

FLA COE
FLB COE
FLD Conventional
Business Class

FLC 112 Conventional
> Century Class Conventional
> Argosy COE
Cargo

> Columbia
Coronado
Business Class M2
> Cascadia

**Freightliner
Service Bulletin**

Description of Revisions: *This bulletin replaces the version dated August 2004 . Cascadia has been added to the list of applicable vehicles, and General Instructions have been revised.*

General Information

Paint chips, due to normal wear and tear over time, may make it necessary to repaint plastic bumpers. Follow the procedure in this bulletin to repaint thermoplastic polyolefin (TPO) parts.

Plas-Stick® 2320S™ should only be used to clean thermoplastic polyolefin (TPO) parts. It is not an all-around plastic cleaner and may seriously damage ABS, PC, or PC/ABS.

The vehicle components this bulletin is addressing are *Cascadia, Columbia, Century Class, and Argosy bumper end caps, and Cascadia and Century Class center sections. Do not treat any other plastic components with the chemicals noted in this bulletin.*

Procedures

All plastic parts must be thoroughly cleaned and sanded as described, to ensure proper adhesion of the topcoat.

1. Clean the surface with a mild detergent and hot water.
2. Saturate the repair area with DuPont Plas-Stick® 2320S™ Plastics Cleaner, and continue to apply Plas-Stick 2320S while rubbing the wet surface with a clean cloth.

After 4 to 5 minutes, the surface should have no gloss, and it should not feel slick. If it does not feel slick, go to step 3. If gloss remains, reapply Plas-Stick 2320S as described above, and clean the surface with a mild detergent and hot water.

Saturate the substrate with Plas-Stick 2320S, and while keeping it wet, wipe it with a clean cloth until all surface gloss is removed and the surface is not slick.

IMPORTANT: It is crucial to clean the surface as described to get good adhesion.

3. Use gray Scotchbrite (or 800 grit sandpaper) to scuff the surface. Do not use 320 grit or red Scotchbrite, as they are too coarse and will rip the plastic surface.
4. Clean the surface again with Plas-Stick 2320S as described in Step 2, and repeat until the substrate is thoroughly clean.
5. Apply one medium coat of DuPont Plas-Stick® 2330S™ immediately after cleaning with Plas-Stick 2320S to guarantee adhesion.
6. Allow the DuPont Plas-Stick 2330S to dry 30 to 40 minutes before applying sealer. (See DuPont "Plastic Refinishing Chart," available from a local DuPont representative, for recommended sealers.)
7. Topcoat with DuPont Imron 5000/6000 or Imron Elite EA/EB.

Warranty

Warranty does not apply. This bulletin is for informational purposes only.