DuPont Automotive Finishes

DuPont™ Plas-Stick® 2350S™ Flexible Additive

Description

Plas-Stick® 2350S™ Flexible Additive is designed for use in selected ChromaSystem™ undercoat, single stage and clearcoat products. Plas-Stick® 2350S™ is part of a system of products designed to improve the adhesion, chip resistance and flexibility of ChromaSystem™ products over semi-flexible and fully-flexible plastics.

General Information

Components

Plas-Stick® 2350S™ Flexible Additive is for use with the following products:
DuPont™ URO® 1120S™/1140S™ Primer-Filler
DuPont 1141S™/1144S™/1147S™ 2K Urethane Primer-Filler
ChromaOne® Single Stage
ChromaClear® *HC*-2300S™, 4500S™, 4700S™, G2-4500S™, G2-4700S™, 7500S™, V-7500S™, 7900S™ and *HC*-7600S™ Clearcoats
ChromaPremier® 32430S™ Primer or 42410S™/42440S™/42470S™ Sealer
ChromaPremier® Single Stage
ChromaPremier® 72200S™, 72400S™ and 72500S™ Clearcoats

Undercoats	Volume	Weight (cum. pt.)
ChromaPremier® 32430S™	5	463.5
ChromaPremier® 12305S™	1	526.1
ChromaPremier® 12375S™	1	576.3
Plas-Stick® 2350S™	1	633.0
ChromaPremier® 42410S™	3	385.3
ChromaPremier® 12305S™	1	462.2
ChromaPremier® 42475S™	1.5	562.6
Plas-Stick® 2350S™	1	633.1
ChromaPremier® 42440S™	3	335.1
ChromaPremier® 12305S™	1	412.0
ChromaPremier® 42475S™	1.5	512.4
Plas-Stick® 2350S™	1	582.9
ChromaPremier® 42470S™	3	336.7
ChromaPremier® 12305S™	1	413.6
ChromaPremier® 42475S™	1.5	514.0
Plas-Stick® 2350S™	1	584.5
Uro® 1120S™	4	336.3
DuPont 1125S™	1	391.5
DuPont 1130S™/1135S™	2	490.4
Plas-Stick® 2350S™	1.5	572.7
Uro® 1140S™	4	343.3
DuPont 1125S™	1	397.4
DuPont 1130S™/1135S™	2	494.7
Plas-Stick® 2350S™	1.5	575.5
DuPont 1141S™/1144S™/1147S™	5	301.0
DuPont 1125S™	3	413.0
DuPont 1175S™	1.5	464.0
Plas-Stick® 2350S	1	502.0

Clearcoats	Volume	Weight (cum. pt.)
ChromaClear® V-7500S™**	9	306.0
ChromaClear® V-7575S™	3	417.2
Plas-Stick® 2350S™	1	452.5
ChromaClear® 7500S™**	9	310.3
ChromaClear® 7575S™	3	418.2
Plas-Stick® 2350S™	1	453.5
ChromaClear® 4500S™, 4700S™, G2-4500S™, or G2-4700S™*	9	225.0
ChromaClear® 4507S™	3	308.5
Plas-Stick® 2350S™	1	334.0
ChromaPremier® 12375S™	3	402.5
ChromaPremier® 7900S™*	2	
ChromaPremier® 7985S™	1	
Plas-Stick® 2350S™	.2	
ChromaPremier® 72200S™*	9	238.4
ChromaPremier® 12305S™	3	325.6
Plas-Stick® 2350S™	1	353.4
ChromaPremier® 12375S™	25-30%	451.3
ChromaPremier® 72400S™*	6	245.6
ChromaPremier® 12305S™	3	378.4
Plas-Stick® 2350S™	0.5	398.7
ChromaPremier® 12385S™	15-20%	465.5
ChromaPremier® 72500S™*	6	266.0
ChromaPremier® 12303S™	3	403.0
Plas-Stick® 2350S™	0.5	430.0
ChromaPremier® 12365S™	10%	464.0

*Mix by weight above OR add 2 oz Plas-Stick® 2350S™ per ready to spray quart of activated clearcoat.

