



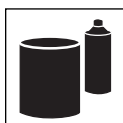
DuPont Automotive Finishes

DuPont™ Plas-Stick® 2340S™ Flexible Adhesion Sealer

Description

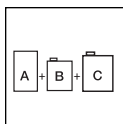
Plas-Stick® 2340S™ Flexible Adhesion Sealer is part of a system of products designed to improve adhesion, chip resistance and flexibility of ChromaSystem™ products over semi-flexible and fully-flexible plastics, and also over metal parts due to its ability to absorb impact.

General Information



Components

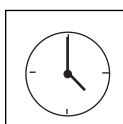
Plas-Stick® 2340S™ Flexible Adhesion Sealer
 ChromaPremier® 1230XS™ Activator (x=3 OR 5)
 ChromaPremier® 12365S™ Fast Reducer



Mix Ratio

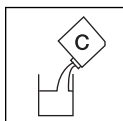
Combine the components either by volume or weight and then mix thoroughly.

	Volume	Weight (cumulative pint)
Plas-Stick® 2340S™ Flexible Adhesion Sealer	4	368.6
ChromaPremier® 1230XS™ Activator	1	451.4
ChromaPremier® 12365S™ Reducer	1	519.1



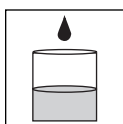
Pot Life

One hour.



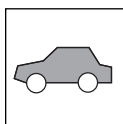
Additives

Accelerator: MasterTint® 389S™ Accelerator; use 1 ounce per ready-to-spray quart.
 Flex-Additive: Not required.



Tinting

Not recommended.

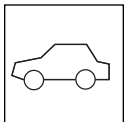


Topcoats

ChromaPremier® Basecoat
 ChromaPremier® single stage
 ChromaBase® Activated Basecoat
 ChromaOne® single stage
 DuPont Vinyl Color

DuPont™ Plas-Stick® 2340S™ Flexible Adhesion Sealer

Application



Substrates (*Flexible Fascia Substrates or metal parts*)

Pre-primed

Plas-Stick® 2340S™ may be applied directly to properly prepared pre-primed plastics.

Unprimed Polyolefin or Non-Polyolefin Plastics

Do not apply Plas-Stick® 2340S™ direct to unprimed or raw polyolefin plastics. Plas-Stick® 2330S™ Plastic Adhesion Promoter must be applied prior to the application of Plas-Stick® 2340S™.

Metal Substrates

Apply 2 coats of Variprime® to a metal part and allow for adequate dry time before applying Plas-Stick® 2340S™.



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 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® Plastic-Prep 2319S™ instead.]

■ **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 Plas-Stick® 2330S™.)

■ **Step 6.** Allow Plas-Stick® 2330S™ to dry 30-40 min before applying 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.

DuPont™ Plas-Stick® 2340S™ Flexible Adhesion Sealer

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.

- **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.
- **CAUTION:** Plas-Stick® 2320S™ may remove primer from pre-primed plastic part.
- **Aside:** If cut-throughs occur, complete the surface prep procedure and use 2330S™ (over the cut-through only) to promote good adhesion.

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.

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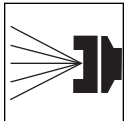
Gun Setups*

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 - 1.5 mm (.051" - .059")



Air Pressure*

Conventional

Siphon Feed: 35 - 40 psi @ the gun.
Gravity Feed: 30 - 35 psi @ the gun.

HVLP

Siphon Feed: 6 - 8 psi @ the gun cap.
Gravity Feed: 6 - 8 psi @ the gun cap.

*The listed setups cover the usual range for various application equipment. For information on specific manufacturers' equipment, see the Appendix section titled "Equipment Information."



Application

As a flexible adhesion sealer:

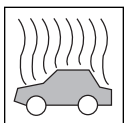
Apply one medium coat and allow proper dry time.

As a leading-edge chip-resistant primer:

Apply two medium coats with a 5-minute flash between coats and allow proper dry time.

Tips for Success

For maximum performance, Plas-Stick® 2340S™ should be used as part of a system, with an activated basecoat and a fully-flexibilized clear or a fully-flexibilized single stage.



Flash/Dry Times

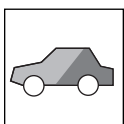
Force Dry

- Plas-Stick® 2340S™ should be force dried for 30 minutes at 140°F prior to topcoating to ensure topcoat holdout and to avoid recoat lifting.

Air Dry

- Plas-Stick® 2340S™ must air dry for two hours prior to topcoating to ensure topcoat holdout and to avoid recoat lifting.
- MasterTint® 389S™ Accelerator may be added (1 oz. per ready-to-spray quart) to reduce air dry time to 30 - 45 minutes.

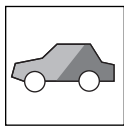
Note: Improper cleaning and surface preparation will result in poor adhesion, and will result in lifting when topcoated.



Blending

Plas-Stick® 2340S™ may be used as a leading-edge, chip resistant sealer by using proper gun technique.

DuPont™ Plas-Stick® 2340S™ Flexible Adhesion Sealer



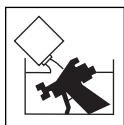
Recoatability/Re-repair

- Plas-Stick® 2340S™ has a recoat lift window between 45 - 90 minutes. All air dry applications require two hours air dry to avoid recoat lifting and to ensure good topcoat holdout.
- Plas-Stick® 2340S™ should be scuff sanded if allowed to dry more than 8 hours.



Sanding

- Plas-Stick® 2340S™ may be nib sanded after 2 hours air dry or after 30 minutes force dry at 140°F.
- The use of MasterTint® 389S™ can reduce the time to nib sand to 30 - 40 minutes air dry.
- Plas-Stick® 2340S™ must be scuff sanded if not topcoated within 8 hours.



Cleanup

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

Physical Properties

VOC: 4.6 lbs/gal ready-to-spray.

Theoretical Coverage: 620.74 sq. ft. per ready-to-spray gallon at 1 mil.

Weight Solids: 51.1% ready-to-spray.

Volume Solids: 38.7% ready-to-spray.

Recommended Dry Film Thickness:

- Flexible Adhesion Sealer: 0.4 - 0.8 mils in 1 coat.
- Leading Edge/Chip Resistant Primer: 1.0 - 1.5 mils in 2 coats.

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

WEAR A POSITIVE-PRESSURE, SUPPLIED-AIR RESPIRATOR (NIOSH APPROVED TC-19C), EYE PROTECTION, GLOVES AND PROTECTIVE CLOTHING WHILE MIXING ACTIVATOR WITH PAINT, DURING APPLICATION AND UNTIL ALL VAPORS AND SPRAY MIST ARE EXHAUSTED. Follow respirator manufacturer's directions for respirator use. INDIVIDUALS WITH HISTORY OF LUNG OR BREATHING PROBLEMS OR PRIOR REACTION TO ISOCYANATES SHOULD NOT USE OR BE EXPOSED TO VAPOR OR SPRAY MIST. Do not permit anyone without protection in the painting area.

