PLAS-STICK®
2341S™/ 2344S™/ 2347S™ PLASTIC ADHESION PROMOTER

GENERAL

DESCRIPTION
A 4.5 VOC compliant plastic adhesion promoter system designed to eliminate a step in the plastic repair process. Now you simply clean the plastic part, apply Plas-Stick® 234XS Adhesion Promoter, then topcoat directly with waterborne or solvent borne basecoat. The adhesion promoters are available in all three ValueShade® colors.

RECOMMENDED USE
- Suitable Substrates: Raw plastic parts commonly found on vehicles, including: PP, TPO, PP/EPDM, ABS and PC PUR.
- Not Recommended for pre painted substrates

NOTE: The use of A-2330S™ Plastic Adhesion Promoter, 2330S™ Plastic Adhesion Promoter or 2332S™ Adhesion Promoter is mandatory prior to the application of 234XS 4.5 VOC Adhesion Promoter over aftermarket polypropylene parts.

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

MIXING

COMPONENTS
Plas-Stick® 2341S™ Plastic Adhesion Promoter - White (VS1)
Plas-Stick® 2344S™ Plastic Adhesion Promoter - Gray (VS4)
Plas-Stick® 2347S™ Plastic Adhesion Promoter - Dark Gray (VS7)
Cromax® Mosaic LE LE1165S™ / LE1175S™ / LE1185S™ / LE1195S™ Activator
Cromax® Premier LE LE1275S™ Reactive Reducer
Cromax® Premier LE LE1265S™ Low Temperature Reactive Reducer
Plas-Stick® 2321S™ Adhesion Additive

MIX RATIO
Use VS1, VS4, VS7 as packaged or mix to create VS2, VS3, VS5, VS6.

Combine components by volume (4:1:1:1). Mix thoroughly.

ValueShade®	Part	Ratio
VS1 (White)	2341S™	--
VS2	2341S™ : 2344S™	2:1
VS3	2341S™ : 2344S™	1:2
VS4 (Medium Gray)	2344S™	--
VS5	2344S™ : 2347S™	2:1
VS6	2344S™ : 2347S™	1:2
VS7 (Dark Gray)	2347S™	--

After creating the desired ValueShade®, mix by volume. For a RTS quart, combine components by weight (cumulative grams). Mix thoroughly.

Component	Volume	VS1	VS2	VS3	VS4	VS5	VS6	VS7
2341S™	4	842	562	280	-	-	-	-
2344S™	4	-	822	803	783	523	260	-
2347S™	4	-	-	-	-	778	773	769
LE1175S™	1	1004	985	965	946	941	936	931
LE1275S™	1	1173	1154	1134	1115	1110	1105	1100

2321S™	1	1292	1273	1253	1234	1229	1224	1219

SPRAY VISCOSITY
16-18 seconds in a Zahn #2 cup.

POT LIFE
60 minutes at 70°F (21.1°C)

Tips for Success
- Shake the adhesion promoter on a mechanical shaker before first usage. To maintain thorough agitation, place adhesion promoter on a mixing machine.
- Mix accurately using a mixing stick and a cup with straight sides for accurate measurements to ensure you achieve the stated product application and performance.

ADDITIVES

Flex Additive:	Not required
Accelerator:	Not required
Fish Eye Eliminator:	Not required
Retarder:	Not required
Flex Additive:	Not required

APPLICATION

TINTING
Not recommended

TOPCOATS
Cromax® Pro Basecoat
Cromax® Mosaic™ Basecoat
ChromaPremier® Basecoat
ChromaPremier® Single Stage
ChromaBase® Basecoat
Cleaning of substrate

The following steps describe the process for using 2310S™ Plastic Cleaning Paste to prepare new unprimed plastic parts:

1. Pre-wash with warm water and 2310S™ Plastic Cleaning Paste using a fine scuff pad.
2. Rinse thoroughly making sure the paste does not dry on the surface.
3. Wash again with warm water and 2310S™ Plastic Cleaning Paste using a fine scuff pad.
4. Rinse thoroughly making sure the paste does not dry on the surface. Dry the part thoroughly immediately following the rinse.
5. Apply Plas-Stick® 234XS Adhesion promoter.

Tip for Success
For difficult to clean plastics, bake parts for a minimum of 15 minutes at 140°F. Repeat Steps 2 and 3. Review the need for this process on every job over less familiar parts such as non-OEM.

GUN SETUP*

Gravity Feed	
HVLP	1.3 mm – 1.4 mm
Reduced Pressure	1.3 mm – 1.4 mm

SPRAY PRESSURE*
Per gun manufacturer recommendation
* The listed setups cover the usual range for various application equipment.
* Observe proper flash time for optimum appearance.
* Use the correct fluid tip send and proper air pressure to keep film builds consistent.

APPLICATION
Apply 1 wet coat.

DRY TIMES

AIR DRY

Nib Sanding:	20 minutes
Topcoating:	20 minutes

FORCE DRY

Flash before Force Dry:	5 minutes
Cycle Time:	10 minutes at 110°F (43°C)
Cool Down:	10 minutes

INFRARED DRY

Refer to the Infrared Guide for setup recommendations.

RECOATIBILITY / RE-REPAIR

When recoating 2341S™/2344S™/2347S™ with itself or top coating, sanding is required if the adhesion promoter has been allowed to air dry more than 2 hours.

EQUIPMENT CLEANING

Clean spray equipment as soon as possible with gun cleaner.

Tip for Success

Cooler temperature or more coats will require longer flash times.

This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.

PHYSICAL PROPERTIES

All Values Ready To Spray

Max. VOC (LE):	380 g/L (3.2 lbs./gal)
Max. VOC (AP):	207 g/L (1.7 lbs./gal)
Avg. Gal. Wt.:	1295 g/L (10.81 lbs./gal)
Avg. Wt.% Volatiles:	57.9%
Avg. Wt.% Exempt Solvent:	44.0%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	45.1%
Avg. Vol.% Water:	0.0%
Theoretical Coverage:	485 sq. ft. at 1 mil
Recommended Dry Film Thickness:	0.8 to 1 mil in 1 coat
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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