



PLAS-STICK® V-2350S™ LOW VOC FLEX ADDITIVE



GENERAL

DESCRIPTION

A Low VOC flexible additive designed to improve the adhesion, chip resistance and flexibility of select collision undercoat 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® V-2350S™ Flex Additive is for use with the following products:

- Cromax® Premier LE LE3401S™/LE3404S™/LE3407S™ 2K Urethane Primer Filler
- Cromax® Premier LE LE3410S™/LE3440S™/LE3470S™ 2K Urethane Sealer
- Cromax® LE LE5100S™ Multi-Panel Clearcoat
- Cromax® LE LE5400S™ Snap Dry Clearcoat
- Cromax® LE LE5600S™ Non-Stop Clearcoat
- Cromax® Premier LE LE8300S™ Productive Clearcoat
- Cromax® Premier LE LE8700S™ Premium Appearance Clearcoat

MIX RATIO

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

Undercoats	Volume	Weight	Clearcoats	Volume	Weight
LE3401S™	4	584.5	LE5100S™	2	298.0
LE1175S™	1	691.4	LE1175S™	1	475.5
V-2350S™	1 oz/pt	720.5	V-2350S™	1 oz/pt	506.4
LE3404S™	4	593.0	LE5400S™	4	375.0
LE1175S™	1	699.9	LE1170S™	1	481.9
V-2350S™	1 oz/pt	729.0	V-2350S™	1 oz/pt	510.8
LE3407S™	4	583.6	LE5600S™	4	317.8
LE1175S™	1	690.5	LE5605S™	1	409.2
V-2350S™	1 oz/pt	719.6	LE5685S™	1	488.5
LE3410S™	4	462.1	V-2350S™	1 oz/pt	517.9
LE1175S™	1	551.2	LE8300S™	3	276.1
LE1275S™	1	644.0	LE1005S™	1	376.9
V-2350S™	1 oz/pt	673.1	LE1075S™	1	495.5
LE3440S™	4	430.1	V-2350S™	1 oz/pt	524.4
LE1175S™	1	519.2	LE8700S™	3	369.8
LE1275S™	1	612.0	LE1005S	1	495.7
V-2350S™	1 oz/pt	641.1	V-2350S™	1 oz/pt	538.0
LE3470S™	4	429.1			
LE1175S™	1	511.0			
LE1275S™	1.	603.8			
V-2950S™	1 oz/pt	632.9			



APPLICATION

SUBSTRATES

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

PAINTING RAW PLASTIC PARTS

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® V- 2350S™ Flexible Additive. Add 2 oz. Plas-Stick® V-2350S™ Low VOC Flex Additive per RTS quart of:

- Cromax® LE LE5100S™ Multi-Panel Clearcoat
- Cromax® LE LE5400S™ Snap Dry Clearcoat
- Cromax® LE LE5600S™ Non-Stop Clearcoat
- Cromax® Premier LE LE8300S™ Productive Clearcoat
- Cromax® Premier LE LE8700S™ Premium Appearance Clearcoat

Tips for Success

For difficult-to-clean and textured plastics, temper the substrate for 15 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. Repeat Steps 1 through 4.

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

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 2310S™ Plastic Cleaning Paste and let dry.

Step 4: Go to 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 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

Cromax® Premier LE LE3401S™ / LE3404S™ / LE3407S™ 2K Urethane Primer Filler
Apply 2-3 light coats to achieve proper fill. Allow a good flash time and avoid excessive film build. Force dry for 30 minutes at 140°F or air dry overnight before sanding.

Cromax® Premier LE LE3410S™ / LE3440S™ / LE3470S™ 2K Urethane Sealer
Air dry 20 minutes for 1 coat or 40 minutes for 2 coats before topcoating.

Productive and Conventional Clearcoats

Apply two coats of clearcoat. Allow a good flash between coats and avoiding excessive film build. Refer to clearcoat Technical Data Sheet for recommended dry times.

RECOATABILITY/RE-REPAIR

Allow to dry overnight before re-repair.



