



PLAS-STICK® 2350S™ FLEX ADDITIVE



GENERAL

DESCRIPTION

A flexible additive designed to improve the adhesion, chip resistance and flexibility of select collision undercoat, single-stage and clearcoat products.

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



MIXING

COMPONENTS

Plas-Stick® 2350S™ Flex Additive is for use with the following products:

ChromaBase® "4 to 1" 7701S™ / 7704S™ / 7707S™ 2K Urethane Primer Filler
 ChromaBase® "4 to 1" 7710S™ / 7740S™ / 7770S™ 2K Urethane Sealer
 ChromaPremier® Pro 33430S™ Productive Primer Sealer
 ChromaPremier® 42410S™ / 42440S™ / 42470S™ / 2K Premier Sealer
 ChromaPremier® Single Stage Topcoats
 ChromaBase® "4 to 1" G2-7779S™ Panel and Overall Clearcoat
 ChromaBase® "4 to 1" HC-7776S™ Snap Dry Clearcoat
 ChromaClear® G2-4500S™ Ultra Productive Baking Clearcoat
 ChromaClear® G2-4700S™ Ultra Productive Air Dry Clearcoat
 ChromaPremier® 72200S™ Productive Clearcoat
 ChromaPremier® 72500S™ Premium Appearance Clearcoat

MIX RATIO

Combine components by volume or by weight (cumulative pint). Mix thoroughly.

Undercoats	Volume	Weight	Clearcoats	Volume	Weight
33430S™	4	451.1	G2-4500S™ or G2-4700S™	9	253.2
14301S™	1	520.6	G2-4507S™	3	347.4
14375S™	1	582.1	12375S™	3	422.9
Plas-Stick® 2350S™	.5	617.1	2350S™	1	451.3
42410S™	3	349.4	72200S™	9	243.4
12305S™	1	423.6	12305S™	3	329.1
42475S™	1.5	524.1	12375S™	1	422.0
2350S™	1	594.1	2350S™	25-30%	448.9
42440S™	3	336.5	72500S™	6	268.1
12305S™	1	410.7	12305S™	3	407.6
42475S™	1.5	511.2	12375S™	0.5	442.5
Plas-Stick® 2350S™	1	581.2	2350S™	10%	463.5
42470S™	3	335.5	G2-7779S™	4	328.4
12305S™	1	409.7	7775S™	1	417.1
42475S™	1.5	510.2	2350S™	2 oz/pt.	443.6
2350S™	1	580.2	HC-7776S™	4	322.5
7704S™	4	452.8	7775S™	1	411.5
7775S™	1	534.3	2350S™	2 oz/pt.	438.0
2350S™	2.5 oz/pt.	595.7			
ChromaSeal® 7710S™	4	461.9	Topcoat	Volume	
ChromaBase® 7775S™	1	548.0	ChromaPremier® Single Stage	3	
Plas-Stick® 2350S™	1.5 oz/pt.	587.1	ChromaPremier® 12305S™	1	
ChromaSeal® 7740S™	4	450.3	ChromaPremier® 12375S™	5%-10%	
ChromaBase® 7775S™	1	536.4	Plas-Stick® 2350S™	2 oz/qt.	
Plas-Stick® 2350S™	1.5 oz/pt.	575.5			
ChromaSeal® 7770S™	4	451.1			
ChromaBase® 7775S™	1	537.2			



Plas-Stick® 2350S™ 1.5 oz/pt. 576.7

APPLICATION

SUBSTRATES

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, 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 2310S™ Plastic Cleaning Paste using a gray or gold Scotchbrite™ 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 one medium coat of Plas-Stick® 2330S™ Plastic Adhesion Promoter or 1 coat of A-2330S™ Plastic Adhesion Promoter 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. 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

Option B

Use the following procedure if you prefer using Plas-Stick® 2320S™ Flexible Parts 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™ / A-2320S™ Plastic Parts Cleaner* and continue to apply cleaner 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 cleaner as described above.

It is crucial to clean the surface as described to get good adhesion.

