

Superior 2:1 epoxy adhesive designed to bond steel, aluminum, SMC and fiberglass body panels. It seals and bonds in one application and prevents corrosion and warping caused by welding. Longer work time to allow adequate adjusting and handling. The glass beads mixed in this formulation provide the adequate spacing between parts for optimal bond strength. Use PF 609N, PF 613N, PF 613N-5 replacement nozzle. (24 elements).

PRODUCT	SIZE	WORK TIME
PF 7115	220 ml (7.4 fl oz)	90 minutes
PF 7116	220 ml (7.4 fl oz)	30 minutes
PF 7117	220 ml (7.4 fl oz)	60 minutes

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:

- Quarter panels
- Door skins
- Roofs
- Other body sheet metal
- Bonds steel
- Aluminum
- SMC/FRP

FEATURES:

- No welds needed Spot weld or Rivet-bonded
- No VOC
- Meets OEM recommendations
- Lifetime warranty, lifetime corrosion protection
- Where ever OEM recommends

DIRECTIONS FOR USE:

*70°F (21°C)	PF 7115	PF 7116	PF 7117
Working Time:	90 minutes	30 minutes	60 minutes
Clamp Time/Handling Strength (R/T):	4 hours	2 hours	4 hours
Paint Time:	8 hours	4 hours	8 hours
Heat Cure (82°C)	15 minutes	10-15 minutes	15 minutes

Read carefully instructions sheet included before proceeding.

1. Remove plastic lid protector. Open cartridge by breaking off the tip with a flat screwdriver removing both plugs.

2. Place cartridge into channels on dispensing gun.
3. Work trigger until both plungers are snug against bottom plugs. Pre-dispense 5 cm (2") of product making sure both sides are equalized and color of the product is uniform. Dispose of this material.
4. Attach mixing nozzle to cartridge and apply product. When application is completed, do not remove mixing nozzle. Store for future use.
5. Always check for any solids build up in the area of cartridge head/nozzle, if contaminants are visible, change nozzle.
6. Use a new mixing nozzle when re-used. Always use applicator gun and mixing nozzle to mix material. Do not mix by hand.
7. Store cartridges at temperature between 18°C to 35°C (65°F to 95°F).

Secondary Aluminum/Metal Panels:

1. Drill out spot welds with spot weld drill cutter.
2. Remove damage quarter with air chisel.
3. Straighten flanges with hammer and dolly.
4. Grind all mating flanges to bare metal with 36 grit to remove all e-coat, rust and galvanizing coatings. Note: 80 grit sand for any aluminum panels.
5. Pre-fit new panel with suspension loaded.
6. Remove retaining cap from the adhesive and load into the gun and dispense out a small amount to be sure both sides are level.
7. Attach mixer and dispense out two inches for proper mix.
8. Apply 3/8" bead to the new panel and the inner structure. Smooth out adhesive with spreader making sure all bare metal is covered. Dispense another 3/8" bead to the new panel.
9. Align new panel in place and apply even pressure. After panel has been position, do not pull it from the vehicle. If repositioning is required, slide the panels against one another.
10. Clamp firmly in place, Note: Pliogrip metal adhesives incorporate glass bead technology to assure proper bond-line thickness.
11. Place screws or rivets in hard to clamp areas.
12. Remove any adhesive from sectioning join.
13. Clamp for recommended time @ 23°C (70°F).
14. Clamp time can be accelerated with heat at 82°C (180°F) for 15 minutes.

Aluminum/Steel Structural Preparation:

1. Clean surface with wax and grease remover.
2. 80 grit scuff bond area removing e-coat or any paint. Note: 36 Grit grind steel to remove paint, e-coat and galvanizing.
3. Blow surface with clean dry air.
4. Pre fit part for alignment, if rivet bonding drill holes where needed. Self-piecing: Locate and mark area where rivets will be placed.
5. Remove part and apply a 3/8" bead to both mated surfaces and spread smooth with a spreader.
6. Apply a second bead of adhesive if required. There must be at least 1/32" of adhesive between the two panels when joined. Do not over clamp.

7. Mate the parts and clamp.
8. You can rivet or compression resistant spot weld wet or dry.
9. Allow part to set per recommendation above.

TECHNICAL DATA:

	Part A		
	PF 7115	PF 7116	PF 7117
Physical State:	Viscous liquid	Liquid	Viscous liquid
Color:	Black	Tan	Black
Odour:	No data	No data	No data
Solubility:	Practically insoluble in water	No data	Practically insoluble in water
Flash point:	>99°C (>210°F) Setaflash Closed Cup	>100°C (>212°F)	>99°C (>210°F) Setaflash Closed Cup
Auto ignition temperature:	No data	No data	Not available
VOC:	No data	No data	2.55 lbs/usg • 305.57 g/L

	Part B		
	PF 7115	PF 7116	PF 7117
Physical State:	Viscous liquid	Liquid	Viscous liquid
Color:	Tan	Black	Tan
Odour:	Very faint, amine-like	No data	Very faint, amine-like
Solubility:	Insoluble in water	No data	Insoluble in water
Flash point:	>93.4°C (>200°F)	>100°C (>212°F)	>93.4°C (>200°F)
Auto ignition temperature:	No data	No data	No data
VOC:	No data	No data	No data

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 or upon request at 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 Data Sheet

Pliogrip® Epoxy Panel Bonder

PF 7115, PF 7116, PF 7117

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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