

A two part non structural epoxy adhesive filler and surfacer designed to repair and bond flexible materials in a few minutes. It resists gasoline, acid and solvents. Excellent performance when used as a skim coat over structural adhesive. For bonding, repairing or as a finishing skim coat on Plastics, SMC, Metals, Aluminum and Fiberglass. Use 17904, 17906 or 17914 replacement nozzle.

**PRODUCT****SIZE****16340**

6.8 fl oz (200 ml)

**16342**

13.5 fl oz (400 ml)

**READ ALL INSTRUCTIONS AND SAFETY PROCEDURES PRIOR TO USING!****IMPORTANT! This product contains hazardous materials.**

Proper protective equipment should be used at all times. Please consult labels on each product as well as the safety data sheet for complete safe handling procedures and personal protection information.

**NOTE: TEST ON A HIDDEN AREA BEFORE USING TO MAKE SURE THE PRODUCT PERFORMS TO YOUR SATISFACTION.**

**SUITABLE SUBSTRATES:**

- Metal
- Aluminum
- Fiberglass
- Plastics
- Glass
- Wood

**ADVANTAGES:**

- 100 % solids
- No shrinkage
- Can be baked
- Can be painted
- No pinholes, no cracking
- Excellent sandability
- Ideal for SMC and FRP

**DIRECTIONS FOR USE:**

**Important:** SMC/FRP must be thoroughly dry before proceeding. In case of any doubt, heat surface gently using a heat gun. Do not overheat. For best results, use when temperature of the product and the surface is between 70°F and 75°F (21°C and 24°C).

1. You must first determine if the substrate is of the TPO family. Use a die grinder on the back side of the part and lightly grind. If it is of the TPO family, it will melt or smear. Use 16158 or 16152 TPO Adhesion Promoter

at step #5. If it powders the substrate is not TPO. Do not use adhesion promoter, skip step #5.

2. Using a clean cloth, clean metal with 13524 Wax and Grease Remover, plastic and SMC with 19040 Plastic Parts Cleaner.
3. Sand surface to be repaired inside and outside to remove paint and protective film. Low revolution sanding is very important. Soften edge with a die grinder at low speed to create a "V" groove.
4. Use a clean dry air source to blow debris from the surface. At this point, do not use solvent or cleaner.
5. If TPO (see step #1) apply 16158 or 16152 TPO Adhesion Promoter to the entire sanded area. Do not apply adhesion promoter onto the exposed adhesive. Allow 10 minutes flash time but not more than 15 minutes before you proceed with the repair.
6. If needed, you can reinforce material by using 17920 Nylon Reinforcing Tape or 17924 Structural Backing Patch.
7. Load cartridge into the gun and purge as per instructions.
8. Apply a first thin coat of 2 part epoxy. Use a plastic spreader to even the product. Let dry for 15 minutes. Sand with 80 grit sandpaper at low speed to remove the glossy film. Continue building with subsequent coats until repair is complete. Make sure to let each coat dry for 15 to 20 minutes before re-coating.
9. Let dry completely (approximately 20 minutes).
10. Sand with an 80 grit sandpaper (low speed). Let dry another 20 minutes.
11. Finish sanding with 180 grit paper then 280 grit and finish with 320 grit sandpaper.
12. Use a clean dry air source to blow debris from the surface.
13. You can now proceed to prime the surface with a high quality non-lacquer based primer.

**Note:**

- Sanding and grinding at low speed will prevent plastic from hardening due to oil loss.
- Under normal shop conditions, this product can be sanded in 20 to 25 minutes and painted in 45 minutes. Full cure of the repair could take as long as 24 hours.
- All drying times refer to shop temperature of 68°F (20°C) / 50° humidity. Drying of this product can be accelerated with heat.

**TECHNICAL DATA:**

	<b>16340, 16342 Part A</b>	<b>16340, 16342 Part B</b>
<b>Physical State</b>	Paste	Paste
<b>Color:</b>	Blue	Light grey
<b>Odour:</b>	Sweet odour	Sweet odour
<b>Solubility :</b>	2.82%	Insoluble
<b>Flash point:</b>	> 149°C / > 300.2°F (Closed cup)	> 93°C / > 199.4°F
<b>Auto ignition temperature:</b>	Not available	Not available

**PRECAUTIONARY INFORMATION**

Refer to product label and Safety Data Sheet for health and safety information before using this product.

**SAFETY CONSIDERATION**

Safety Data Sheets are available at [www.proformproducts.com](http://www.proformproducts.com) or upon request at [info@proformproducts.com](mailto:info@proformproducts.com). These are provided to help our customers satisfy their own handling, safety and disposal needs, and those required by local applicable health and safety regulations. Our Safety data sheets are updated regularly, therefore, please review the most current Safety Data Sheet before handling or using any product.

**TECHNICAL INFORMATION**

The technical information, recommendations and other statements contained in this document are based upon tests or experience that Pro Form believes are reliable, but the accuracy or completeness of such information is not guaranteed.

**PRODUCT USE**

Many factors beyond Pro Form's control and uniquely within user's knowledge and control can affect the use and performance of a Pro Form product in a particular application. Given the variety of factors that can affect the use and performance of a Pro Form product, user is solely responsible for evaluating the Pro Form product and determining whether it is fit for a particular purpose and suitable for user's method of application.

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