Class 6-8 Heavy Duty Truck
Metton® Repair Guide

	SMC/FRP #8004 220ml #8032 400ml	Door Skin 30 #1508	Finishing Cream 3 #8003 220ml	Finishing Cream 10 #8310 220ml
Work Time	60 minutes	30 minute	3 minutes	10 minutes
Sand Time	4 hr or 10-15 @180F	1.5 hr or 5-10 min @ 180F	10-15 min 3-5 min @ 180F	30 minutes or 5 min @180F
Paint Time	4hr or 10-15 min @ 180F	1.5 - 2hr or 15 min @180F	30 minutes	45 minutes

(#8007 Panel 60 and #8050 Panel 90 can also be used for repair)

* All data taken at 23°C (74° F)

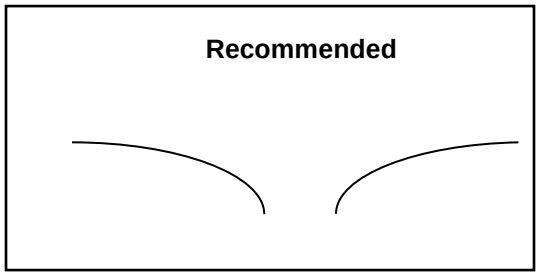
Introduction: PLIOGRIP repair systems may be used to produce undetectable repairs on Metton© and other DCPD type plastic found on hoods, bumpers, and side fairings. Techniques required on Metton© are different from other plastics and are described in this repair bulletin.

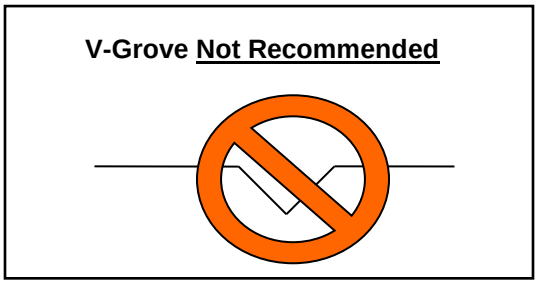
Procedure

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. Cut a piece of ***Fiberglass Reinforcing Cloth (stock# 8023/8022)*** that is 1 inch larger than damage area.
7. Remove the cap of the ***Repair adhesive from chart above.*** *P*ry 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.
8. 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.
9. Attach mixer and dispense out two inches for proper mix.
10. Apply a generous amount of 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 Repair adhesive over top of the Fiberglass Reinforcing Cloth.
11. Apply Repair adhesive to the Class A side immediately following application to the back-side patch, filling the damage area.
12. Allow adhesive to cure per recommendation.
13. Sand and level with 80 grit sandpaper, working from the middle out.
14. 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.
15. If a skim coat is needed, use ***Finishing Cream (stock# 8003/8310)***. **Note: adhesion promoter is not used for this step. Note: Static mixers are not used with Finishing Cream. Dispense onto mixing pallet and mix by hand with spreader. Note: Do not use Body Filler over Plastic repair 1,3,10 or Finishing Cream. This could cause blister. Body filler could be used over SMC repair adhesive for large repair areas.**
16. Allow Finishing Cream to cure for 10-15 minutes.
17. Sand with 180 grit and then finer grit as desired.

18. Prime and paint per paint manufacture's recommendation.
19. Preserve unused adhesive in cartridge by replacing the original cap.

Illustration 1:





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