

# PRODUCT DATA SHEET

## FLEXPRO

(Adhesion promotor plastic)

Z

### Application

plastic painting



### Description:

- good adhesion to various plastics
- high efficiency

### Substrates:

- = very well suited
- = well suited
- = suited in some cases

Steel	
Galv. Steel	
Stainless steel	
Aluminium	
Anodized Aluminium	
GRP / SMC	
PP-EPDM	●●
RM CV-Primer	
RM CV-Primer-Filler / Filler	
Powder	
Coil-Coating	
Plywood	
Wood	
OEM Paint work	●
Old paint work	●

### Remarks:

Find addition information in the technical data sheet of GHD SURFACER WHITE  
The substrate should be clean, free of dust, rust, oil and grease

### Special remarks

- The products are suitable for professional use only.
- It cannot be ruled out that this product contains particles < 0.1 µm



Paint process

P 10

Spreading rate

≈ 408 m<sup>2</sup> / l / 1µm

Solid content

≈ 11 %

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R-M Automotive Refinish Paints, BASF Coatings S.A.S, F-60676 Clermont-de-l'Oise Cedex

Jan 2014

Perfection made simple



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## FLEXPRO

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### Pre-mix

mix FLEXPRO (70 parts) with GV200 (30 Parts)



### Mixing ratio

by volume



### Hardener



### Reducer



### Spray viscosity DIN 4 / 20°C

### Application



Compliant-garvity feed cup



HVLP-Spray gun



Suction cup



Airless/Airmix (ESTA)



Pressure pot/Dble membr. Pump

	bar	2,2 - 2,5	2,0	2,5	2	2,5
Atomization pressure	bar	2,2 - 2,5	2,0	2,5	2	2,5
Material pressure	bar	--	-	-	120-150	0,8-1,5
Nozzle size	mm	1,4-1,6	1,5-1,7	1,7	0,28-0,33	1,0-1,1
Voltage	kV	-	-	-	60 - 70	-
Elect. Resistance	Ω	-	-	-	600 - 800	-
Number of spraycoats		1-2	1-2	1-2	1	1-2
Flash off	min.	without	without	without	without	without
Filmbuild	µm	20-30 *				



### Drying



over-coatable



tack free



tapeable



ready to assamble



sandable

	20°C	Min. 60 min	Max. 72 h
Panel temperat.	20°C	60 min	72 h
Panel temperat.	60°C	30 min	

### Remarks



\*ABS, GRP, SMC: GHD SURFACER WHITE with H380 and GV 300/400 (100:50:10);

PA, PC, PP-EPDM, GHD SURFACER WHITE with H380 and FLEXPRO (100:50:10);

PP, PE: (adhesion can not be guaranteed) GHD SURFACER WHITE with H380 and FLEXPRO (100:50:10);

\*\*Higher dry film thickness possible (50-60 µm)

Attention: Due to different raw material supplier the quality of the different plastics can be differ from time to time. The adhesion should be check before painting.

See D-Part Tables Painting of Plastic and/or Painting Process P10 for further details

