



## Class 6-8 Heavy Duty Truck SMC/Fiberglass Panel Bonding

Adhesive	Work Time	Clamp Time	Paint Time
Plastic Panel 3 (7773)	3.5 minutes	15-20 minutes	30 minutes
Plastic Panel 10 (7779)	10 minutes	45 minutes	60 minutes
Plastic Panel 35 (7770)	35 minutes	1.5 hours	2 hours
#5760 Epoxy	90 minutes	4 hours @ 74°F 10-15 minutes @ 180°F	8 hours @ 74°F or 30 minutes @ 180°F

**Introduction:** PLIOGRIP is a two-component, structural adhesive cartridge system intended for use in secondary plastic panel bonding (ex. SMC Class 8 truck hoods). This document is intended as a general guide to make a successful repair. For detailed guidelines, refer to the specific OEM repair procedure.

### **Panel Removal and Preparation**

1. Apply heat to the damaged panel with a heat gun or heat lamps. The panel needs to reach 300-350°F. Insert a chisel between panels and slowly separate the outer panel.
2. Once the panel has been removed, grind the inner structure of the vehicle to remove any remaining adhesive. If the vehicle has a steel inner structure, prime all bare metal with direct to metal primer (DTM) when using Plastic Panel 3, 10 or 35. **Note: Bare metal does not need to be primed if using SMC Repair; this product has corrosion resistant properties.**
3. Scuff the new panel with 80 grit sand paper. Blow off with clean dry air.
4. Scuff the SMC inner structure with 80 grit sand paper. If inner structure is primed metal, scuff with 220 grit sand paper.

### **Installing New Skin**

5. Dry-fit the new panel for proper alignment.
6. Remove the retaining cap from the adhesive and load into the gun. Dispense a small amount to be sure both sides flow evenly.
7. Attach mixer and dispense out two inches for proper mix.
8. Apply a 3/8–1/2 inch bead of adhesive to the new panel.
9. Position the replacement panel in place. After the panel has been positioned, **do not pull it away** from the vehicle. If repositioning is required, slide the panels against one another. This will ensure no air is trapped in the bondline.
10. Clamp firmly in place.
11. Allow adhesive to cure per recommendation at the top of the page.
12. Prime and paint per manufacturer's recommendation.

**General Information:** Refer to the MSDS document for information on safety and handling before use. Ashland's cartridge system is sold as a kit. Performance has been verified using the kit contents as supplied in certain dispense tools that are sold with the product. Do not attempt to use other static mixers or dispense guns in the application of this product. Additional mixers are available.