



**PLIOGRIP® 7779/50  
PLIOGRIP® 7779/220  
PLIOGRIP® 7779/660  
CARTRIDGE ADHESIVE SYSTEM**

Last Revision Date: September 2006

PLIOGRIP® 7700 cartridge adhesive systems are high performance, two-component polyurethane adhesives packaged in 25ml by 25 ml (50ml nominal yield), 110ml by 110ml (220ml nominal yield) or 330ml by 330ml (660ml nominal yield), side-by-side cartridges.

PLIOGRIP 7700 series adhesives are high-strength, structural adhesives which are resistant to exposure to elevated temperatures, moisture, fuel, most solvents and chemicals.

The adhesive systems are tested using stringent performance specifications of all major domestic automotive manufacturers and heavy truck producers. They have been designed for ease of dispense with a hand-held, pump action gun.

PLIOGRIP 7779 Adhesive Systems are the intermediate cure profile products in the series. The 10 minute working time allows ample time for application and bonding, yet is easy to sand in about an hour without heat. With heat enhancement, cure times can be accelerated.

## NOMINAL COMPONENT PROPERTIES

|   | <b>PLIOGRIP 7700<br/>Prepolymer</b> | <b>PLIOGRIP 7779<br/>Curative</b> |
|---|-------------------------------------|-----------------------------------|
| <b>Color</b>                                | Tan                                 | Green                             |
| <b>Viscosity, cP</b>                        | 14,500                              | 20,500                            |
| <b>Density, Lbs/Gal. (g/cm<sup>3</sup>)</b> | 10.82 (1.30)                        | 10.25 (1.23)                      |

## TYPICAL CURE CHARACTERISTICS OF MIXED ADHESIVE

|                     |               |               |
|---------------------|---------------|---------------|
| <b>Open Time</b>    | @ 23°C (73°F) | 10 Minutes    |
| <b>Working Time</b> | @ 23°C (73°F) | 17 Minutes    |
| <b>Sanding Time</b> | @ 23°C (73°F) | 60 Minutes    |
| <b>Clamp Time</b>   | @ 23°C (73°F) | 30 Minutes    |
| <b>Shrinkage, %</b> |               | Imperceptible |

## TYPICAL PHYSICAL PROPERTIES OF CURED ADHESIVE

(1 MPa = approximately 145 psi)

|                                    | <i>Test Method</i> | <b>Value</b> |
|------------------------------------|--------------------|--------------|
| <b>Tensile, MPa @ 23°C</b>         | ASTM D-638         | 29           |
| <b>Young's Modulus, MPa @ 23°C</b> | ASTM D-638         | 1184         |
| <b>Elongation, %</b>               | ASTM D-638         | 63           |
| <b>Water Absorption, %</b>         | ASTM D-570         | <1.5         |

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**TYPICAL USE INSTRUCTIONS**

|                            |   |
|----------------------------|---|
| <b>Adhesive System</b>     | PLIOGRIP® 7779/50, 7779/220 and 7779/660 adhesive                 |
| <b>Substrate</b>           | Structural Plastics including Automotive and Marine; Coated Metal |
| <b>Surface Preparation</b> | Plastics – Sand and Clean / Metal – Coated or Primed              |
| <b>Fixture Cure</b>        | Room Temperature  |

**HANDLING**

PLIOGRIP 7779/50, PLIOGRIP 7779/220 and PLIOGRIP 7779/660 adhesives contain ingredients which could be harmful if improperly handled. Contact with skin and eyes should be avoided and necessary protective equipment and clothing should be worn.

Ashland maintains Material Safety Data Sheets on all of its products. Material Safety Data Sheets contain health and safety information for your development of appropriate product handling procedures to protect your employees and customers.

Our Material Safety Data Sheets should be read and understood by all of your supervisory personnel and employees before using Ashland products in your facility.

|                                | <b>PLIOGRIP 7779/50<br/>ADHESIVE</b>  | <b>PLIOGRIP 7779/220<br/>ADHESIVE</b>  | <b>PLIOGRIP 7779/660<br/>ADHESIVE</b>   |
|--------------------------------|---|--|---|
| <b>STORAGE:</b>                | Unopened container stored indoors at 60°-90°F (15°-32°C)  | Unopened container stored indoors at 60°-90°F (15°-32°C)   | Unopened container stored indoors at 60°-90°F (15°-32°C)  |
| <b>SHELF LIFE:</b>             | 2 Years   | 2 Years  | 2 Years   |
| <b>PACKAGING:</b>              | PLIOGRIP® 7779/50 adhesive is packaged in 25ml by 25ml side-by-side cartridges for use with a hand-held dispensing gun. | PLIOGRIP® 7779/220 adhesive is packaged in 110ml by 110ml side-by-side cartridges for use with a hand-held dispensing gun. | PLIOGRIP® 7779/660 adhesive is packaged in 330ml by 330ml side-by-side cartridges for use with a hand-held pneumatic gun. |
| <b>PRODUCT CODE:</b>           | 583918  | 583567   | 583318  |
| <b>DOT LABEL REQUIREMENTS:</b> | None Required   | None Required  | None Required   |