DuPont Automotive Finishes

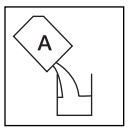
DuPont™ Plas-Stick® Plastic-Prep 2319S™

Description

Plas-Stick® Plastic-Prep 2319S™ is a ready-to-use unprimed plastic parts cleaner designed to remove mold release agents and other surface contaminants and eliminate static. Plas-Stick® Plastic-Prep 2319S™ is a critical step in the success of the plastic repair procedure. It is intended for use on unprimed ABS or Lexan (Polycarbonate) substrates. For all other Collision Market substrate applications, Plas-Stick® Plastic-Prep 2319S™ is being replaced by Plas-Stick® 2320S™ Plastics Cleaner. Refer to Plas-Stick® 2320S™ (and Plas-Stick® 2330S™) technical data sheets for the most current plastic repair recommendations.

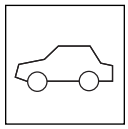
General Information

Components
Plas-Stick® Plastic-Prep 2319S™



Mix Ratio/Viscosity
Ready to use.

Application



Substrates
For use on ABS or Lexan (PolyCarbonate) substrates.

Flexible plastics that have been properly prepared. See “DuPont Flexible Plastics Repair Procedures Flow Chart” for schematic representation.

Types of Plastic Substrates and how to Paint them:

Type 1: Painting Raw Plastic Parts

Surface Preparation and Painting
All plastic substrates must be thoroughly cleaned and sanded as described below to ensure adequate cleaning (See Flexible Plastics Repair Flow Chart for process summary):

- **Step 1:** Clean surface with mild detergent and hot water.
- **Step 2**: Saturate the plastic with Plas-Stick® Plastic-Prep 2319S™ and continue to apply Plas-Stick® Plastic-Prep 2319S™ while rubbing wet surface with a clean cloth. After 4-5 min., the surface should have no gloss and it should not feel slick. If it does, reapply as described above and continue until gloss is reduced and the surface is not slick. **It is crucial to clean the surface as described to get good adhesion.**

- **Step 3:** Sand substrate thoroughly using the grit described:

DuPont™ Plas-Stick® Plastic-Prep 2319S™

Hand sanding: Use gray Scotchbrite (or 800 grit sandpaper). Do not use 320 grit or red Scotchbrite, it is too severe and will rip the plastic substrate surface.
DA sanding: Use 500 grit (Do not use 320 grit, it is too severe)

■ **Step 4:** Clean again with Plas-Stick® Plastic-Prep 2319S™ as described in Step 2. And repeat until substrate is squeaky clean. To minimize static build-up allow to flash dry after cleaning.

■ **Step 5**: Apply one medium coat of Plas-Stick® 2330S™ Plastics Adhesion Promoter** **immediately after cleaning with Plas-Stick® Plastic-Prep 2319S™ to guarantee adhesion.**
(For fiberglass, sand with 400 grit and go direct to sealer. It is not necessary to use Plas-Stick® 2330S™.)**

■ **Step 6.** Allow Plas-Stick® 2330S™ to dry 30-40 min before applying sealer (e.g., ChromaPremier® Sealer)

■ **Step 7. Apply activated basecoat.**

■ **Step 8.** Apply clearcoat with Plas-Stick® 2350S™Flexible Additive. **Note:** For ChromaClear® 4500S™, 4700S™, G2-4500S™, G2-4700S™, and 7900S™, and ChromaPremier 72200S™ 72400S™ and 72500S™ Clearcoats, simply add 2 oz Plas-Stick® 2350S™ per ready-to-spray quart of activated clearcoat.

