


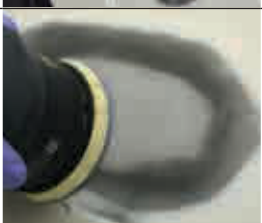
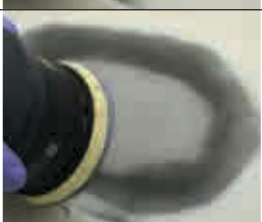


Flexible Patch Non-Structural Bumper Repair

1		Clean the Damaged Area 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.
2		Initial Grinding 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.
3		Initial Prep Sand 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.
4		Apply Reinforcement Patch 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.
5		Mix and Apply Flexible Filler 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.
6		Sand Flexible Filler DA sand the flexible filler material with a P180 abrasive disc or block sand the repair area with a P180 abrasive sheet.
7		Final Sand and Inspect 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.

Visit www.3M.com.au/aad or www.3m.co.nz/aad for more SOPs and videos

Product List ANZ

3M™ Purple Clean Sanding Hookit™ Disc, 75mm, P320, PN 30275; 150mm., P320, PN 01812



3M™ Cubitron™ II Clean Sanding Hookit™ Abrasive Disc, 150mm, 80+, PN 31371, 150mm, 150+, PN 31373, 150mm, 180+, PN 31374



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



3M™ Cubitron™ II Fibre Roloc™ Disc, grade 60+, PN 33391



3M™ Polyolefin Adhesion Promoter, 12 oz. aerosol, PN 05907



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

3M™ Automotive Adhesion Promoter, Sponge Applicator Packets, 2.5mL per packet, PN 06396



3M™ EZ Sand Multi-Purpose Flexible Adhesive, 200mL, PN 05887;



3M™ Performance Manual Applicator, 200mL, PN 08117



Think About Your Health

3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300



3M™ Half Facepiece Respirator, PN 07502 with appropriate cartridge



3M™ Lexa™ Protective Eyewear, PN 15200 or 3M Secure Fit SF401AF-AS



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.

Want a product sample or demo, or to speak to a 3M expert? Let us know here: <http://go.3M.com/4AHf>

For ordering information, contact your 3M Sales Representative