

### Starting Formulation for 3-Coats Plastic Parts

*Formulation No: C2 - 18, C2 - 19 and C2 – 20, Status Code C*

#### (a) Introduction

Starting formulation for base coat, dyed coat and PU clear coat for use in application such as motorbike ABS plastic parts

#### (b) Formulation

Ingredients	w/w	
<i>Base Coat</i>		
30% Elvacite® 2614	20.0	( 30% 2614 & 70% Xylene)
Cellulose acetyl butyrate 381-2	12.0	(20% solid content)
Organic anti-settling agent	1.0	
Aluminium powder	1.5	
Butyl acetate	3.0	
BYK-358*	0.2	
<i>Dyed Coat</i>		
30% Elvacite® 2614	40.0	(30% 2614 + 70% xylene)
Chlorinated wax #42	0.6	
BYK-358*	0.1	
BASF Dye	2.0	
30% LTH*	4.0	(30% LTH + 70% xylene)
<i>PU Clear Coat</i>		
Bayer 2180*	75.6	(hydroxyl acrylic resin)
BYK-077	0.2	
BYK-306	0.2	
Bayer N-75*	24.0	(HDI)
30% LTH*	7.5	(30% LTH + 70% xylene)

Note: Above are starting formulations. They are not optimised, hence they are not converted to 100%.

\* BYK-358 is a trade name of BYK Chemie

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\* LTH is a trade name of Creanova, LTH is an adhesion enhancing resin

\* Bayer 2180 and Bayer N-75 are products of Bayer AG

### (c) Recommended Processing Procedure

#### (1) Base Coat

- (i) Mix all ingredients except the aluminium powder. Blend well.
- (ii) Add in aluminium powder paste. Mix well.

#### (2) Dyed Coat

- (i) Mix all ingredients and blend well.

#### (3) PU Clear Coat

- (i) Mix all ingredients and blend well.

### (d) Applications Guideline

- (i) Dilute with xylene to spray viscosity; 15-30 sec #4 Ford Cup.
- (i) Apply the base coat. Dry well (or bake at 45°C for 30 min) before applying the dyed coat.
- (ii) For application of the PU clear coat, air dry the dyed coat well (or bake at 45°C for 30 min) before application of this layer.

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