

# Technical Datasheet

Ashland Specialty Ingredients



## PLIOGRIP™ 5770P Epoxy Adhesive System

Description	<p>PLIOGRIP Epoxy 5770P is a two-component, structural epoxy cartridge system intended for use in panel bonding. This document is intended as a general guide to making a successful repair. For detailed guidelines, refer to the specific OEM repair procedure.</p> <p>High body characteristics eliminate waste from the sag of mixed materials during application and assembly.</p> <p>Substrates must be prepared for optimum adhesive performance.</p>
General Information	<p>General Information: These 2:1 cartridges are available in convenient side by side delivery systems in 220 ml or 400 ml sizes. The larger chamber contains a purple epoxy based resin; the smaller side contains a beige catalyst system. Refer to the MSDS documents for additional information on safety and handling before use. Refer to Ashland's InfoTech Technical Data Sheet for product characteristics. Ashland's epoxy cartridge system is sold as a kit and performance has been verified using the kit contents. Do not attempt to use other mixers, for example, in the application of this product. Additional mixers are available.</p>
Procedures	<ol style="list-style-type: none"> <li>(1) Remove panel and with an abrasive disc, grind all paint and rust from the surfaces to be bonded using either a 36 grit for steel, or 80 grit for aluminum. Be sure to grind all target bonding areas to bare metal. When sectioning, the seam will need to be adequately beveled to assure a smooth transition to the existing panel to prevent ghost lines when painted.</li> <li>(2) Blow off all surfaces to be bonded with clean, dry air.</li> <li>(3) Straighten all metal; align parts and dry clamp in place to ensure proper fit.</li> <li>(4) Remove the part from the vehicle then clean all surfaces with a wax and grease remover and allow to dry.</li> <li>(5) Remove the cap of the adhesive cartridge by prying the uppermost slot with a flat screwdriver. The cap may be retained for future closure.</li> <li>(6) Properly place the cartridge into the gun. Prior to attaching the static mixer, dispense a small amount of adhesive to be sure both sides flow evenly.</li> <li>(7) Install the static mixer furnished with the PLIOGRIP 5770P kit (Ashland Part # 870115) shown actual size on the reverse side of this instruction sheet. There is no need to cut the tip due to the excellent flow characteristics of this product. Dispense 1" - 2" of material and dispose, observing for desired mix and consistency. NOTE: The green static mixers furnished with PLIOGRIP urethane products may not be used interchangeably with PLIOGRIP 5770P epoxy; the black mixer included and specified for use with 5770P epoxy is longer and is necessary to achieve proper mixing of the product. Use of the incorrect mixer voids the product warranty.</li> </ol>



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- (8) Apply a 3/8" - 1/2" bead of adhesive to both sides of all areas to be bonded then tool the adhesive evenly making sure to cover all surfaces of bare metal.
- (9) Align the parts to be bonded and apply even pressure. After the panel has been positioned, do not pull it from the vehicle. Instead, if repositioning is required, slide the panels against one another insuring no air is trapped in the bond line.
- (10) Clamp firmly in place. NOTE: Pliogrip 5770P panel bonding adhesive incorporates glass bead technology to assure proper adhesive gap, reducing problems encountered by over clamping.
- (11) Install screws or rivets in "hard to clamp" areas.
- (12) For future use of the adhesive, after removing from the gun, either leave the mixing tip on or replace the original cap, removed in Step 5 by aligning the circles and squares. Store the partially used for future use.
- (13) Tool the adhesive squeeze-out into the seam as you would with any traditional seam sealer.
- (14) Proceed with welding where required and in accordance with OEM recommendations. Exercise caution when welding as the adhesive can be combustible; we suggest welds to be at least 2 inches from the adhesive.
- (15) Clamp a minimum of 10 hours at 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.
- (16) Remove any adhesive from the sectioned area (if applicable). Additional grinding may be needed to ensure a smooth seam. Apply fiber-filled body filler, sand, and finish with conventional body filler. Allow proper dry time.
- (17) If painting, sand the cured adhesive with 320 grit sandpaper or scuff with a medium scuff pad to remove gloss from the surface.
- (18) Top coat adhesive following paint manufacturer's recommendations. NOTE: Because of the purple color priming may be required with some top coat colors (such as white) to ensure uniform coverage.
- (19) Apply sealers and/or anti-corrosion materials to the repair per manufacturers' recommendations. Finish, sand and paint vehicle as needed.
- (20) Vehicle may be returned to service after 24 hours.



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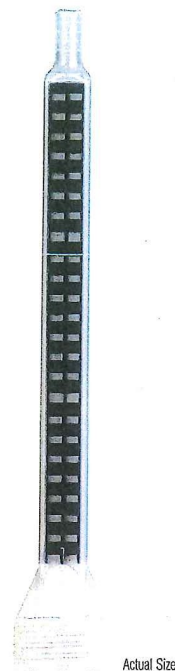
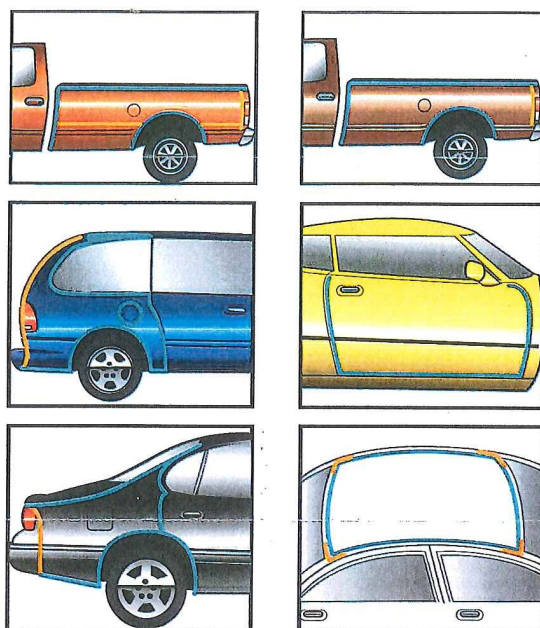
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Green = Adhesive Bonded Areas  
Orange = Suggested Welded Areas



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#### Notice

All information presented herein is believed to be accurate and reliable, and is solely for the user's consideration, investigation and verification. The information is not to be taken as an express or implied representation or warranty for which Ashland assumes legal responsibility. Any warranties, including warranties of merchantability, fitness for use or non-infringement of intellectual property rights of third parties, are herewith expressly excluded.

Since the user's product formulations, specific use applications and conditions of use are beyond the control of Ashland, Ashland makes no warranty or representation regarding the results which may be obtained by the user. It shall be the sole responsibility of the user to determine the suitability of any of the products mentioned for the user's specific application.

Ashland requests that the user reads, understands and complies with the information contained herein and the current Material Safety Data Sheet.

#### More information

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