

**Refinish**

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™ ChromaSurfacer™ 7704S™

DuPont™ ChromaSeal® 7710S™/7740S™/7770S™ 2K Urethane Primer-Filler

ChromaOne® Single Stage Basecoats

ChromaClear® HC-2300S™, G2-4500S™, G2-4700S™, 7779S™, and HC-7776S™ Clearcoats

ChromaPremier® 32430S™ Primer or 42410S™/42440S™/42470S™ Sealer

ChromaPremier® Single Stage Basecoats

ChromaPremier® 72200S™ and 72500S™ Clearcoats

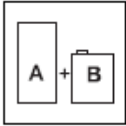
Topcoats

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



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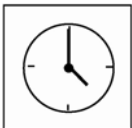
Mix Ratio

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

Undercoats	Volume	Weight (cum pt)	Clearcoats	Volume	Weight (cum pt)
ChromaPremier® 32430S™	5	463.5	ChromaClear® G2-4500S™ or G2-4700S™	9	254.5
ChromaPremier® 12305S™	1	526.1	ChromaClear® G2-4507S™	3	348.5
ChromaPremier® 12375S™	1	576.3	Plas-Stick® 2350S™	1	376.9
Plas-Stick® 2350S™	1	633.0	ChromaPremier® 12375S™	3	452.7
ChromaPremier® 42410S™	3	349.9	ChromaPremier® 72200S™	9	238.4
ChromaPremier® 12305S™	1	424.0	ChromaPremier® 12305S™	3	325.6
ChromaPremier® 42475S™	1.5	520.0	Plas-Stick® 2350S™	1	353.4
Plas-Stick® 2350S™	1	589.9	ChromaPremier® 12375S™	25-30%	451.3
ChromaPremier® 42440S™	3	335.1	ChromaPremier® 72500S™	6	266.0
ChromaPremier® 12305S™	1	412.0	ChromaPremier® 12303S™	3	403.0
ChromaPremier® 42475S™	1.5	512.4	Plas-Stick® 2350S™	0.5	430.0
Plas-Stick® 2350S™	1	582.9	ChromaPremier® 12365S™	10%	464.0
ChromaPremier® 42470S™	3	336.7	ChromaClear® 7779S™	4	327.0
ChromaPremier® 12305S™	1	413.6	ChromaBase® 7775S™	1	416.0
ChromaPremier® 42475S™	1.5	514.0	Plas-Stick® 2350S™	2 oz/pt	442.5
Plas-Stick® 2350S™	1	584.5	ChromaClear® HC-7776S™	4	322.5
ChromaSurfacer® 7704S™	4	453.0	ChromaBase® 7775S™	1	411.5
ChromaBase® 7775S™	1	534.0	Plas-Stick® 2350S™	2 oz/pt	438.0
Plas-Stick® 2350S™	2.5 oz/pt	596.0			
ChromaSeal® 7710S™	4	462.0	Topcoat	Volume	
ChromaBase® 7775S™	1	548.0	ChromaPremier® Single Stage	3	
Plas-Stick® 2350S™	1.5 oz/pt	587.0	ChromaPremier® 12305S™	1	
ChromaSeal® 7740S™	4	450.5	ChromaPremier® 12375S™	5% - 10%	
ChromaBase® 7775S™	1	537.0	Plas-Stick® 2350S™	2 oz/qt	
Plas-Stick® 2350S™	1.5 oz/pt	576.0	ChromaOne® Single Stage	3	
ChromaSeal® 7770S™	4	447.5	ChromaOne® 7005S™ Activator	1	
ChromaBase® 7775S™	1	534.0	ChromaOne® 7075S™ Reducer	1	
Plas-Stick® 2350S™	1.5 oz/pt	573.0	Plas-Stick® 2350S™	2 oz/qt	

Pot Life

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





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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

Option A: Use the following process for the plastics ABS, CAD, CN, EP, MF, PA, PC, PE, PDTP, PETB, PT, PMMA, POM, PP, PPO, PL, PVC, SAN, BBB, TPU, AND UP.

