



Door Skin Bonding Guide

	Panel 60
Work Time	60 minutes
Handling Strength	4 hours at room temperature or 10-15 minutes @ 180°F
Paint Time	8 hours at room temperature or 25-30 minutes @ 180°F

* All data taken at 23°C (74° F)

Introduction:

PLIOGRIP by Valvoline Panel 60 is a two-component structural epoxy 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 to making 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.

Installing New Skin:

1. Scuff the inside of the door skin with a 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 cap of the adhesive cartridge by prying the uppermost slot with a flat screwdriver. The cap may be retained for future storage.
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- to 3/8-inch 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.
8. Clamp tightly in place every 4 - 6 inches, then roll the hemmed flange. **Note: Panel 60 panel adhesive incorporates glass bead technology to assure proper panel gap and prevents over-clamping.**

9. Tape off hemmed seam, and apply the same adhesive for seam sealing. This will allow the seam sealer to cure at the same time. Clamp times may be accelerated by use of a heat gun or lamp for 10-15 minutes at 180° F.
10. Prime and paint per paint manufacturer's recommendation.

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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