



FLEXIBLE PLASTICS REPAIR PROCEDURES FLOW CHART

OPTION A UNPRIMED	OPTION B UNPRIMED		FIBERGLASS	PRIMED	OEM FINISH	
ABS, CAB, CN, EP, MF, PA, PC, PE, PBTP, PETB, PT, PMMA, POM, PP, PPO, PL, PVC, SAN, BBB, PP-TPO, SMC, PUR, TPU, UP	Polyolefin or Nonpolycarbonate	ABS or Lexan® (Polycarbonate)	Fiberglass with gelcoat	Plastic or fiberglass	Flexible parts	
Pre-wash with warm water and 2310S™ Plastic Cleaning Paste using a gray or gold Scotchbrite™.	Wash with soap and hot water	Wash with soap and hot water	Wash with soap and hot water		Test with Basemaker® 7175S™. If primer lifts, remove primer and repair with Option A or B.	Wash with soap and hot water
Rinse thoroughly, making sure the 2310S™ Plastic Cleaning Paste does not dry on the surface.	Scrub Gray scuff pad & Plas-Stick® 2320S™ or A-2320S™	Scrub Gray scuff pad & Plas-Stick® 2319S™ or V-3921S™	Sand P500 grit sandpaper		If primer does not lift with 7175S™, sand with P500 grit sandpaper.	Sand P500 grit sandpaper
Wash again with warm water and 2310S™ Plastic Cleaning Paste using a gray or gold Scotchbrite™.	Clean with Plas-Stick® 2320S™ or A-2320S™	Clean with Plas-Stick® 2319S™ or V-3921S™ and wipe dry	Clean with Plas-Stick® 2319S™ or V-3921™ and wipe dry		Clean with Plas-Stick® 2319S™ or V-3921S™ and wipe dry.	Clean with A-3970S™, A-3990S™ 3909S™ or V-3921S™ and wipe dry
Rinse thoroughly, making sure the 2310S™ Cleaning Paste does not dry on the surface. Dry following the rinse.					Plas-Stick® 2330S™, A-2330S™, or 2332S™ for cut throughs only	
MAKE IT STICK with Plas-Stick® 2322S™, 2330S™, A-2330S™, 2332S™, or 234XS™ Adhesion Promoter		MAKE IT STICK with Plas-Stick® 234XS™ Adhesion Promoter				
APPLY FLEXED PRIMER OR SEALER Fill required: Use ChromaSystem™ primer-filler with the appropriate flexible additive No fill required: Use ChromaSystem™ primer-sealer with the appropriate flexible additive						
APPLY FLEXED SINGLE STAGE TOPCOAT, ACTIVATED CHROMASYSTEM™ BASECOAT OR CROMAX® PRO BASECOAT Flex ChromaSystem™ single stage topcoat with Plas-Stick® 2350S™ or V-2350S™ Flexible Additive or Plas-Stick® 2360S™ Flexible Matting Additive or apply MasterTint® Vinyl color.						
MAKE IT SHINE Gloss finish over basecoat: Any ChromaSystem™ clearcoat with Plas-Stick® 2350S™ or V-2350S™ Flexible Additive Matted finish over basecoat: For semi-gloss, eggshell or flat finish, use ChromaClear® 2370S™ Matted Clearcoat or ChromaSystem™ clearcoat with Cromax® 2363S™ Low VOC Matting Additive.						
Refer to ChromaSystem™ and ChromaSystem™ Low VOC Manuals for additional details. These directions refer to the use of products that may be restricted in VOC regulated areas. Follow usage instructions.						

In the United States:
1.855.6.AXALTA
cromax.us

In Canada:
1.800.668.6945
cromax.ca

