



PLAS-STICK® 2332S™ ADHESION PROMOTER



GENERAL

DESCRIPTION

A green adhesion promoter designed to enhance the performance of select Cromax® products on unprimed polyolefin or non-polyolefin plastic parts.

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



MIXING

COMPONENTS

Plas-Stick® 2332S™ Adhesion Promoter

MIX RATIO

Ready to spray. Shake or stir well prior to use.

POT LIFE

Indefinite

ADDITIVES

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



APPLICATION

PRIMERS OR SEALERS

- Cromax® LE LE3004S™ 2K Primer Surfacer
- Cromax® LE LE3010S™ / LE3040S™ / LE3070S™ 2K Primer Sealer
- Cromax® Premier LE LE3401S™ / LE3404S™ / LE3407S™ Urethane Primer Filler
- Cromax® Premier LE LE3410S™ / LE3440S™ / LE3470S™ Urethane Primer Sealer

Plas-Stick® 2332S™ Adhesion Promoter must always be followed with a Cromax® primer-surfacer or sealer. Do not apply topcoat directly to adhesion promoter.

TOPCOATS

Must be primed or sealed prior to topcoat. Follow usage recommendations in the VOC Compliant Products Chart for your area.

SUBSTRATES

Unprimed rigid, semi-flexible or flexible automotive plastic parts.

Note: Since it is difficult for paint to adhere to polyethylene and polypropylene, clean with 2310S™ Plastic Cleaning Paste thoroughly before applying Plas-Stick® 2332S™ Adhesion Promoter.

Note: For specific substrate information, refer to the Automotive Plastics Refinishing Guide. Do not use Plas-Stick® 2332S™ 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.

SURFACE PREPARATION AND PAINTING

Use the following process to repair bare plastics ABS, CAB, CN, EP, MF, PA, PC, PE, PBTP, PETB, PT, PMMA, POM, PP, PPO, PL, PVC, SAN, BBB, PP-TPO, SMC, PUR, TPU, 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. Make 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 Scotch-Brite™ pad.

Step 4: Rinse thoroughly. Make 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® 2332S™ Adhesion Promoter immediately after cleaning to help ensure adhesion.

Step 6: Allow adhesion promoter to dry 30 minutes before applying flexed primer or flexed sealer.

Step 7: Apply Cromax® Pro or Cromax® Mosaic™ Basecoat.

Step 8: Apply clearcoat with Plas-Stick® V-2350S™ Flex Additive.

Tips for Success

Pre-primed plastic can be prepared according to standard practices for painted surfaces.

GUN SETUPS*

Compliant	
Siphon Feed:	1.4 mm-1.6 mm (.055"-.063")
Gravity Feed:	1.3 mm-1.6 mm (.051"-.063")
HVLP	
Siphon Feed:	1.6 mm-1.8 mm (.063"-.071")
Gravity Feed:	1.3 mm-1.6 mm (.051"-.063")

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

*The listed setups cover the usual range for various application equipment.

APPLICATION

Apply 1 medium-wet coat. Do not target application of product to hiding.

BLENDING

Plas-Stick® 2332S™ Adhesion Promoter may be used for spot repairs.

CLEANUP

Clean spray equipment as soon as possible with equipment cleaning solvent.



DRY TIMES

Flash to Prime or Seal: 30 minutes

Tips for Success

Plas-Stick® 2332S™ Adhesion Promoter must be primed or sealed within 48 hours to minimize the potential for contamination and to ensure proper adhesion.

For optimum adhesion of Plas-Stick® 2332S™ Adhesion Promoter to raw plastic substrate, force dry (ex: 30 minutes at 140°F (60°C)) after applying single stage or clearcoat.

RECOATABILITY/RE-REPAIR

Plas-Stick® 2332S™ Adhesion Promoter may be re-coated at any stage of dry or cure. Avoid multiple coats and excessive film build.



SANDING / COMPOUNDING / POLISHING

SANDING

Plas-Stick® 2332S™ Adhesion Promoter does not require sanding. If sanding is necessary to remove dirt or imperfections, reapply Adhesion Promoter on cut throughs exposing raw plastic substrate. Avoid excessive film build.



PHYSICAL PROPERTIES

Max. VOC (LE):	522 g/L (4.4 lbs./gal)
Max. VOC (AP):	265 g/L (2.2 lbs./gal)
Avg. Gal. Wt.:	1160 g/L (9.68 lbs./gal)
Avg. Wt.% Volatiles:	78.7%
Avg. Wt.% Exempt Solvent:	55.8%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	49.3%
Avg. Vol.% Water:	0.0%
Theoretical Coverage:	657 sq. ft. per RTS gallon at 0.5 mil DFT
Recommended Thickness:	0.5 mils dry film
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:
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