







Cosmetic Flexible Bumper Repair Scrapes, Gouges and Deformations		
1		<p>Clean the Damaged Area</p> <p>Clean the repair area with soap and water, followed by a VOC compliant surface cleaner.</p>
2		<p>Initial Prep Sand</p> <p>“Dish Out” the damaged area using a P80 abrasive disc on a DA sander. Keep the P80 abrasive scratches within the “Dish Out” area. Use a DA sander with P180 abrasive to “feather” the repair area 2–3 in. from the “Dish Out” area.</p>
3		<p>Apply Adhesion Promoter</p> <p>Blow off the repair area with clean, dry air. Apply aerosol adhesion promoter, allowing to dry 5–10 minutes. Always apply adhesion promoter before any filler material.</p>
4		<p>Mix and Apply Flexible Filler</p> <p>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</p> <p>Hand block or DA sand flexible repair material with a P150 disc or sheet, followed by a P180 disc or sheet.</p>
6		<p>Final Sand and Inspect</p> <p>Finish sand the repair and the surrounding area using a P320 abrasive disc. Blow off and inspect the repair for quality. Repeat steps 3, 4 and 5 as necessary.</p>
<p>Visit www.3MCollision.com for more SOPs and videos</p>		

Product List	
<p>3M™ Purple Clean Sanding Hookit™ Disc, 3 in., P320, PN 30275 6 in., P320, PN 01812</p>	
<p>3M™ Cubitron™ II Clean Sanding Hookit™ Abrasive Disc, 3 in, 80+, PN 31361 3 in, 150+, PN 31363 3 in, 180+, PN 31364 6 in, 80+, PN 31371 6 in, 150+, PN 31373 6 in, 180+, PN 31374</p>	
<p>3M™ Cubitron™ II Hookit™ Clean Sanding Sheet Roll, 70mm x 12m, 150+ grade, PN 34445; 180+ grade, PN 34446</p>	
<p>3M™ Polyolefin Adhesion Promoter, 12 oz. aerosol, PN 05907</p>	
<p>3M™ EZ Sand Multi-Purpose Flexible Adhesive, 200mL, PN 05887; 600mL DMS, PN 55887</p>	
<p>3M™ Performance Manual Applicator, 200mL, PN 08117</p>	

Think About Your Health	
<p>3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300</p>	
<p>3M™ Half Facepiece Respirator, PN 07182</p>	
<p>3M™ Lexa™ Protective Eyewear, PN 15200</p>	

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 www.3MCollision.com

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

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IMPORTANT NOTE: There are of course many factors and variables that can affect an individual repair, so the technician and repair facility need to evaluate each specific application and repair process, including relevant vehicle, part and OEM guidelines, and determine what is appropriate for that repair.



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