





Flexible Patch Non-Structural Bumper Repair		
1		<p>Clean the Damaged Area</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>
2		<p>Initial Grinding</p> <p>Grind the front of the repair using a 75mm grade 60 disc. Grind at a low speed creating a “Dish Out” area 75mm wide that tapers to the bottom of the damage.</p>
3		<p>Initial Prep Sand</p> <p>Sand the “Dish Out” area using a P80 abrasive disc on a DA sander, removing any melted plastic. Keep the P80 abrasive scratches within the “Dish Out” area. Using P180 abrasive, feather edge 50 - 100mm from the “Dish Out” area.</p>
4		<p>Apply Reinforcement Patch</p> <p>On the back side of the repair area apply the flexible patch adhesion promoter. Firmly apply the flexible reinforcement patch overlapping the damaged area by 30 - 40mm on all sides of the repair.</p>
5		<p>Mix and Apply Flexible Filler</p> <p>Apply 3M™ Polyolefin Adhesion Promoter (PN 05907) to the front side of the repair and allow to dry for 5 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 23°C.</p>
6		<p>Sand Flexible Filler</p> <p>DA sand the flexible filler material with a P150 abrasive disc or block sand the repair area with a P180 abrasive sheet.</p>
7		<p>Final Sand and Inspect</p> <p>Using a DA sander, finish sand the repair and the surrounding area using a P320 abrasive disc. Blow off and inspect the repair for quality. Repeat steps 5 and 6 as necessary.</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, 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, 180+ grade, PN 34446</p>	
<p>3M™ Cubitron™ II Fibre Roloc™ Disc, grade 60+, PN 33391</p>	
<p>3M™ Polyolefin Adhesion Promoter, 12 oz. aerosol, PN 05907</p>	
<p>3M™ EZ Fix Flexible Patch Kit (with adhesion promoter wipes), 4 in. x 8 in., PN 05888</p>	
<p>3M™ Automotive Adhesion Promoter, Sponge Applicator Packets, 2.5mL per packet, PN 06396</p>	
<p>3M™ EZ Sand Multi-Purpose Flexible Adhesive, 200mL, PN 05887;</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>	

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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.