

Two part Urethane Structural Adhesives are designed to bond and repair all plastics, fiberglass, SMC, metal and glass. Use PF 604N, PF 611N or PF 611N-5 replacement nozzle (17 or 18 elements).

| PRODUCT | SIZE | WORK TIME |
|---------|--------------------|-------------|
| PF 7770 | 220 ml (7.4 fl oz) | 35 minutes |
| PF 7771 | 220 ml (7.4 fl oz) | 1 minute |
| PF 7773 | 220 ml (7.4 fl oz) | 3.5 minutes |
| PF 7775 | 220 ml (7.4 fl oz) | 30 seconds |
| PF 7779 | 220 ml (7.4 fl oz) | 10 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:

- Plastics
- Fibreglass
- SMC
- Metal
- Glass
- Wood

FEATURES:

- Fast cure
- Flexible
- Easy to tool out
- Sands easily
- No shrinkage
- Excellent paint adhesion
- Lifetime warranty

DIRECTIONS FOR USE:

| * 21°C (70°F) | PF 7770 | PF 7771 | PF 7773 | PF 7775 | PF 7779 |
|----------------------|------------|------------|---------------|------------|------------|
| Open Time: | 35 minutes | 1 minute | 3.5 minutes | 45 seconds | 10 minutes |
| Working Time: | 35 minutes | 1 minute | 3.5 minutes | 60 seconds | 10 minutes |
| Sanding Time: | 1.5 hours | 10 minutes | 15-20 minutes | 6 minutes | 45 minutes |
| Clamp Time: | 2 hours | 15 minutes | 30 minutes | 4 minutes | 60 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).

PLASTIC STRUCTURAL REPAIR

Repair Procedure:

1. Clean the damage area using a prep solvent.
2. Prep the Class A damage area using 36-50 grit sanding discs on 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.
4. Using an 80-grit sanding disc, sand the back side 2-3 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 Adhesion Promoter, allow 5-10 minute flash.
7. Cut Bumper Reinforcing Mesh one inch larger than the damage area. Remove reinforcing mesh from plastic and apply to the back side.
8. Remove the cap of the adhesive cartridge by prying the uppermost slot with a flat screwdriver.
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. 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. Use finishing cream for final skim coat.

PLASTIC PANEL REPAIR

Panel Preparation:

1. Vehicle should be at room temperature before beginning any repair. Applying heat to the damage area will ensure all moisture is out of the fibers.
2. Use wax and grease remover before sanding the repair area. **Note:** Do not allow solvent to absorb into fibers.
3. Sand the back side with 80-grit sandpaper. Blow off with clean, dry air.
4. Grind the front side, and open up the damage area. Round off the edges about one inch beyond the cracked area (see Illustration 1).
5. Blow off with clean, dry air.

Backer Patch:

1. Cut a piece of Fiberglass Reinforcing Cloth 1 inch larger than the damage area.
2. Place a piece of masking tape over the front side of repair area.

3. Remove the cap of the adhesive cartridge by prying the uppermost slot with a flat screwdriver. The cap may be retained for future storage.
4. Properly place the cartridge into the gun. Dispense a small amount of adhesive to ensure both sides flow evenly. Dispense the proper amount onto a mix pallet and mix by hand with a spreader.
5. Apply a generous amount of adhesive to the back side, and spread out smooth. Lay the pre-cut fiber reinforcement onto the adhesive and saturate with a spreader. Once smoother out, apply a thin top coat, and spread smooth.
6. Apply heat with a heat gun or heat lamp for 10-15 minutes at 180°F.

Cosmetic / Class A Side:

1. Remove the tape from the front side, and sand out any of the adhesive, tapering into the backing patch.
2. Build a pyramid reinforcing patch on the front side with a minimum of two to three layers. This step is very important as the repair area needs to simulate the original panel for expansion and contraction. This will eliminate halos and bull's eyes.
3. Cut the first piece slightly smaller than outer edge of the repair area. The next two pieces need to be smaller than the first.
4. Apply a thin coat of adhesive to the repair area. Lay the smallest piece on first, and saturate with a spreader, making sure no air is trapped between the cloths. Next, apply another thin coat of adhesive, and lay the next larger piece in, and follow with largest piece. Apply a final top coat, and smooth out.
5. Apply heat with heat gun or heat lamp at 180°F for 10 minutes. Allow to cool.
6. Sand with 80-grit sandpaper, cutting slightly lower than the surface of the panel.
7. Apply a final coat for finishing cream and feather out into panel.
8. Apply a heat lamp for 30 minutes at 180°F. This will prevent shrinkage after paint bake.
9. Allow to cool, and sand with 80-grit sandpaper, working finer.

TECHNICAL DATA :

| | PF 7770, PF 7771, PF 7773, PF 7775, PF 7779 | |
|-----------------------------------|--|--------------------|
| | Part A | Part B |
| Physical State | Viscous liquid | |
| Color: | Beige | Green |
| Odour: | No data | No data |
| Solubility : | Practically insoluble in water | Insoluble in water |
| Flash point: | >100°C (>212°F) | >93.4°C (200°F) |
| Auto ignition temperature: | Not available | Not available |
| VOC: | 2.55 lb/USG - 305.57 g/L | 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 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.

WARRANTY, LIMITED REMEDY, DISCLAIMER AND LIMITATION OF LIABILITY

Pro Form Products Ltd. ("Pro Form") makes no warranty, either express or implied, and specifically excludes any implied warranties or conditions of quality, whether of merchantability, fitness or otherwise. On any claim, irrespective of the legal theory invoked, Pro Form's total liability shall not exceed the purchase price of the product. At its option, Pro Form may instead replace or repair the product. In no event shall Pro Form be liable for any damages of any type, or for loss. 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.