



2319S™ PLASTIC SURFACE CLEANER



GENERAL

DESCRIPTION

A ready-to-use plastic parts cleaner designed to remove mold release agents, surface contaminants and eliminate static from primed plastic, primed fiberglass, ABS and Lexan® (polycarbonate) substrates.

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.



MIXING

COMPONENTS

2319S™ Plastic Surface Cleaner

MIX RATIO

Ready to use



APPLICATION

SUBSTRATES

For use on ABS or Lexan® (polycarbonate) substrates, primed plastic or primed fiberglass. Refer to "Flexible Plastics Repair Procedures Flow Chart" for schematic representation.

UNPRIMED ABS OR UNPRIMED LEXAN®

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 2319S™ Plastic Surface Cleaner and continue to apply while rubbing wet surface with a clean cloth. After 4-5 minutes, the surface should have no gloss and it should not feel slick.

If it does, reapply 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.

Step 3

Sand substrate thoroughly using a fine scuffing pad such as gray or gold Scotch-Brite™

Step 4

Clean again with 2319S™ Plastic Surface Cleaner as described in Step 2. And repeat until substrate is squeaky clean. To minimize static build-up, allow to flash dry after cleaning.

Step 5

Apply one medium coat of Plas-Stick® 2330S™ Plastic Adhesion Promoter or A-2330S™ Plastics Adhesion Promoter** immediately after cleaning with 2319S™ Plastic Surface Cleaner to guarantee adhesion.

Step 6

Allow Plas-Stick® 2330S™ Plastic Adhesion Promoter or A-2330S™ Plastic Adhesion Promoter to dry 25 min before applying flexible primer or flexible 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.

Tips for Success

- To test the surface preparation, pour a cap of 2319S™ Plastic Surface Cleaner on the prepared area. It will sheet cleanly over a clean substrate. If 2319S™ Plastic Surface Cleaner beads up, the surface is not clean.
- 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 2319S™ Plastic Surface Cleaner after tempering to remove mold release agent.
- Use a clean cloth when applying 2319S™ Plastic Surface Cleaner.



PHYSICAL PROPERTIES

All Values Ready To Spray

Max. VOC (LE):	797 g/L (6.7 lbs./gal)
Max. VOC (AP):	664 g/L (5.5 lbs./gal)
Avg. Gal. Wt.:	831 g/L (6.93 lbs./gal)
Avg. Wt.% Volatiles:	100.0%
Avg. Wt.% Exempt Solvent:	0.0%
Avg. Wt.% Water:	20.0%
Avg. Vol.% Exempt Solvent:	0.0%
Avg. Vol.% Water:	16.7%
Flash Point:	See MSDS/SDS

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/SDS 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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In the United States:
1.855.6.AXALTA
cromax.us

In Canada:
1.800.668.6945
cromax.ca

