

# SMC Bonding Guide



	<b>Plastic Panel 15</b> 7715 #8005 Green	<b>Plastic Panel 35</b> 7770/ #8006 Green 7770B, Black	<b>Panel 60</b> #8007	<b>Panel 90</b> #8051
<b>Work Time</b>	10-15 minutes	30-35 minutes	60 minutes	90 minutes
<b>Clamp Time/ Sand Time</b>	45 minutes	90 minutes	4 hours	4 hours
<b>Handling Strength</b>	45 minutes	90 minutes	4 hours at room temperature or 10-15 minutes @ 180°F	4 hours at room temperature or 10-15 minutes @ 180°F
<b>Paint Time</b>	90 minutes	2 hours	8 hours at room temperature or 25-30 minutes @ 180°F	8 hours at room temperature or 25-30 minutes @ 180°F

\* All data taken at 23°C (74° F)

## Introduction:

PLIOGRIP SMC bonding is a two-component structural adhesive cartridge system intended for use in secondary plastic panel bonding (e.g.. roof skin, door skin, quarter panel and body panel). Used on OEM Corvette bonding applications

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. Apply heat to the damaged panel with heat gun or heat lamps. The panel must reach 300°F. Insert a chisel between panels, and slowly separate the outer panel.
2. Once the panel has been removed, grind the inner structure of the vehicle to remove any remaining adhesive. If the vehicle has a steel inner structure, prime all bare metal with direct to metal (DTM) primer, when using Panel Bonder 15 or 35. **Note: Panel 60/90 does not require a primer on bare steel. This product has corrosion-resistant properties.**
3. Scuff the new panel with 80-grit sandpaper. Blow off with clean, dry air.
4. Scuff the SMC inner structure with 80-grit sandpaper, or 220-grit sand paper, if it is primed metal.

## Installing New Skin:

1. Dry-fit the new panel for proper alignment.
2. Remove the cap of the adhesive cartridge by prying the uppermost slot with a flat screwdriver. The cap may be retained for future storage.
3. Properly place the cartridge into the gun. Prior to attaching the mixer, dispense a small amount of adhesive to ensure both sides flow evenly.
4. Attach mixer, and dispense two inches of adhesive for proper mixing.
5. Apply a 3/8" – 1/2" bead of adhesive to the new panel.

6. Position panel in place. After the panel has been positioned, do not pull it away from the vehicle. If repositioning is required, slide the panels against one another. This will ensure no air is trapped in the bond line.
7. Clamp firmly in place.
8. Allow adhesive to cure per recommendation at the top of the page.
9. 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.

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**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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