

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 3 in. grade 60 disc. Grind at a low speed creating a “Dish Out” area 3 in. 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 2–4 in. 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 1-1/2 in. 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 75°F.</p>
6		<p>Sand Flexible Filler</p> <p>DA sand the flexible filler material with a P150 abrasive disc. 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>

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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, 3 in, 80+, PN 31361 3 in, 150+, PN 31363 3 in, 180+, PN 31364 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; 600mL DMS, PN 55887</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> 
<p>Not a complete list. Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.</p>

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

For product material safety data sheets see 3MCollision.com

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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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