



Bed Side Panel Bonding Guide

	Panel 60 # 8007 - White	Panel 90 #8051- Black
Work Time	60 minutes	90 minute
Handling Strength	4 hours at room temperature or 10-15 minutes @ 180°F	4 hours at room temperature or 10-15 minutes @ 180°F
Paint Time	8 hours at room temperature or 25-30 minutes @ 180°F	8 hours at room temperature or 25-30 minutes @ 180°F

II data taken at 23°C (74° F)

Introduction:

PLIOGRIP Panel 60/90 is a two-component rubber toughened 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.

Note: only outer bed skins can be bonded. If the panel comes with the inner panel attached or goes into the floor, this has to be welded as this becomes a structural panel.

Panel Removal and Preparation:

1. Straighten any damage to vehicle prior to removing panels.
2. Remove large portions of the panel, making sure not to cut into the flanges.
3. Remove the outer welded flanges using a spot weld cutter tool.
4. Straighten any damage to the flanges with a hammer and dolly.
5. Scuff sand the e coat under the top rail. Wheel well, front plate and tail gate area grind to bare steel removing e coat and galvanizing coating. **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.**
6. Blow off both surfaces with clean, dry air. **Note: The rear post at the tailgate and the front plate need to be welded. These areas are considered structural.**
7. Pre-fit new bed side panel for proper alignment. **Note: Make sure suspension is loaded during pre-fit.**
8. Remove the part from the vehicle

Panel Installation:

1. Remove the cap of the adhesive cartridge by prying the uppermost slot with a flat screwdriver. The cap may be retained for future storage.
2. Properly place the cartridge into the gun. Prior to attaching the mixer, dispense a small amount of adhesive to ensure both sides flow evenly.
3. Attach mixer, and dispense two inches for proper mix.
4. Apply a 3/8- to 1/2-inch bead of adhesive to all areas to be bonded, then spread 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**
5. Align the new panel in place, and apply even pressure. After the panel has been positioned, do not pull away from the vehicle. If repositioning is required, slide the panels against one another to ensure no air is trapped in the bond line.

6. Clamp tightly in place every 4 - 6 inches. **Note: Panel 60/90 adhesive incorporates glass bead technology to assure proper panel gap and prevents over-clamping.**
7. Install welds in the front plate and the rear post.
8. Clamp a minimum of 4 hours at 23°C / 74°F. Longer clamp times may be necessary if lower temperatures are experienced. Clamp times may be accelerated by use of a heat gun or lamp for 10-15 minutes at 180° F.
9. Finish, sand and paint per paint manufacturer's recommendation.
10. For future use of the adhesive, remove cartridge from the gun and either leave on the mixer tip or replace the original cap.

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 Solution 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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