



































# Plastic repair.

Working recommendation.

Work process	3M™ products	Festool Automotive Systems – tools		
				
		Festool Automotive Systems Compressed Air Eccentric Sander <b>LEX 3 77 / 2.5</b>	Festool Automotive Systems Geared Eccentric Sander <b>RO 90 DX</b>	Festool Automotive Systems Eccentric Sander <b>ETS EC 150</b>
<b>Clean and pre-treat</b>	3M™ General Purpose Adhesive Cleaner, 1L, PN08984, 3M™ Panel Wipes, PN34567 			
<b>Repair area preparation</b>				
<b>Hole</b>		3M 80+/150+ 	3M 80+/150+ ○ Sanding Pad ⦿ Rough Sanding 	3M 80+/150+ 
<b>Crack and tab</b>		3M 80+/150+ 	3M 80+/150+ △ \ ○ Sanding Pad ⦿ Rough Sanding 	3M 80+/150+ 
<b>Clean and pre-treat</b>	3M™ VHB Surface Cleaner, 1L, PN22779 (SC1), 3M™ Panel Wipes, PN34567 			
<b>Primer</b>	3M™ Polyolefin Adhesion Promoter, 200ml, PN05917 			
<b>Adhesive application</b> Work time: ● Sanding time: ●	3M™ Flexible Parts Repair Material, 50ml, PN05901  <b>7 mins</b> <b>20 mins</b>			
	3M™ Structural Plastic Adhesive, 200ml, PN55047  <b>60 sec</b> <b>15 mins</b>			
	3M™ Super Fast Repair Adhesive, 50ml, Clear, PN55045  <b>20 sec</b> <b>5 mins</b>			
	3M™ Super Fast Repair Adhesive, 50ml, Black, PN04748  <b>20 sec</b> <b>5 mins</b>			
	3M™ Crack Seal Tape, PN03020, 3M™ Flexible Plastic Patch Kit, PN05888 			
<b>Intermediate sanding (optional)</b>		3M 80+/150+ 	3M 80+/150+ △ \ ○ Sanding Pad ⦿ Rough Sanding 	3M 80+/150+ 
<b>Final sanding</b>		3M 80+/150+ 	3M 80+/150+ △ \ ○ Sanding Pad ⦿ Eccentric Sanding 	3M 80+/150+ 
<b>Clean and pre-treat</b>	3M™ VHB Surface Cleaner, 1L, PN22779 (SC1) 			
	3M™ General Purpose Adhesive Cleaner, 1L, PN08984 			
	3M™ Panel Wipes, PN34567 			
<b>Primer</b>	3M™ Polyolefin Adhesion Promoter, 200ml, PN05917 			
<b>Plastic filler</b> Work time: ● Sanding time: ●	3M™ Plastic Filler, 0.5kg, PN51009  <b>3 mins</b> <b>45 mins</b>	3M 80+/150+ 	3M 80+/150+ △ \ ○ Sanding Pad ⦿ Eccentric Sanding 	3M 80+/150+ 
	3M™ EZ Sand Flexible Parts Repair, 200ml, PN05887  <b>5-7 mins</b> <b>15 mins</b>			

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