Cosmetic Flexible Bumper Repair
Scrapes, Gouges and Deformations

1. **Clean the Damaged Area**
   Clean the repair area with soap and water, followed by a VOC compliant surface cleaner.

2. **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.

3. **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.

4. **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.

5. **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.

6. **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.

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**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

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**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

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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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