



DuPont Automotive Finishes

DuPont™ Plas-Stick® 2330S™ Plastics Adhesion Promoter

Description

Plas-Stick® 2330S™ is a green-gray pigmented adhesion promoter for polyolefin or non-polyolefin unprimed automotive plastics. When combined with proper surface preparation, this product enhances the performance of ChromaSystem™ products on unprimed polyolefin or non-polyolefin plastic parts. It is recommended to prime or seal Plas-Stick® 2330S™ prior to topcoating for optimum flexibility.

To enhance adhesion of coatings to an unprimed plastic part, Plas-Stick® 2330S™ should be used in place of Plas-Stick® 2322S™ Adhesion Promoter for Plastics.

General Information

Components

Plas-Stick® 2330S™ Plastics Adhesion Promoter

Mix Ratio/Viscosity

Ready-to-spray.

Pot Life

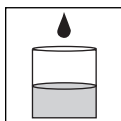
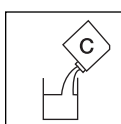
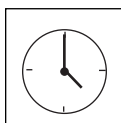
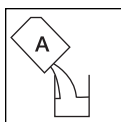
Indefinite.

Additives

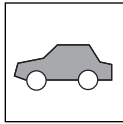
Accelerator:	Not recommended.
Fish Eye Eliminator:	Not recommended.
Flex Additive:	Not recommended.
Reducer:	Not recommended.
Retarder:	Not recommended.

Tinting

Not recommended.



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Primer/Sealer

Plas-Stick® 2340S™ Flexible Adhesion Sealer

DuPont 1141S™/1144S™/1147S™ 2K Urethane Primer-Filler (for rigid plastics)

DuPont 2K 1141S™/1144S™/1147S™ Urethane Primer-Filler with Plas-Stick® 2350S™ Flexible Additive

ChromaPremier® 42410S™/42440S™/42470S™ Sealer (for rigid plastics)

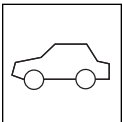
ChromaPremier® 42410S™/42440S™/42470S™ Sealer with Plas-Stick® 2350S™

Prime 'N Seal® 2710S™/2740S™/2770S™ (for rigid plastics only)

DuPont 4001S™/4004S™/4007S™ 2K UltraProductive Primer-Filler with Plas-Stick® 4150S™

DuPont 4001S™/4004S™/4007S™ 2K UltraProductive Primer-Filler with Plas-Stick® 4950S™

DuPont 4904S™ 2K UltraProductive Primer-Filler with Plas-Stick® 4950S™



Topcoats

It is recommended to apply one of the above Primers/Sealers over Plas-Stick® 2330S™ before applying one of the following topcoats:

ChromaPremier® Basecoat

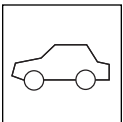
ChromaPremier® single stage

ChromaBase®

ChromaOne®

DuPont Vinyl Color

Application



Substrates

Unprimed rigid, semi-flexible or flexible automotive plastic parts.

Note: Since it is difficult for paint to adhere to polyethylene and polypropylene, clean and sand thoroughly before applying Plas-Stick® 2330S™.

Note: For specific substrate information, refer to the Automotive Plastics Refinishing Guide. **Do not use** Plas-Stick® 2330S™ over fiberglass, silicone rubber, polyurethane foams or primed plastics.



Surface Preparation

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® 2320S™ Plastics Cleaner* and continue to apply Plas-Stick® 2320S™ 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 Plas-Stick® 2320S™ as described above and

■ Clean surface with mild detergent and hot water.

■ Saturate the substrate with Plas-Stick® 2320S™ (Plas-Stick® Plastic-Prep 2319S™ for ABS or Lexan) and while keeping it wet, wipe with clean cloth until all surface gloss is removed. If surface still feels slick, repeat the procedure until it is not. continue until gloss is reduced and the surface is not slick. **It is crucial to clean the surface as described to get good adhesion.**

[*Plas-Stick® 2320S™ should not be used to clean ABS or Lexan (polycarbonate) because it will partially dissolve the substrate. Use Plas-Stick® 2319S™ instead]

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

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® 2320S™ as described in Step 2. And repeat until substrate is squeaky clean. To minimize static build-up allow Plas-Stick® 2320S™ to flash dry after cleaning.

- **Step 5:** Apply one medium coat of Plas-Stick® 2330S™** **immediately after cleaning with Plas-Stick® 2320S™ to guarantee adhesion.**

(** For fiberglass, sand with 400 grit and go direct to sealer. It is not necessary to use 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

- *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® 2320S™ after tempering to remove mold release agent.*

- *Use a clean cloth when applying Plas-Stick® 2320S™.*

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.

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.

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■ **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.

■ **Do not wipe with dry cloth because it will generate static.**



Gun Setups*

Conventional

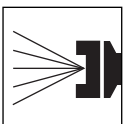
Siphon Feed: 1.4 mm - 1.6 mm (.055" - .063")

Gravity Feed: 1.3 mm - 1.5 mm (.051" - .059")

HVLP

Siphon Feed: 1.4 mm - 1.6 mm (.055" - .063")

Gravity Feed: 1.3 mm - 1.4 mm (.051" - .055")



Air Pressure

Conventional

Siphon Feed: 35 - 40 psi @ the gun.

Gravity Feed: 30 - 35 psi @ the gun.

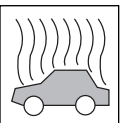
HVLP

6 - 8 psi @ the gun cap.



Application

Apply 1 medium coat beyond the entire repair area. (This will typically not lead to complete hiding. It is not necessary to have complete hiding.) After the recommended dry time, Plas-Stick® 2330S™ will still be tacky. Follow with the appropriate primer or topcoat.



Flash/Dry Times

Air Dry for Plas-Stick® 2330S™

Time to prime/seal/topcoat: 25 minutes

Force Dry for Plas-Stick® 2330S™

Bake at 140°F for 15 min.

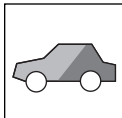
Note: Plas-Stick® 2330S™ must be primed, sealed or topcoated within 48 hours to minimize the potential for contamination and to ensure proper adhesion.

Air Dry for Sealer (e.g., ChromaPremier® 42440S™) over Plas-Stick® 2330S™

Time to base coat: 30-40 minutes

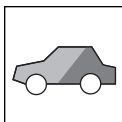
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If the sealer is not allowed to dry long enough, application of the basecoat will cause the coating to wrinkle or lift. For optimum adhesion of Plas-Stick® 2330S™ to raw plastic substrate, force dry (e.g. 140°F x 30 minutes) after applying single stage or clearcoat.



Blending

Plas-Stick® 2330S™ may be used for spot repairs.



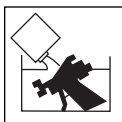
Recoatability/Re-repair

Plas-Stick® 2330S™ may be re-coated at any stage of dry or cure. Avoid multiple coats and excessive film build.



Sanding

Plas-Stick® 2330S™ does not require sanding. If sanding is necessary to remove dirt or imperfections, reapply Plas-Stick® 2330S™. Avoid excessive film build.



Cleanup

Clean spray equipment as soon as possible with DuPont Lacquer Thinner.

Physical Properties

VOC: 5.9 lbs/gal ready-to-spray.

Theoretical Coverage: 280 sq. ft. per ready-to-spray gallon at 1 mil.

Weight Solids: 25.94% ready-to-spray.

Volume Solids: 18.13% ready-to-spray.

Flash Point: See MSDS.

Recommended dry film thickness: 0.35 to 0.50 mils. in 1 coat.

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.

