

**Back Side Reinforcement (SMC, FRP, Composites)**

<b>1</b>		<p><b>Clean the Damaged Area</b></p> <p>Clean the repair area with soap and water followed by a VOC compliant surface cleaner making sure to minimize the exposure of damaged or exposed fibers to the cleaners. Thoroughly dry the part. Do not apply any other cleaners throughout the remainder of the repair procedure.</p>
<b>2</b>		<p><b>Surface Preparation</b></p> <p>Grind the backside of the repair with a grade 60 3M™ Roloc™ Abrasive Disc on a pistol grip grinder set at a low speed. When finished the sanded area should be at least 2 in. larger than the repair area. Remove sanding debris from the surface using clean compressed air and a clean, dry rag.</p>
<b>3</b>		<p><b>Adhesion Promoter</b></p> <p>No adhesion promoter is needed for SMC or FRP repairs. If repairing Metton® Liquid Molding Resin, apply a light, consistent coat of 3M™ Polyolefin Adhesion Promoter to the repair area. Allow to dry for at least 5 minutes.</p>
<b>4</b>		<p><b>Alignment</b></p> <p>Align the front side of the repair and cover the damaged area with Scotch® Auto Body Repair Tape to keep the adhesive from the back side from flowing through to the front side.</p>
<b>5</b>		<p><b>Prepare and Apply Reinforcement Material</b></p> <p>Cut a piece of fiberglass matting 1-1/2 in. larger than the damaged area. Following product instructions, apply a “tight coat” of matting adhesive to the repair area to ensure good contact with the composite. Place the fiberglass mat on a clean, dry work surface. Saturate the entire section of mat with matting adhesive on both sides and apply it over the “tight coat” on the repair. Apply more 3M™ Fiberglass Mat Adhesive if necessary.</p>
<b>6</b>		<p><b>Dry</b></p> <p>Allow the matting adhesive to cure for 45 minutes at 75°F.</p>

Visit [3MCollision.com](http://3MCollision.com) for more SOPs and videos

**Product List**

- 3M™ Car Wash Soap Concentrate, 5 gallons, PN 38378 

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- 3M™ Specialty Adhesive Remover, 15 oz. aerosol, PN 38987 

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- 3M™ Cubitron™ II Fibre Roloc™ Disc, grade 60+, 3 in. (75mm), PN 33391 

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- 3M™ Pistol Grip Disc Sander, PN 33577 

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- 3M™ Polyolefin Adhesion Promoter, PN 05907 

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- Scotch® Auto Body Repair Tape, 2 in. x 125 in., PN 95331 

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- 3M™ Aluminum Foil Tape 425, Silver, 2 in. x 60 yd., 4.6 mil, PN 95072 

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- Scotch® Performance Green Masking Tape 233+, 48mm width (1.9 in.), PN 26340 

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- Dynatron™ Fiberglass Mat, 8 sq. ft., PN 00688 

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- 3M™ Fiberglass Mat Adhesive, 400mL, PN 08277 


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- 3M™ Performance Pneumatic Applicator for 400mL cartridges, PN 08280 


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- Marson® Yellow Spreaders, PN 20395 


**Think About Your Health**

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

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- 3M™ Half Facepiece Respirator, PN 07182 

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- 3M™ Virtua™ CCS Protective Eyewear with Foam Gasket, PN 11872 

**Not a complete list.** Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.

# Protect Your Repairs

Corrosion protection is recommended for this type of repair.

Protect repairs with a self-healing, non-hardening formula

- 3M Cavity Wax Plus, PN 08852
- 3M™ Cavity Wax Plus Applicator Wand Kit, PN 08851



All OEMs recommend the application of internal anti-corrosion material during body repair, which includes cavity wax.

## Individual Product Instruction and Safety Information

For individual product instructions and applicable precautions see product labels and associated literature for the individual product at [www.3MCollision.com](http://www.3MCollision.com)

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

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**IMPORTANT NOTE:** There are of course many factors and variables that can affect an individual repair, so the technician and repair facility need to evaluate each specific application and repair process, including relevant vehicle, part and OEM guidelines, and determine what is appropriate for that repair.



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