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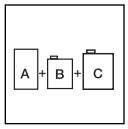
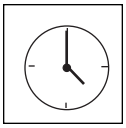
Topcoats
For ChromaPremier® single stage and ChromaOne® single stage topcoats, add 2 ounces of Plas-Stick® 2350S™ per ready-to-spray quart.

Tips For Success
ChromaClear® 7600S™ and V-7600S™ are not recommended for use on plastic parts.

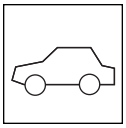


Mix Ratio
Combine the components either by volume or weight and then mix thoroughly.



Pot Life
30 - 60 minutes. Mix the appropriate amount of material for the job and clean equipment immediately after use.

Application



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® 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™ Plastics Adhesion Promoter** **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.**

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■ **Step 8.** Apply clearcoat with Plas-Stick® 2350S™ FLexible Additive. **Note:** For ChromaClear® 4500S™, 4700S™, G2-4500S™, G2-4700S™, 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 apply 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* Plas-Stick® *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*

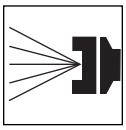
Conventional

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")

Note: The use of Plas-Stick® 2350S™ Flexible Additive will act to reduce the ready-to-spray viscosity of ChromaSystem™ products. In addition, the application of products containing Plas-Stick® 2350S™ are typically small in area of coverage and require low film builds for maximum performance. For these reasons, we recommend a more restricted gun setup compared to normal applications.



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/Dry Times

DuPont™ URO® Prime

Apply 2 - 3 light coats to achieve proper fill. Allow good flash time and avoid excessive film build. Force dry for 60 minutes at 140°F or air dry overnight before sanding.

ChromaPremier® Sealer

Apply one medium coat to achieve uniformity of the surface on pre-primed and OEM painted substrates. Allow 30 minutes flash time prior to topcoating.

single stage

Apply 2 - 3 coats, allowing good flash time between coats. Force dry for 30 - 60 minutes at 140°F or air dry overnight before handling.

Productive and Conventional Clearcoats

Apply two coats of the appropriate clearcoat, allowing good flash between coats and avoiding excessive film build.

For productive clearcoats (for example, ChromaClear® 4500S™/G2-4500S™ and 4700S™/G2-4700S™) process as follows:

ChromaClear® 4500S™/G2-4500S™- Force dry at 10 minutes (cycle time) X 160° F (booth temp.), then let stand for 1 hour. If Air drying, allow to stand for 4.5 - 6 hours.

ChromaClear® 4700S™/G2-4700S™ - Express dry at 10 minutes (cycle time) X 120°F* (booth temp.), then let stand for 1 hour. If Air drying, allow to stand for 2 - 2.5 hours.

* If ChromaClear® 4700S™ & G2-4700S™ are baked at higher temperatures than described above, dieback may occur.

For conventional clearcoats (for example, ChromaPremier® 72200S™, 72400S™ and 72500S™ or ChromaClear® V-7500S™ and 7500S™) process as follows:

Force dry for 30 to 45 minutes at 140° F or air dry overnight.

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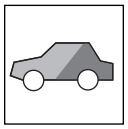
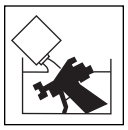


Recoatability/Re-repair
Allow overnight dry before performing re-repair operations.

Sanding
The use of Plas-Stick® 2350S™ in primer, single stage and clearcoat will slow dry and cure times. Allow additional dry time before sanding flexibilized primer surfacer, or sanding and polishing single stage and clearcoat finishes.



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

Physical Properties

VOC: 3.5 lbs/gal.
Weight Solids: 57.1%.
Volume Solids: 50.8%.
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.