



PLAS-STICK® 2320S™ / A-2320S™ FLEXIBLE PARTS CLEANER



GENERAL

DESCRIPTION

A ready-to-use cleaner designed to remove mold release agents and surface contaminants from unprimed plastic parts. Do not use to clean ABS or Lexan® (polycarbonate).

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



MIXING

COMPONENTS

Plas-Stick® 2320S™ Flexible Parts Cleaner
Plas-Stick® A-2320S™ Aerosol Flexible Parts Cleaner

MIX RATIO

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™ Flexible Parts Cleaner, it may partially dissolve the substrate. Use 2319S™ Plastic Surface Cleaner instead.**
- Flexible plastics that have been properly prepared. Refer to “Flexible Plastics Repair Procedures Flow Chart” for schematic representation.

PAINTING RAW PLASTIC PARTS

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™ Flexible Parts Cleaner* and continue to apply 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™ Flexible Parts Cleaner 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™ Flexible Parts Cleaner should not be used to clean ABS or Lexan® (polycarbonate) because it will partially dissolve the substrate. Use 2319S™ Plastic Surface Cleaner 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 A- 2320S™ or 2320S™ Flexible 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 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™ Flex Additive. Add 2 oz. of Plas-Stick® 2350S™ Flex Additive per RTS quart of:

- ChromaClear® G2-4500S™ Ultra Productive Baking Clearcoat
- ChromaClear® G2-4700S™ Ultra Productive Air Dry Clearcoat
- ChromaPremier® Pro 74500S™ Productive Clearcoat
- ChromaPremier® Pro 74700S™ Productive Express Clearcoat
- ChromaPremier® 72200S™ Productive Clearcoat
- ChromaPremier® 72500S™ Premium Appearance Clearcoat
- ChromaBase® "4 to 1" HC-7776S™ Snap Dry Clearcoat
- ChromaBase® "4 to 1" G2-7779S™ Panel and Overall Clearcoat

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

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.
- 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.



PHYSICAL PROPERTIES

All Values Ready To Spray

	2320S™	A-2320S™
Max. VOC (LE):	785 g/L (6.6 lbs./gal)	699 g/L (5.8 lbs./gal)
Max. VOC (AP):	785 g/L (6.6 lbs./gal)	699 g/L (5.8 lbs./gal)
Avg. Gal. Wt.:	785 g/L (6.55 lbs./gal)	699 g/L (5.83 lbs./gal)
Avg. Wt.% Volatiles:	100.0%	100.0%
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%
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
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In Canada:
1.800.668.6945
cromax.ca

