

Door Skin Bonding Guide



	Door Skin 30 # 1508	Panel 60 # 8007	Panel 90 # 8051
Work Time	30 minutes	60 minutes	90 minutes
Unclamp Time	1 1/2 - 2 hours or 10 minutes @180°F	4 hours at room temperature or 10-15 minutes @ 180°F	4 hours at room temperature or 10-15 minutes @ 180°F
Paint Time	2 hours	8 hours at room temperature or 10-15 minutes @ 180°F	8 hours at room temperature or 10-15 minutes @ 180°F

Introduction:

* All data taken at 23°C (74° F)

PLIOGRIP is a two-component cartridge system intended for use in secondary panel bonding (e.g., roof skins, door skins, quarter panels and rear body panels). This document is intended as a general guide for door skins to make a successful repair. For detailed guidelines, refer to the specific OEM repair procedure.

Panel Removal and Preparation:

1. Grind the outer edge of the door skin with an angle grinder.
2. Drill out factory spot welds.
3. Remove outer skin from door shell.
4. Remove remaining flange with an air chisel.
5. Straighten any damage to the flange with a hammer and dolly.
6. Grind the door shell flange to bare metal, removing all adhesive, paint, galvanized coating and e coats.
Note: Continue to grind until a constant flow of sparks is observed coming off the grinding disc to ensure all the galvanizing coating is being removed.
7. Dry fit for proper alignment.

cartridge upside down and strike the onto a hard surface, then remove. This will remove the top closure of the cartridge. Retain closure for storage after use or leave mixer on tube.

4. Properly place the cartridge into the gun. Prior to attaching the mixer, dispense a small amount of adhesive to ensure both sides flow evenly.
5. Attach mixer, and dispense out two inches for proper mix.
6. Apply a 1/4- bead of adhesive to bare metal door shell, then tool or brush the adhesive evenly, making sure to cover all surfaces of the bare metal. **Note: This eliminates exposed metal, which would be susceptible to corrosion.**
7. Align the new skin in place, and apply even pressure. After the panel has been positioned, do not pull it away from the shell. If repositioning is required, slide the panels against one another to ensure no air is trapped in the bond line.

Installing New Skin:

1. Scuff the inside of the door skin with a red scratch/scuff pad to remove the shiny surface of the e-coat.
2. Blow off with clean, dry air, and wipe with clean, dry rag.
3. Remove the "shipping cap" and discard. Turn the

8. Clamp tightly in place every 4 - 6 inches, then roll the hemmed flange

9. Tape off hem flange area and use Seam sealer 6, High Body 12, DTM 5/15 or Controlled Flow 6 to duplicate the factory look.

10. Prime and paint per paint manufacturer's recommendation.

IMPORTANT INFORMATION: Refer to the Material Safety Data Sheet (MSDS) for information on safety and handling before use. Ashland's cartridge system is sold as a kit, and performance has been verified using the kit content. Do not attempt to use other mixers in the application of this product. Additional mixers are available. This Repair Guide is incorporated as part of Bonding Solutions Recommendations for Use of PLIOGRIP. Failure to adhere to recommendations in this Repair Guide and the Instructions sold with the product voids the Lifetime Warranty.

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PLIOGRIP doc# 3003 rev. date 08/29/2017



Lit06 08/29/2017
