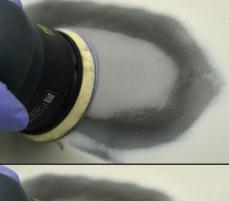


Two-Sided Bumper Repair

Cracks, Holes & Punctures

1		Clean the Damaged Area Clean the front and back of the repair area with soap and water, followed by a VOC compliant surface cleaner.
2		Prepare for Reinforcement Material Apply aluminum autobody repair tape to the front side of the repair to align and secure the damage while the back side reinforcement is being completed. On the back side, use a DA with grade 80 abrasive disc to sand the repair area where the reinforcement patch will be applied. Blow off with clean, dry air and apply adhesion promoter, allowing 10 minutes to dry.
3		Apply Reinforcement Material Apply alternating applications of thin, wet coats of semi-rigid plastic repair material and reinforcement cloth on the damaged area. Allow dry time of 15 minutes at 75°F.
4		Tapering the Front Side Remove the aluminum tape. Grind the front damage using a grade 36 file belt at a low speed to create a gradual "Dish Out" area 3 in. wide and deep enough to expose a 1/4-inch wide strip of the back side reinforcement material through the center of the damage.
5		Preparing the Repair Area Use a 3 in. DA with grade 80 abrasive disc to create a smooth transition into the dished area, remove any melted plastic and create a fuzzy surface for the adhesive. No shiny plastic areas should remain. Abrade with grade 180 around the dished out area where the adhesive will eventually be featheredged.
6		Mix and Apply Flexible Filler Blow off the front side repair area with clean dry air, apply aerosol adhesion promoter and allow to dry for 10 minutes. Mix and apply flexible filler material with an initial "tight coat" immediately followed by additional coats to fill in all low areas. Allow 15 minutes to cure at 75°F.
7		Sand Flexible Filler DA sand flexible repair material with grade 80 disc to roughly shape, staying on top of the flexible repair material only. Block sand the repair area with grade 180 sheet to finish shaping and featheredging the repair.
8		Final Sand and Inspect Use a DA sander to finish sand the repair area using grade 320 abrasive disc. Blow off and inspect the repair quality. Repeat steps 6 and 7 as necessary.

Visit 3MCollision.com for more SOPs and videos

Product List

3M™ Cubitron™ II Hookit™
Clean Sanding Abrasive Disc,
3 in., grade 80+, PN 31361;
3 in., grade 180+, PN 31364;
3 in., grade 320+, PN 31463;
6 in., grade 80+, PN 31371;
6 in., grade 180+, PN 31374;
6 in., grade 320+, PN 31483



3M™ Semi-Rigid Plastic
Repair Material, 200mL
cartridge, PN 04240



3M™ Reinforcement
Patch, 5 in. x 12 ft. roll,
PN 04904



3M™ File Belt Sander,
18 in., PN 33575



3M™ Cubitron™ II File Belt,
grade 36+, PN 33443



3M™ Polyolefin Adhesion
Promoter, 12 oz. aerosol,
PN 05907



3M™ EZ Sand Multi-Purpose
Repair Material,
200mL, PN 05887;
600mL DMS, PN 55887



3M™ Performance
Manual Applicator,
200mL, PN 08117



3M™ Dynamic Mixing
Applicator — Pneumatic,
PN 05846



Think About Your Health

3M™ E-A-R™ Skull Screws™
Ear Plug, PN P1300



3M™ Half Facepiece
Respirator, PN 07182



3M™ Virtua™ Protective
Eyewear, PN 11326



Note: We do not recommend a final coat of 3M™ Polyolefin Adhesion Promoter (PN 05907) after the final sanding. The paint companies all recommend their own paint adhesion promoters and applying the PN 05907 may cause a compatibility issue.

Individual Product Instruction and Safety Information

For individual product instructions and applicable precautions see product labels and associated literature for the individual product at **3MCollision.com**

For product material safety data sheets see **3MCollision.com**

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