SANDING / COMPOUNDING / POLISHING

SANDING

The use of Plas-Stick® V-2350S™ Low VOC Flex Additive in primer 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

	LE3401S	LE3404S
Max. VOC (LE):	241 g/L (2.0 lbs./gal)	239 g/L (2.0 lbs./gal)
Max. VOC (AP):	143 g/L (1.2 lbs./gal)	141 g/L (1.2 lbs./gal)
Avg. Gal. Wt.:	1551 g/L (12.95 lbs./gal)	1561 g/L (13.03 lbs./gal)
Avg. Wt.% Volatiles:	57.3%	57.6%
Avg. Wt.% Exempt Solvent:	32.9%	34.3%
Avg. Wt.% Water:	0.0%	0.0%
Avg. Vol.% Exempt Solvent:	40.5%	41.1%
Avg. Vol.% Water:	0.0%	0.0%

	LE3407S	LE3410S
Max. VOC (LE):	242 g/L (2.0 lbs./gal)	228 g/L (1.9 lbs./gal)
Max. VOC (AP):	143 g/L (1.2 lbs./gal)	108 g/L (.9 lbs./gal)
Avg. Gal. Wt.:	1544 g/L (12.89 lbs./gal)	1446 g/L (12.07 lbs./gal)
Avg. Wt.% Volatiles:	57.3%	50.7%
Avg. Wt.% Exempt Solvent:	33.7%	43.0%
Avg. Wt.% Water:	0.0%	0.0%
Avg. Vol.% Exempt Solvent:	40.6%	50.1%
Avg. Vol.% Water:	0.0%	0.0%

	LE3440S	LE3470S
Max. VOC (LE):	240 g/L (2.0 lbs./gal)	240 g/L (2.0 lbs./gal)
Max. VOC (AP):	120 g/L (1.0 lbs./gal)	108 g/L (.9 lbs./gal)
Avg. Gal. Wt.:	1368 g/L (11.42 lbs./gal)	1352 g/L (11.28 lbs./gal)
Avg. Wt.% Volatiles:	55.7%	56.8%
Avg. Wt.% Exempt Solvent:	47.3%	48.5%
Avg. Wt.% Water:	0.0%	0.0%
Avg. Vol.% Exempt Solvent:	51.1%	52.2%
Avg. Vol.% Water:	0.0%	0.0%

	LE5100S	LE5400S
Max. VOC (LE):	243 g/L (2.0 lbs./gal)	243 g/L (2.0 lbs./gal)
Max. VOC (AP):	139 g/L (1.2 lbs./gal)	121 g/L (1.0 lbs./gal)
Avg. Gal. Wt.:	1078 g/L (8.99 lbs./gal)	1083 g/L (9.03 lbs./gal)
Avg. Wt.% Volatiles:	57.6%	62.9%
Avg. Wt.% Exempt Solvent:	44.7%	51.7%
Avg. Wt.% Water:	0.0%	0.0%
Avg. Vol.% Exempt Solvent:	42.8%	50.0%
Avg. Vol.% Water:	0.0%	0.0%

	LE5600S	LE8300S
Max. VOC (LE):	240 g/L (2.0 lbs./gal)	240 g/L (2.0 lbs./gal)
Max. VOC (AP):	120 g/L (1.0 lbs./gal)	132 g/L (1.1 lbs./gal)
Avg. Gal. Wt.:	1098 g/L (9.16 lbs./gal)	1132 g/L (9.45 lbs./gal)
Avg. Wt.% Volatiles:	64.1%	61.5%
Avg. Wt.% Exempt Solvent:	53.3%	59.8%
Avg. Wt.% Water:	0.0%	0.0%
Avg. Vol.% Exempt Solvent:	51.1%	45.7%
Avg. Vol.% Water:	0.0%	0.0%

	LE8700S
Max. VOC (LE):	240 g/L (2.0 lbs./gal)
Max. VOC (AP):	150 g/L (1.3 lbs./gal)
Avg. Gal. Wt.:	1110 g/L (9.26 lbs./gal)
Avg. Wt.% Volatiles:	54.8%
Avg. Wt.% Exempt Solvent:	41.2%



Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	37.4%
Avg. Vol.% Water:	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 Canada:
1.800.668.6945
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