	Glasurit® 93-E3 Adjusting Base	 2:1 mixing stick	 HVLP 1.3 mm 2.0-3.5 bar	 2 + ½	 approx. 10 min.
	Glasurit® 923-335 HS Multi Clear	Glasurit® 929-31 / -33 Hardener VOC 3.5	Glasurit® 352- Reducer	 2:1+10% mixing stick	 HVLP 1.3 mm 2.0-3.5 bar	 2

Direct-gloss topcoat

Topcoat	Glasurit® 22 Line HS 2K Topcoat VOC 3.5	Glasurit® 929-31 / -33 Hardener VOC 3.5	Glasurit® 352- Reducer	 2:1+10% mixing stick	 HVLP 1.3 mm 2.0-3.5 bar	 2	 30 min. at 60°C
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