*Plas-Stick® 2320S™ / A-2320S™ Plastic Parts Cleaner should not be used to clean ABS or Lexan® (polycarbonate) because it will partially dissolve the substrate. Use Plas-Stick®



2319S™ Plastic Cleaning Paste 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™ / A-2320S™ Plastic Parts Cleaner 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™ Plastic Adhesion Promoter** or 1 coat of Plas-Stick® A-2330S™ Plastic Adhesion Promoter immediately after cleaning with Plas-Stick® 2320S™ Plastic Parts Cleaner to guarantee adhesion.

** For gel coated fiberglass, sand with 400 grit and go direct to sealer. It is not necessary to use Plas-Stick® 2330S™ / A-2330S™ Plastic Adhesion Promoter.

Step 6: Allow Adhesion Promoter to dry 25 min before applying flexed primer or 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

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

Note: Tempering is not beneficial for urethane parts (PUR) due to “post cure” temperatures in excess of 140°F (60°C).

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 Cleaning Paste 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™ / A-2330S™ Plastic Adhesion Promoter (over the cut-through only) to promote good adhesion.

CLEANUP

Clean spray equipment as soon as possible with lacquer thinner.



DRY TIMES

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 (60°C) or air dry overnight before sanding.

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 (60°C) 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.

- ChromaClear® G2-4500S™ Ultra Productive Baking Clearcoat - Force dry at 10 minutes (cycle time) at 160°F (71°C) (booth temp.), then let stand for 1 hour. If Air drying, allow to stand for 4.5-6 hours.
- ChromaClear® G2-4700S™ Ultra Productive Air Dry Clearcoat - Express dry at 10 minutes (cycle time) x 120°F (49°C)* (booth temp.), then let stand for 1 hour. If Air drying, allow to



stand for 2-2.5 hours. ***If baked at higher temperatures than directed, dieback may occur.**

- ChromaPremier® 72200S™ Productive Clearcoat - Force dry for 30 to 45 minutes at 140° F or air dry overnight.
- ChromaPremier® 72500S™ Premium Appearance Clearcoat - Force dry for 30 to 45 minutes at 140° F (60°C) or air dry overnight.
- ChromaBase® "4 to 1" HC-7776S™ Snap Dry Clearcoat – Force dry 15 minutes at 140°F or air dry overnight.
- ChromaBase® "4 to 1" G2-7779S™ Panel and Overall Clearcoat – Force dry 30 minutes at 140°F (60°C) or air dry overnight.

RECOATABILITY/RE-REPAIR

Allow overnight dry before performing re-repair operations.



SANDING / COMPOUNDING / POLISHING

SANDING

The use of Plas-Stick® 2350S™ Flex Additive in primer, single stage and clearcoat will slow dry and cure times. Allow additional dry time before sanding flexed primer surfacer, or sanding and polishing single stage and clearcoat finishes.



