PLAS-STICK®
2322S™ PLASTIC ADHESION PROMOTER

GENERAL

DESCRIPTION
An adhesion promoter designed to enhances the performance of select products on unprimed polyolefin.

MIXING

COMPONENTS
Plas-Stick® 2322S™ Plastic Adhesion Promoter

MIX RATIO
Ready to Spray

POT LIFE
Indefinite

ADDITIVES

Accelerator:	Not recommended
Fish Eye Eliminator:	Not recommended
Flattener:	Not recommended
Flex Additive:	Not recommended
Reducer:	Not recommended
Retarder:	Not recommended

TINTING
Not recommended

APPLICATION

PRIMER/SEALER
Plas-Stick® 2340S™ Flexible Adhesion Sealer
ChromaBase® "4 to 1" 7701S™ / 7704S™ / 7707S™ 2K Urethane Primer
ChromaBase® "4 to 1" 7710S™ / 7740S™ / 7770S™ 2K Urethane Sealer
ChromaPremier® Pro 33430S™ Productive Primer Sealer
ChromaPremier® 42410S™ / 42440S™ / 42470S™ / 2K Premier Sealer

TOPCOATS
It is recommended to apply one of the above primers/sealers over Plas-Stick® 2322S™ Plastic Adhesion Promoter before applying one of the following topcoats:
- ChromaPremier® Basecoat, activated
- ChromaPremier® Single Stage
- ChromaBase® Basecoat, activated
- MasterTint® Vinyl Color

SUBSTRATES
Unprimed rigid, semi-flexible or flexible automotive plastic parts.
- Since it is difficult for paint to adhere to polyethylene and polypropylene, clean and sand thoroughly before applying Plas-Stick® 2322S™ Plastic Adhesion Promoter.
- For specific substrate information, refer to the Automotive Plastics Refinishing Guide. Do not use Plas-Stick® 2322S™ Plastic Adhesion Promoter over fiberglass, silicone rubber, polyurethane foams or primed plastics.

SURFACE PREPARATION

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

PAINTING RAW PLASTIC PARTS

Option A

Use the following process for the plastics ABS, CAB, CN, EP, MF, PA, PC, PBTP, PETB, PT, PMMA, POM, PPO, PL, PVC, SAN, BBB, TPU, PP-TPO, SMC, PUR AND UP.

Step 1: Pre-wash with warm water and 2310S™ Plastic Cleaning Paste using a gray or gold Scotch-Brite™ pad.

Step 2: Rinse thoroughly making sure the 2310S™ Plastic Cleaning Paste does not dry on the surface.

Step 3: Wash again with warm water and 2310S™ Plastic Cleaning Paste using a gray or gold Scotchbrite™ pad.

Step 4: Rinse thoroughly making sure the 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 2 medium coats of Plas-Stick® 2322S™ Plastic Adhesion Promoter immediately after cleaning to help ensure adhesion. Allow 5 minutes flash between coats.

Step 6: Allow adhesion promoter to dry 20 minutes before applying flexed primer or flexed sealer.

Step 7: Apply activated ChromaSystem™ basecoat.

Step 8: Apply clearcoat with Plas-Stick® 2350S™ Flex Additive. Add 2 oz. Plas-Stick® 2350S™ Flex Additive per RTS quart of:

- ChromaClear® G2-4500S™ Ultra Productive Baking Clearcoat
- ChromaClear® G2-4700S™ Ultra Productive Air Dry Clearcoat
- ChromaBase® "4 to 1" HC-7776S™ Snap Dry Clearcoat
- ChromaBase® "4 to 1" G2-7779S™ Panel and Overall Clearcoat
- ChromaPremier® 72200S™ Productive Clearcoat
- ChromaPremier® 72500S™ Premium Appearance Clearcoat

ChromaPremier® Pro 74500S™ Productive Clearcoat and ChromaPremier® Pro 74700S™ Productive Express Clearcoat do not require addition of flex additive.

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, TPU, PP-TPO, PUR 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.**

*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 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 two medium coats of Plas-Stick® 2322S™ immediately after cleaning with Plas-Stick® 2320S™ to guarantee adhesion. Allow 5 minutes flash between coats.

