



Class 6-8 Heavy Duty Truck Metton[®] Repair Guide

	SMC Repair #8004 220ml/ #8032 400ml	Finishing Cream #8003 220ml
Work Time	60 minutes	3 minutes
Sand Time	4 hours or 10-15 min at 180°F	10-15 minutes
Paint Time	8 hours or 30 min at 180°F	30 minutes

* All data taken at 23°C (74° F)

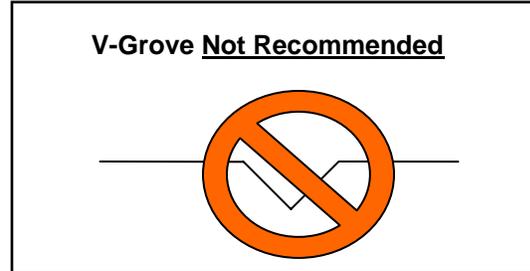
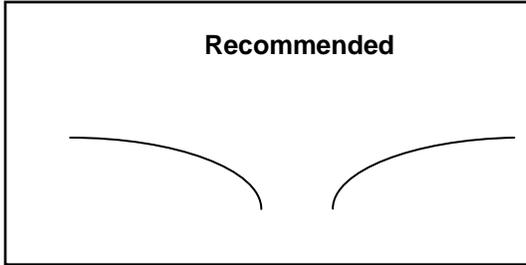
Introduction: PLIOGRIP by Valvoline epoxy repair systems may be used to produce undetectable repairs on Metton[®] and other DCPD type plastic found on hoods, bumpers, and side fairings. Techniques required on Metton are different that for other plastics and are described in this repair bulletin.

Procedure

1. Clean damage area using a prep solvent.
2. Prep damage area using 36 grit on an angle grinder, opening up the hole and rounding off edges.
3. Round off damage edges further with 80 grit at low speed, removing melted plastic on the surface. **Note: 'V' grooving will cause a bull's eye in the repair. See Illustration 1.**
4. Sand back side with 80 grit. Sand area two inches larger than the damage area.
5. Blow off with clean dry air. **Note: Do not use wax & grease remover after the surface has been sanded.**
6. Apply a thin coat of **Adhesion Promoter TP-S (stock# 8016)** to both sides and allow to flash for 5-10 minutes.
7. Cut a piece of **Fiberglass Reinforcing Cloth (stock# 8023)** that is 1 inch larger than damage area.
8. Remove the cap of the **SMC Repair adhesive (stock#8004 220ml or #8032 400ml)**. On the #8004 220ml size, pry the uppermost slot with a flat screwdriver. The cap may be used as a closure after use. If the #8032 400ml is used, remove the retaining ring and remove the screw-on cap.
9. Properly place the cartridge into the gun. Prior to attaching the mixer, dispense a small amount of adhesive to be sure both sides flow evenly.
10. Attach mixer and dispense out two inches for proper mix.
11. Apply a generous amount of SMC Repair adhesive on the back-side covering an area about the size of the patch. Press the pre-cut Fiberglass Reinforcing Cloth into the adhesive, pushing it down with a spreader and smoothing out. Apply a thin top coat of SMC Repair adhesive over top of the Fiberglass Reinforcing Cloth.
12. Apply SMC Repair adhesive to the class A side immediately following application to the back side patch, filling the damage area.
13. Allow adhesive to cure per recommendation.
14. Sand and level with 80 grit sandpaper, working from the middle out.
15. After level, switch to 180 grit sandpaper and feather edge into the surface. Finish with 220-320 grit or finer. Wet sanding is permissible if desired.
16. If a skim coat is needed, use **Finishing Cream (stock# 8003)**. **Note: adhesion promoter is not required for this step. Note: Static mixers are not used with Finishing Cream. Dispense onto mixing pallet and mix by hand with spreader.**
17. Allow Finishing Cream to cure for 10-15 minutes.

18. Sand with 180 grit and then finer grit as desired.
19. Prime and paint per paint manufacture's recommendation.
20. Preserve unused adhesive in cartridge by replacing the original cap.

Illustration 1:



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.

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