- **Step 1:** Pre-wash with warm water and DuPont™ 2310S™ Plastic Cleaning Paste using a gray or gold Scotchbrite™ pad.
- **Step 2:** Rinse thoroughly making sure the DuPont™ 2310S™ Plastic Cleaning Paste does not dry on the surface.
- **Step 3:** Wash again with warm water and DuPont™ 2310S™ Plastic Cleaning Paste using a gray or gold Scotchbrite™ pad.
- **Step 4:** Rinse thoroughly making sure the DuPont™ 2310S™ Plastic Cleaning Paste does not dry on the surface. Dry thoroughly following the rinse. Repeat steps 3 and 4 if necessary to obtain a surface that is squeaky clean without any greasy film.
- **Step 5:** Apply one medium coat of Plas-Stick® 2330S™ or 1 coat of A-2330S™ immediately after cleaning to help ensure adhesion.
- **Step 6:** Allow adhesion promoter to dry 25 minutes before applying flexed primer or flexed sealer.
- **Step 7:** Apply activated ChromaSystem™ basecoat.
- **Step 8:** Apply clearcoat with Plas-Stick® 2350S™ Flexible Additive.
Note: For ChromaClear® G2-4500S™, G2-4700S™, 7779S™, and HC-7776S™ and ChromaPremier® 72200S™, 72500S™, add 2 oz of Plas-Stick® 2350S™ per ready-to-spray quart of activated clearcoat.

Option B: Use the following procedure if you prefer using 2320S™ Plastic Cleaner in place of 2310S™ Plastic Cleaning Paste.

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 soap and hot water.
- **Step 2:** Saturate the plastic with Plas-Stick® 2320S™ Plastics Cleaner* or A-2320S™ and continue to apply cleaner 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 cleaner as described above.
- **It is crucial to clean the surface as described to get good adhesion.**

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

- **Step 3:** Sand substrate thoroughly using the grit described:
Hand sanding: Use gray or gold 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™ or A-2320S™ as described in Step 2 and repeat until substrate is squeaky clean. To minimize static build-up, allow cleaner to flash dry after cleaning.



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- **Step 5:** Apply one medium coat of Plas-Stick® 2330S™** or 1 coat of A-2330S™ immediately after cleaning with Plas-Stick® 2320S™ to guarantee adhesion.
(* For gel coated fiberglass, sand with 400 grit and go direct to sealer. It is not necessary to use 2330S™.)
- **Step 6.** Allow Adhesion Promoter to dry 25 min before applying flexed primer or flexed sealer.
- **Step 7.** Apply activated ChromaSystem® basecoat.
- **Step 8.** Apply clearcoat with Plas-Stick® 2350S™ Flexible Additive.
Note: For ChromaClear® G2-4500S™, G2-4700S™, 7779S™ or HC-7776S™ and ChromaPremier® 72200S™ 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™ or A-2320S™.

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

Caution: Do not use other 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.

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 can occur. 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. Wet the 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 can occur. 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 500 grit sandpaper. Be careful not to sand through the primer.
- **Step 3:** Clean with DuPont™ Plas-Stick® 2319S™ Plastic Prep and let dry.



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- **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.*



Gun Setups*

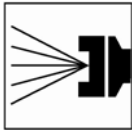
Conventional

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."



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Application/Dry Times

DuPont™ ChromaSurfacer™

Apply 2 - 3 light coats to achieve proper fill. Allow good flash time and avoid excessive film build. Force dry for 30 minutes at 140°F or air dry overnight before sanding.

DuPont™ ChromaSeal®

Allow to air dry 20 minutes for 1 coat or 40 minutes for 2 coats before topcoating

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.

ChromaPremier® Single Stage or ChromaOne® 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® G2-4500S™ and G2-4700S™) process as follows:

ChromaClear® 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® 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® G2-4700S™ is baked at higher temperatures than described above, dieback may occur.

For ChromaPremier® 72200S™ and 72500S™ force dry for 30 to 45 minutes at 140° F or air dry overnight.

For ChromaPremier® HC-7776S™ bake 15 minutes at 140°F or air dry overnight

For ChromaPremier® 7779S™ bake 30 minutes at 140°F or air dry overnight



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.

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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 usage and recommendations in the VOC Compliant Products Chart for your area.

Safety and Handling

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

Please visit: www.performancecoatings.dupont.com to view or print an addition copy of this "Technical Product Data" sheet.

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DuPont Performance Coatings 7