

Back Side Reinforcement (SMC, FRP, Composites)

1		<p>Clean the Damaged Area</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>
2		<p>Surface Preparation</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 48mm larger than the repair area. Remove sanding debris from the surface using clean compressed air and a clean, dry rag.</p>
3		<p>Adhesion Promoter</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>
4		<p>Alignment</p> <p>Align the front side of the repair and cover the damaged area with Aluminium Foil Tape. Create a ridge in the tape to allow adhesive to come through.</p>
5		<p>Prepare and Apply Reinforcement Material</p> <p>Cut a piece of Reinforcement Patch larger than the damaged area. Following product instructions, apply a “tight coat” of 34240 to the repair area to ensure good contact with the composite. Place the reinforcement patch on a clean, dry work surface. Saturate the entire section of mat with 04904 on both sides and apply it over the “tight coat” on the repair.</p>
6		<p>Dry</p> <p>Allow the matting adhesive to cure for 15 minutes at 24°C.</p>

Product List

3M™ Car Wash Soap Concentrate, 3.7L, PN 38377



3M™ Cubitron™ II Fibre Roloc™ Disc, grade 60+, 75mm, PN 33391



3M™ Pistol Grip Disc Sander, PN 33577



3M™ Polyolefin Adhesion Promoter, PN 05907



3M™ Aluminium Foil Tape 425, Silver, 48mm x 50M



Scotch® Performance Green Masking Tape 233+, 48mm width



3M™ Reinforcement Patch, 127mm x 3.66M, PN 04904



3M™ Semi Rigid Plastic Repair, 47.3ml, PN 34240



Dynatron® Spreader, Yellow, PN 344



Think About Your Health

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



3M™ Half Face Welding Respirator Kit, PN 6228



3M™ Solus™ 1000 Series Scotchgard™ Anti-fog Eyewear, PN S1201SGAF



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