


Two-Sided Bumper Repair
Cracks, Holes & Punctures

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.</p>
2		<p>Prepare for Reinforcement Material</p> <p>Apply aluminum autobody repair tape to the front side of the repair to align and secure the damage while the back side reinforcement is being completed. On the back side, use a DA with grade 80 abrasive disc to sand the repair area where the reinforcement patch will be applied. Blow off with clean, dry air and apply adhesion promoter, allowing 5 minutes to dry.</p>
3		<p>Apply Reinforcement Material</p> <p>Apply alternating applications of thin, wet coats of semi-rigid plastic repair material and reinforcement cloth on the damaged area. Allow dry time of 15 minutes at 23°C.</p>
4		<p>Tapering the Front Side</p> <p>Remove the aluminum tape. Grind the front damage using a 3 in. grade 60 disc or grade 60 file belt at a low speed to create a gradual "Dish Out" area 75mm wide and deep enough to expose a 6mm wide strip of the back side reinforcement material through the center of the damage.</p>
5		<p>Preparing the Repair Area</p> <p>Use a DA with grade 80 abrasive disc to create a smooth transition into the dished area, remove any melted plastic and create a fuzzy surface for the adhesive. No shiny plastic areas should remain. Abrade with grade 180 around the dished out area where the adhesive will eventually be featheredged.</p>
6		<p>Mix and Apply Flexible Filler</p> <p>Blow off the front side repair area with clean dry air, apply aerosol adhesion promoter and allow to dry for 5 minutes. Mix and apply flexible filler material with an initial "tight coat" immediately followed by additional coats to fill in all low areas. Allow 15 minutes to cure at 24°C.</p>
7		<p>Sand Flexible Filler</p> <p>Use a DA to sand the flexible filler material with a grade 150 abrasive disc, followed by a block with grade 180.</p>
8		<p>Final Sand and Inspect</p> <p>Use a DA sander to finish sand the repair area using P320 abrasive disc. Blow off and inspect the repair quality. Repeat steps 6 and 7 as necessary.</p>

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

Product List ANZ

3M™ Polyolefin Adhesion Promoter, 340g aerosol, PN 05907



3M™ Plastic Repair Material Semi-Rigid, 200mL cartridge, PN 04240



3M™ Reinforcement Patch, 125mm x 3.6m roll, PN 04904 or equivalent



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



3M™ Cubitron™ II File Belt, 10mm x 330mm, grade 60+, PN 33439



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



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



3M™ Purple Clean Sanding Hookit™ Disc, P320, PN 30275; P320, PN 01812

3M™ 29B7™ 51> Sanding Hookit™ 2B1C9F59C3



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.

For ordering information, contact your 3M Sales Representative