

Plastic Repair Guide

	Plastic Repair 1	Plastic Repair 3	Plastic Repair 10	Finishing Cream
Work Time	1 minute	3 minutes	10 minutes	3 minutes
Sand Time	10 minutes 3-4 minutes at 100/120°F	15-20 minutes or 3-4 minutes at 100/120°F	45-50 minutes or 5-6 minutes at 100/120°F	10-15 minutes 3-4 minutes at 100/120°F
Paint Time	15 Minutes	30 minutes	45 minutes	30 minutes

Introduction:

* All data taken at 23°C (74°)

PLIOGRIP by Valvoline Plastic Repair products are used for making undetectable repairs on TEO, TPO, PP, ABS and PUR bumpers and other types of plastic body parts.

Repair Preparation:

1. Clean the damage area using a prep solvent.
2. Prep the Class A damage area using 36- 50grit sanding discs on an angle grinder to open up the hole and round off the edges.
3. Round off damage edges with 80-grit sanding at low speed. Remove any melting on the surface. Surface appearance should have a dry fuzzy feel
Note: V grooving will cause a bull's-eye in the repair (see Illustration I).
4. Using an 80-grit sanding disc, sand the back side two inches larger than the damage area.
5. Blow off with clean, dry air. **Note: Do not use cleaners after the surface has been sanded.**
6. Apply a thin coat of PLIOGRIP by Valvoline Adhesion Promoter - TPS to both sides, and allow 5-10 minute flash.
7. Cut a piece of Bumper Reinforcing Mesh one inch larger than the damage area. Remove reinforcing mesh from plastic and apply to the back side.
8. Remove the cap of the adhesive cartridge by prying the uppermost slot with a flat screwdriver. The cap may be retained for future storage.
9. Properly place the cartridge into the gun. Prior to attaching the mixer, dispense a small amount of adhesive to ensure both sides flow evenly.
10. Attach mixer, and dispense two inches of adhesive for proper mixing.
11. Apply a Plastic Repair adhesive on the back side, about the size of the patch. Smooth out with spreader
12. Depending on work time, immediately apply adhesive to the front side, and level out.
Note: if adhesive from back side starts to set up on the outer surface, STOP, and allow to fully cure. After cured, scuff the adhesive surface with 80-grit sandpaper, blow off and re-apply Adhesion Promoter – TPS and Plastic Repair adhesive to the front side.
13. Allow adhesive to cure per recommendation.
14. Sand and level with 80-grit sandpaper, working from the middle out.

15. After leveling, switch to 180-grit sandpaper, and feather edge into the surface.
Finish with 220-320-grit sandpaper or finer. Wet sanding can be done, if desired.

Finishing Cream

Can be used for minor scratch, gouge or as a skim coat over the Plastic Repair adhesive.

PLIOGRIP by Valvoline Finishing Cream. **Note: DO NOT USE MIXER OR ADHESION PROMOTER**

1. Dispense onto mixing pallet, and mix by hand with a spreader until uniform green color is obtained.
2. Apply a thin layer to fill. Can be spread out to paint and blocked sanded. This eliminates the lifting of the raw plastic when priming
3. Allow 10-15 minutes to cure or heat cure @ 140F for 3 minutes and cool
4. Sand with 180-grit sandpaper and work finer. Prime and paint. Water borne primers can be used.
DO NOT USE POLYESTER BODY FILLER OR POLYESTER PRIMERS OVER FINISHING CREAM, This will result with soft uncured material.
5. Prime and paint per paint manufacturer's recommendation.

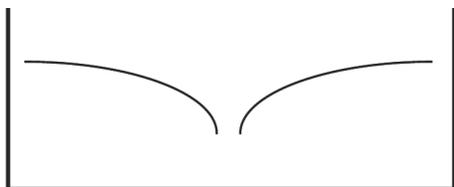
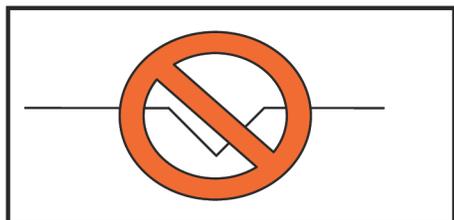


Illustration 2: V Groove Not Recommended



NOTE: If Bumper has been impacted and dented, lightly heat with a heat gun and work the back side to return to original contour. Cool plastic with cold water to hold shape. If this is not followed, the damage may show a bull's-eye in the repaired area after the bake cycle.

CAUTION: This product contains ingredients which could be harmful if mishandled. Contact with skin and eyes should be avoided, and necessary protective equipment and clothing should be worn. Do not breathe vapor or dust. Application of this product and all sanding activities should be performed in areas with adequate local exhaust ventilation, using ventilation equipment designed to reduce exposure to chemical vapors and dust.

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 Ashland's Recommendations for Use of PLIOGRIP by Valvoline products. Failure to adhere to recommendations in this Repair Guide and the Instructions sold with the product voids the Lifetime Warranty

1.800.PLIOGRIP www.PliogripbyValvoline.com

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