

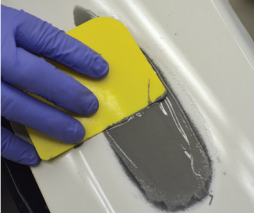



**Flexible Patch Non-Structural Bumper Repair**

<b>1</b>		<p><b>Clean the Damaged Area</b></p> <p>Clean the front and back of the repair area with soap and water, followed by a VOC compliant surface cleaner. Be sure to remove any overspray from the back side of the repair area. A Scotch-Brite™ scuffing pad may be used to assist with stubborn overspray.</p>
<b>2</b>		<p><b>Initial Grinding</b></p> <p>Grind the front of the repair using a grade 36 file belt. Grind at a low speed creating a “Dish Out” area 3 in. wide that tapers to the bottom of the damage.</p>
<b>3</b>		<p><b>Initial Prep Sand</b></p> <p>Sand the “Dish Out” area using a grade 80 abrasive disc on a 3 in. DA sander, removing any melted plastic. Keep the grade 80 abrasive scratches within the “Dish Out” area. Using grade 180 abrasive, feather edge 2–4 in. from the “Dish Out” area.</p>
<b>4</b>		<p><b>Apply Reinforcement Patch</b></p> <p>On the back side of the repair area apply the flexible patch adhesive promoter sponge. Firmly apply the flexible reinforcement patch overlapping the damaged area by at least 1-1/2 in. on all sides of the repair.</p>
<b>5</b>		<p><b>Mix and Apply Flexible Filler</b></p> <p>Apply 3M™ Polyolefin Adhesion Promoter to the front side of the repair and allow to dry for 10 minutes. Mix and apply flexible filler with a “tight coat” followed by additional coats to fill in all low areas. Allow 15 minutes to cure at 75°F.</p>
<b>6</b>		<p><b>Sand Flexible Filler</b></p> <p>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>
<b>7</b>		<p><b>Final Sand and Inspect</b></p> <p>Using a DA sander, finish sand the repair and the surrounding area using a grade 320 abrasive disc. Blow off and inspect the repair for quality. Repeat steps 5 and 6 as necessary.</p>

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**Product List**

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



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



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™ Automotive Adhesion Promoter, Sponge Applicator Packets, 2.5mL per packet, PN 06396



3M™ EZ Fix Flexible Patch Kit (with adhesion promoter wipes), 4 in. x 8 in., PN 05888



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](http://3MCollision.com)

For product material safety data sheets see [3MCollision.com](http://3MCollision.com)

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