

Roof Ditch Seam Sealing Guide



	DTM 15 Controlled Flow #8952	
Work Time	15 minutes	
Sand Time	N/A	
Paint Time	45 Minutes	

Introduction: Introducing the new high-performance 2-part urethane seam sealers from PLIOGRIP.

DTM 15 Control Flow is a higher-body flow-able product for roof ditches and puddle seams.

Allow PLIOGRIP 2K seam sealers to cure 1hr. for this application before painting.

Repair Preparation:

1. Clean and remove all dirt and corrosion from seamed area.
2. Prime bare metal with Epoxy primer. (Note: for roof seams DO NOT USE ACID ETCH PRIMERS) This area needs to be scuffed before sealer application and etch primers can expose bare metal when scuffed. Epoxy allows 220 grit scuff and good adhesion. **(Ford recommends Epoxy Primer)**
3. Allow primer to flash 1 hour before application of PLIOGRIP seam sealers. Application of the seam sealer before full cure of the primer may cause primer to fail to adhere to the metal. Heat may be used to accelerate cure of the primer if specified by the manufacturer of the primer. 180-220 grit scuff or red scuff pa. Blow off and wipe with clean rag. Do not use cleaner after sanding
4. Remove the cap of the adhesive cartridge by prying the uppermost slot with a flat screwdriver. The cap may be used to seal the cartridge after use.
5. Place the cartridge into the dispense gun. Prior to attaching the mixer, dispense a small amount of adhesive to ensure both sides are flowing evenly.
6. Attach mixer. Dispense a two inch bead to ensure proper mix.
TIP: Reduce air pockets in seam. Place end of mixer against card board on floor to plug end of mixer. Squeeze handle on gun forcing material to fill void in mixer. Lift gun and allow a silver dollar amount on card board. Release plunger pressure and start applying to seam
7. Apply seam sealer to seamed area. It is always better to start at the back of the seam and work towards the front windshield. Once you get a puddle started, keep the tip in puddle and push the puddle towards the front allowing sealer to flow to edges. As you come to the curvature of windshield slow down and let up on pressure. After you are at the curvature stop and allow to flow down. Most times it will flow to the outside edge. Pick up Mixer and flow in material while still wet to fill in voids. If needed use a pointed edge to remove any air bubbles in seam.
8. Allow seam sealer to cure as described in the table in these instructions. 1 hour
9. Prime and paint per paint manufacturer's recommendation

IMPORTANT INFORMATION: Ashland's cartridge system is sold as a kit, and performance has been verified using the kit contents. Do not attempt to use other static mixers in application of this product. This repair Guide is incorporated as part of Bonding Solution Recommendations for Use of PLIOGRIP 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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