

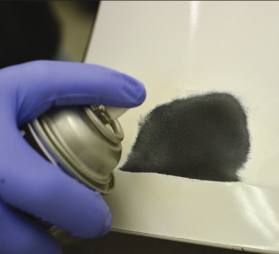
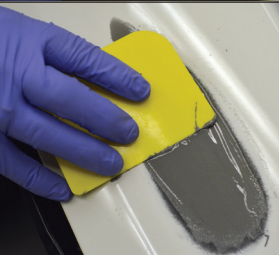
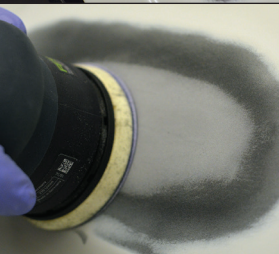
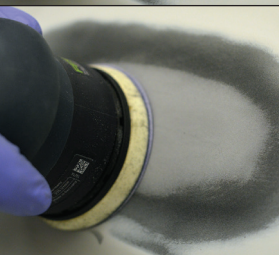


Cosmetic Flexible Bumper Repair Scrapes, Gouges and Deformations		
1		<p>Clean the Damaged Area Clean the repair area with soap and water, followed by a VOC compliant surface cleaner.</p>
2		<p>Initial Prep Sand “Dish Out” the damaged area using a grade 80 abrasive disc on a 3 in. DA sander. Keep the grade 80 abrasive scratches within the “Dish Out” area. DA sand with grade 180 abrasive to “feather” the repair area 2–3 in. from the “Dish Out” area.</p>
3		<p>Apply Adhesion Promoter Blow off the repair area with clean, dry air. Apply aerosol adhesion promoter, allowing to dry for 10 minutes. Always apply adhesion promoter before any filler material.</p>
4		<p>Mix and Apply Flexible Filler Mix and apply flexible filler with a “tight coat,” followed by additional coats to fill in all low areas. Allow to cure for 15 minutes at 75°F.</p>
5		<p>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.</p>
6		<p>Final Sand and Inspect Finish sand the repair and the surrounding area using a grade 320 abrasive disc. Blow off and inspect the repair for quality. Repeat steps 3, 4 and 5 as necessary.</p>

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™ 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



3M™ Cubitron™ II Hookit™ Clean Sanding Sheet Roll, 70mm x 12m, grade 180+, PN 34446



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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