DUPONT Refinish

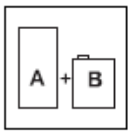
DuPont™ Plas-Stick® 2330S™ and A-2330S™ Plastics Adhesion Promoter

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. Plas-Stick® A-2330S™ is designed to provide aerosol convenience with the benefits of Plas-Stick® 2330S™.

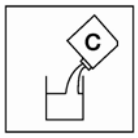
General Information

Components
Plas-Stick® 2330S™ or Plas-Stick® A-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™ ChromaSurfacer™ 7704S™ 2K Urethane Primer-Filler (for rigid plastics)
DuPont™ ChromaSurfacer™ 7704S™ 2K Urethane Primer-Filler flexed with 2350S™
DuPont™ ChromaSeal® 7710S™/ 7740S™/7770S™ 2K Urethane ValueShade® Sealer (over rigid parts)
DuPont™ ChromaSeal® 7710S™/ 7740S™/7770S™ 2K ValueShade® Sealer with flexed with 2350S™
ChromaPremier® 32430S™ 2K Primer
ChromaPremier® 32430S™ 2K Primer flexed with 2350S™
ChromaPremier® 42410S™/42440S™/42470S™ Sealer (for rigid plastics)
ChromaPremier® 42410S™/42440S™/42470S™ Sealer with Plas-Stick® 2350S™ Flex Additive
DuPont™ 4004S™ 2K UltraProductive Primer-Filler with Plas-Stick® 4150S™
DuPont™ 4004S™ 2K UltraProductive Primer-Filler with Plas-Stick® 4950S™ 2K Flex Additive
DuPont™ 4904S™ 2K UltraProductive Primer-Filler with Plas-Stick® 4950S™ 2K Flex Additive
DuPont™ 4910S™/4940S™/4970S™ UltraProductive Primer Sealer (for rigid plastic)
DuPont™ 4910S™/4940S™/4970S™ UltraProductive Primer Sealer with Plas-Stick® 4950S™ Flex Additive

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, activated
ChromaPremier® single stage
ChromaBase®, activated
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™ or A-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.

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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, CAB, CN, EP, MF, PA, PCPBTP, PETB, PT, PMMA, POM, PP, PPO, PL, PVC, SAN, PP-TPO, SMC, PUR, TPU, AND UP.

- Step 1: Pre-wash with warm water and DuPont™ 2310S™ Plastic Cleaning Paste using a gray or gold Scotch-Brite™ 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 Scotch-Brite™ 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™ or 2322S™ 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. Use this process for the plastics CAB, CN, EP, MF, PA, PC, PBTP, PETB, PT, PMMA, POM, PPO, PL, PVC, SAN, PP-TPO, PUR, TPU, AND UP.
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 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 Scotch-Brite™ (or 800 grit sandpaper). Do not use 320 grit or red Scotch-Brite™, 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.

- 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 500 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.

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- 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 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: Scuff substrate with gray or gold Scotch-Brite™. Be careful not to scuff through the primer.

- Step 3: Clean with DuPont™ Plas-Stick® 2319S™ Plastic Prep 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.*

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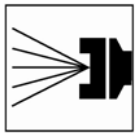
Gun Setups

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" - .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™ and A-2330S™ will still be tacky. Follow with the appropriate primer or topcoat.

Flash/Dry Times

Air Dry for Plas-Stick® 2330S™ or A-2330S™

Time to prime/seal/topcoat: 25 minutes

Force Dry for Plas-Stick® 2330S™or A-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.

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™ and A-2330S™ to raw plastic substrate, force dry (e.g. 140°F x 30 minutes) after applying single stage or clearcoat.

Blending

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

Recoatability/Re-repair

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

Sanding

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

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

Physical Properties

	2230S™	A-2330S™
VOC:	6.6 lb/gal	5.8 lb/gal
Theoretical Coverage:	240 sq ft/gal at 0.5 mil	120 sq ft/gal at 0.5 mil
Weight Solids:	12.7% ready-to-spray	6.8% ready to spray
Volume Solids:	7.6% ready-to-spray	3.8% ready-to-spray

Flash Point: See MSDS.
Recommended dry film thickness: 0.35 to 0.50 mils in 1 coat.

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.pc.dupont.com to view or print an addition copy of this "Technical Product Data" sheet.

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