



Refinish

DuPont™ Plas-Stick® 2320S™ and A-2320S™ Cleaner

Description

Plas-Stick® 2320S™ is a ready-to-use **unprimed** plastic parts cleaner designed to remove mold release agents and other surface contaminants and eliminate static. Plas-Stick® 2320S™ is critical to the success of the plastic repair procedure. Plas-Stick® A-2320S™ is designed to provide aerosol convenience with the exceptional plastic parts cleaning of Plas-Stick® 2320S™.

Plas-Stick® A-2320S™ is interchangeable with Plas-Stick® 2320S™.

*Do not use to clean ABS or Lexan® (polycarbonate) because it will partially dissolve the substrate. Use Plas-Stick® Plastic-Prep 2319S™ instead.

General Information



Components

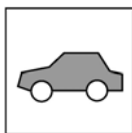
Plas-Stick® 2320S™ Cleaner for plastics

Plas-Stick® A-2320S™ Aerosol Cleaner for plastics

Mix Ratio/Viscosity

Ready-to-spray.

Application



Substrates

For use on most automotive **unprimed** plastics, including rigid, semi-rigid, and flexible parts. **For ABS or Lexan (Polycarbonate), do not use Plas-Stick® 2320S™, it may partially dissolve the substrate. Use Plas-Stick® Plastic-Prep 2319S™ instead.**

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

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 soap and hot water.
- **Step 2:** Saturate the plastic with Plas-Stick® 2320S™* 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 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 to help ensure adhesion.
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- **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.*

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™.*
- *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™ FinalKlean™ 3901S™, Prep-Sol® 3919S™, duPont 3939S™ Lacquer & Enamel Cleaner) due to static buildup and the potential for flash fire.*

Physical Properties

VOC: (lbs/gal)

	<u>AP</u>	<u>LE</u>
2320S™	6.6	6.6
A-2320S™	5.8	5.8

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.



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