Tips for Success
■ *To test the surface preparation, pour a cap of Plas-Stick® Plastic-Prep 2319S™ on the prepared area.* It *will sheet cleanly over a clean substrate. If Plas-Stick® Plastic-Prep 2319S™ beads up, the surface is not clean.*
■ *For difficult-to-clean and textured plastics, temper the substrate for 30 minutes at 140°F (60°C) after cleaning and sanding. This may be helpful in driving out further mold release agents. Do not sand after tempering. Reapply Plas-Stick® Plastic-Prep 2319S™ after tempering to remove mold release agent.*
■ *Use a clean cloth when applying Plas-Stick® Plastic-Prep 2319S™.*

Type 2: Painting Pre-Primed Plastic Parts (where **primer swells** when applying solvent.... remove it before you paint)
When Pre-Primed OEM parts are painted, lifting may occur when a poor quality primer is used or if the primer exhibits poor solvent resistance. Problems typically arise when basecoat is applied over sealer. That is, lifting occurs. To ensure that this does not occur, it is crucial to test the pre-primed part for solvent resistance. The best way to do that is to use Basemaker® as described below in **Steps 1 and 2**.

Surface Preparation and Painting
■ **Step 1**: Test Pre-Primed part for solvent resistance. Soak entire bumper with Basemaker® 7175S™ and let stand for 5 minutes*. After the solvent has flashed, wipe off primer from areas that lifted.
[*Caution: Be careful when using Basemaker® 7175S™. Avoid static buildup due to potential risk of flash fire].

■ **Step 2**: Repeat Step 1 to make sure all of the solvent sensitive primer has been removed.
■ **Step 3**: Go to **Type 1: Painting Raw Plastic Parts** (previous page) and follow steps 1 to 8 for the remainder of the repair.

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Type 3: Painting Pre-Primed Plastic Parts (If **primer is resistant to solvent**, sand primer and paint)

When Pre-Primed OEM parts are painted, lifting may occur when a poor quality primer is used or if the primer exhibits poor solvent resistance. Problems typically arise when basecoat is applied over sealer. That is, lifting occurs. To ensure that this does not occur, it is crucial to test the pre-primed part for solvent resistance. The best way to do that is to use Basemaker® as described below in Step 1. If no swelling or lifting occurs proceed to Step 2.

■ **Step 1**: Test Pre-Primed part for solvent resistance. Soak entire bumper with Basemaker® 7175S™ and let stand for 5 minutes. If the primer does not lift anywhere on the bumper, proceed to Step 2.

■ **Step 2**: Sand substrate with 400 or 500 grit sandpaper. Be careful not to sand through the primer.

■ **Step 3**: Clean with DuPont Final Klean 3901S™ or DuPont Low VOC Final Klean 3909S™ and let dry.

■ **Step 4**: Go to **Type 1: Painting Raw Plastic Parts** and follow steps 6 to 8 for the remainder of the repair.

■ Aside: If cut-throughs occur, complete the surface prep procedure and use Plas-Stick® 2330S™ (over the cut-through only) to promote good adhesion.

Note: Tempering is not beneficial for urethane parts (PUR) due to "post cure" temperatures in excess of 140°F.

Caution: Do not use solvent-based cleaners on unprimed plastic or fiberglass (i.e., DuPont First Klean 3900S™, DuPont Final Klean 3901S™, Prep-Sol® 3919S™, DuPont 3939S™ Lacquer & Enamel Cleaner) due to static buildup and the potential for flash fire.

Physical Properties

VOC: 5.5 lbs/gal ready to use (6.6 lbs/gal less water and exempt solvents).
Flash Point: See MSDS.

VOC Regulated Areas

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing and usage recommendations in the VOC Compliant Products Chart for your area.

Safety and Handling

Before using any DuPont Refinish product, be sure to read all safety directions and warnings. WEAR A PROPERLY FITTED AIR PURIFYING RESPIRATOR with organic vapor cartridges (NIOSH approved TC-23C) and particulate filter (NIOSH TC-84A), eye protection, gloves and protective clothing during application and until all vapors and spray mists are exhausted. In confined spaces, or in situations where continuous spray operations are typical, or if proper air purifying respirator fit is not possible, wear a positive-pressure, supplied air respirator (NIOSH TC-19). In all cases follow respirator manufacturer's directions for respirator use. Do not permit anyone without protection in the painting area. This product is intended for industrial use only by professional, trained painters.