

# Plastic Repair Guide



	Plastic Repair 1 #8049	Plastic Repair 3 #8001	Plastic Repair 10 #8002	Finishing Cream #8003/ 8310
<b>Work Time</b>	1 minute	3 minutes	10 minutes	3 minutes 10 Minute
<b>Sand Time</b>	10 minutes 3-4 minutes at 100/120°F	15-20 minutes <b>or</b> 3-4 minutes at 100/120°F	45-50 minutes <b>or</b> 5-6 minutes at 100/120°F	3/10-15 minutes 10/ 45 Minute 3-4 minutes at 100/120°F
<b>Paint Time</b>	15 Minutes	30 minutes	45 minutes	30 minutes 1 hour

## Introduction:

\* All data taken at 23°C (74° F)

PLIOGRIP Plastic Repair products are used for making undetectable repairs on TEO, TPO, PP, ABS and PUR bumpers and other types of plastic body parts. One product, repairs all plastics. You choose the work time. This new unique urethane technology allows for fast sand times, with no edge roll back. Adhesion promoter is required in order to get the adhesion into TPO, TEO, PP plastics.

## Repair Preparation:

1. Clean the damage area using a prep solvent.
2. Prep the Class A damage area using 36- 50grit sanding discs on an angle grinder to open up the hole and round off the edges.
3. Round off damage edges with 80-grit sanding at low speed. Remove any melting on the surface. Surface appearance should have a dry fuzzy feel  
**Note: V grooving will cause a bull's-eye in the repair (see Illustration I).**
4. Using an 80-grit sanding disc, sand the back side two- three inches larger than the damage area.
5. Blow off with clean, dry air. **Note: Do not use cleaners after the surface has been sanded.**
6. Apply a thin coat of PLIOGRIP Adhesion Promoter – TPS(#8016) to both sides, and allow 5-10 minute flash.
7. Cut a piece of Bumper Reinforcing Mesh one inch larger than the damage area. Remove reinforcing mesh from plastic and apply to the back side. Adhesive on screen will adhere it to the plastic
8. Remove the cap of the adhesive cartridge by prying the uppermost slot with a flat screwdriver. The cap may be retained for future storage.
9. Properly place the cartridge into the gun. Prior to attaching the mixer, dispense a small amount of adhesive to ensure both sides flow evenly.
10. Attach mixer, and dispense two inches of adhesive for proper mixing.
11. Apply a Plastic Repair adhesive on the back side, about the size of the patch. Smooth out with spreader
12. Depending on work time, immediately apply adhesive to the front side, and level out.  
**Note: if adhesive from back side starts to set up on the outer surface, STOP, and allow to fully cure. After cured, scuff the adhesive surface with 80-grit sandpaper to remove any shiny areas, blow off and re- apply Adhesion Promoter – TPS #8016 and Plastic Repair adhesive to the front side**
13. Allow adhesive to cure per recommendation. Heat gun or lamp can accelerate cure, 3 minutes at 180F
14. Sand and level with 80-grit sandpaper, working from the middle out.
15. After leveling, switch to 180-grit sandpaper, and feather edge into the surface.  
Finish with 220-320-grit sandpaper or finer. Wet sanding can be done, if desired.

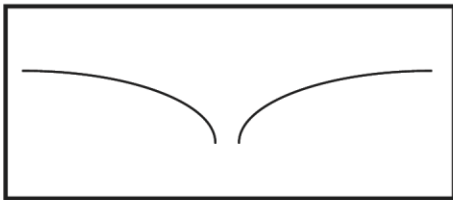
### **Finishing Cream**

Can be used for minor scratch, gouge or as a skim coat over the Plastic Repair adhesive.

PLIOGRIP Finishing Cream. **Note: Do Not use mixer or Adhesion Promoter**

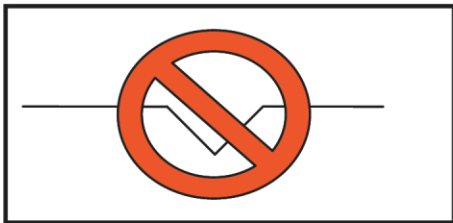
1. Prepare surface with 180 -220 grit scuff. Paint does not need to be removed. Blow off with clean dry air, no cleaners after sanding
2. Dispense onto mixing pallet, and mix by hand with a spreader until uniform green color is obtained.
3. Apply a thin layer to fill. Can be spread out to paint and blocked sanded. This eliminates the lifting of the raw plastic when priming
4. Allow 10-15 minutes to cure or heat cure @ 180F for 3 minutes and cool. Surface will get dull look to it
5. Sand with 180-grit sandpaper and work finer. Prime and paint. Water borne primers can be used
6. Prime and paint per paint manufacturer's recommendation.
7. For future use of the adhesive, replace the original cap.

### ***Illustration 1: Rounded Edges***



**NOTE: If Bumper has been impacted and dented, lightly heat with a heat gun and work the back side to return to original contour. Cool plastic with cold water to hold shape. If this is not followed, the damage may show a bull's-eye in the repaired area after the bake cycle.**

### ***Illustration 2: V Groove Not Recommended***



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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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PLIOGRIP doc# 3000 rev. date 08-30-2017



Lit01 8-30-2017