PHYSICAL PROPERTIES

All Values Ready To Spray

	33430S™	42410S™
Max. VOC (LE):	518 g/L (4.3 lbs./gal)	531 g/L (4.4 lbs./gal)
Max. VOC (AP):	518 g/L (4.3 lbs./gal)	531 g/L (4.4 lbs./gal)
Avg. Gal. Wt.:	1305 g/L (10.89 lbs./gal)	1256 g/L (10.48 lbs./gal)
Avg. Wt.% Volatiles:	39.6%	42.3%
Avg. Wt.% Exempt Solvent:	0.0%	0.0%
Avg. Wt.% Water:	0.0%	0.0%
Avg. Vol.% Exempt Solvent:	0.0%	0.0%
Avg. Vol.% Water:	0.0%	0.0%
	42440S™	42470S™
Max. VOC (LE):	531 g/L (4.4 lbs./gal)	531 g/L (4.4 lbs./gal)
Max. VOC (AP):	531 g/L (4.4 lbs./gal)	531 g/L (4.4 lbs./gal)
Avg. Gal. Wt.:	1229 g/L (10.25 lbs./gal)	1226 g/L (10.23 lbs./gal)
Avg. Wt.% Volatiles:	43.2%	43.3%
Avg. Wt.% Exempt Solvent:	0.0%	0.0%
Avg. Wt.% Water:	0.0%	0.0%
Avg. Vol.% Exempt Solvent:	0.0%	0.0%
Avg. Vol.% Water:	0.0%	0.0%
	7704S™	7710S™
Max. VOC (LE):	470 g/L (3.9 lbs./gal)	533 g/L (4.4 lbs./gal)
Max. VOC (AP):	467 g/L (3.9 lbs./gal)	533 g/L (4.4 lbs./gal)
Avg. Gal. Wt.:	1267 g/L (10.57 lbs./gal)	1241 g/L (10.36 lbs./gal)
Avg. Wt.% Volatiles:	37.2%	43.0%
Avg. Wt.% Exempt Solvent:	.4%	0.0%
Avg. Wt.% Water:	0.0%	0.0%
Avg. Vol.% Exempt Solvent:	.6%	0.0%
Avg. Vol.% Water:	0.0%	0.0%



	7740S™	7770S™
Max. VOC (LE):	533 g/L (4.4 lbs./gal)	532 g/L (4.4 lbs./gal)
Max. VOC (AP):	533 g/L (4.4 lbs./gal)	532 g/L (4.4 lbs./gal)
Avg. Gal. Wt.:	1216 g/L (10.15 lbs./gal)	1218 g/L (10.16 lbs./gal)
Avg. Wt.% Volatiles:	43.9%	43.7%
Avg. Wt.% Exempt Solvent:	0.0%	0.0%
Avg. Wt.% Water:	0.0%	0.0%
Avg. Vol.% Exempt Solvent:	0.0%	0.0%
Avg. Vol.% Water:	0.0%	0.0%

	G2-450XS	72200S™
Max. VOC (LE):	505 g/L (4.2 lbs./gal)	424 g/L (3.5 lbs./gal)
Max. VOC (AP):	479 g/L (4.0 lbs./gal)	400 g/L (3.3 lbs./gal)
Avg. Gal. Wt.:	956 g/L (7.98 lbs./gal)	968 g/L (8.07 lbs./gal)
Avg. Wt.% Volatiles:	57.1%	53.6%
Avg. Wt.% Exempt Solvent:	3.5%	4.6%
Avg. Wt.% Water:	0.0%	0.0%
Avg. Vol.% Exempt Solvent:	4.3%	5.7%
Avg. Vol.% Water:	0.0%	0.0%

	72500S™	G2-7779S™
Max. VOC (LE):	418 g/L (3.5 lbs./gal)	500 g/L (4.2 lbs./gal)
Max. VOC (AP):	394 g/L (3.3 lbs./gal)	432 g/L (3.6 lbs./gal)
Avg. Gal. Wt.:	984 g/L (8.21 lbs./gal)	939 g/L (7.84 lbs./gal)
Avg. Wt.% Volatiles:	45.7%	57.5%
Avg. Wt.% Exempt Solvent:	5.6%	11.5%
Avg. Wt.% Water:	0.0%	0.0%
Avg. Vol.% Exempt Solvent:	5.6%	13.6%
Avg. Vol.% Water:	0.0%	0.0%

	HC-7776S™	F Quality Basecoat
Max. VOC (LE):	494 g/L (4.2 lbs./gal)	596 g/L (5.0 lbs./gal)
Max. VOC (AP):	385 g/L (3.2 lbs./gal)	561 g/L (4.7 lbs./gal)
Avg. Gal. Wt.:	927 g/L (7.74 lbs./gal)	965 (4.7 lbs./gal)
Avg. Wt.% Volatiles:	60.2%	62.9%
Avg. Wt.% Exempt Solvent:	18.6%	4.8%
Avg. Wt.% Water:	0.0%	0.0%
Avg. Vol.% Exempt Solvent:	21.9%	5.9%
Avg. Vol.% Water:	0.0%	0.0%

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