Step 6: Allow Adhesion Promoter to dry 20 min before applying flexed primer or flexed sealer.

Step 7: Apply activated ChromaSystem™ basecoat.

Step 8: Apply clearcoat with Plas-Stick® 2350S™Flexible Additive. Add 2 oz. Plas-Stick® 2350S™ Flex Additive per RTS quart of:

- ChromaClear® G2-4500S™ Ultra Productive Baking Clearcoat
- ChromaClear® G2-4700S™ Ultra Productive Air Dry Clearcoat
- ChromaBase® "4 to 1" HC-7776S™ Snap Dry Clearcoat
- ChromaBase® "4 to 1" G2-7779S™ Panel and Overall Clearcoat
- ChromaPremier® 72200S™ Productive Clearcoat
- ChromaPremier® 72500S™ Premium Appearance Clearcoat

ChromaPremier® Pro 74500S™ Productive Clearcoat and ChromaPremier® Pro 74700S™ Productive Express Clearcoat do not require addition of flex additive.

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™ Flexible Parts Cleaner after tempering to remove mold release agent.
- Use a clean cloth when applying Plas-Stick® 2320S™ Flexible Parts Cleaner or Plas-Stick® A-2320S™ Flexible Parts Cleaner.

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. First Klean™ 3900S™ Surface Cleaner, Final Klean™ 3901S™ Surface Cleaner, Prep-Sol® 3919S™ Cleaning Solvent, 3939S™ Lacquer and Enamel Cleaner) due to static buildup and the potential for flash fire.

Do not wipe with dry cloth because it will generate static.

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. To ensure that lifting 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.

Step 1: Test Pre-Primed part for solvent resistance. Wet the entire bumper with 7175S™ Basemaker and let stand for 5 minutes*. After the solvent has flashed, wipe off primer from areas that lifted.

Caution: Be careful when using 7175S™ Basemaker. 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.

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. To ensure that lifting 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 7175S™ Basemaker 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 2319S™ Plastic Surface Cleaner 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.

If cut-throughs occur, complete the surface prep procedure and use Plas-Stick® 2322S™ Plastic Adhesion Promoter (over the cut-through only) to promote good adhesion.

GUN SETUP

Compliant	
Siphon Feed:	1.4 mm-1.6 mm
Gravity Feed:	1.3 mm-1.5 mm
HVLP	
Siphon Feed:	1.4 mm-1.6 mm
Gravity Feed:	1.3 mm-1.4 mm

AIR PRESSURE

Compliant	
Siphon Feed:	35-40 psi at the gun.
Gravity Feed:	30-35 psi at the gun.
HVLP:	6-8 psi at the gun cap.

APPLICATION

Apply 2 light to medium coats. Flash 5 minutes between coats. Follow with the appropriate primer or topcoat.

BLENDING

Plas-Stick® 2322S™ Plastic Adhesion Promoter may be used for spot repairs.

CLEANUP

Clean spray equipment as soon as possible with Lacquer Thinner.

DRY TIMES

AIR DRY

Time to Primer/Sealer: 20 minutes

Note: Plas-Stick® 2322S™ Plastic Adhesion Promoter must be primed or sealed within 2 hours to minimize the potential for contamination and to ensure proper adhesion.

RECOATABILITY/RE-REPAIR

Plas-Stick® 2322S™ Plastic Adhesion Promoter may be re-coated at any stage of dry or cure. Avoid excessive film build.

SANDING / COMPOUNDING / POLISHING

SANDING

Plas-Stick® 2322S™ Plastic Adhesion Promoter requires sanding. If sanding is necessary, reapply Plas-Stick® 2322S™ Plastic Adhesion Promoter. Avoid excessive film build.

PHYSICAL PROPERTIES

VOC (LE/AP):	6.6 / 6.6 lbs./gal (791 / 791 g/L)
Theoretical Coverage:	140 sq. ft. per RTS gallon at 1 mil
Weight Solids:	11.1% RTS.
Volume Solids:	9.3% RTS.
Weight per Gallon:	7.39 lbs./gal (886 g/L) RTS
Weight Water:	0% RTS
Weight Exempts:	0% RTS
Flash Point:	See MSDS.
Recommended dry film thickness:	0.25 to 0.50 mils in 2 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.

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