


| Flexible Patch Non-Structural Bumper Repair |   |   |
|---|---|---|
| <b>1</b>                                    |    | <p><b>Clean the Damaged Area</b></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>    |
| <b>2</b>                                    |    | <p><b>Initial Grinding</b></p> <p>Grind the front of the repair using a 76mm grade 60 disc. Grind at a low speed creating a “Dish Out” area 76mm wide that tapers to the bottom of the damage.</p>  |
| <b>3</b>                                    |   | <p><b>Initial Prep Sand</b></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 50 - 101mm from the “Dish Out” area.</p>                                       |
| <b>4</b>                                    |  | <p><b>Apply Reinforcement Patch</b></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 25 - 38mm on all sides of the repair.</p>  |
| <b>5</b>                                    |  | <p><b>Mix and Apply Flexible Filler</b></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 24°C.</p> |
| <b>6</b>                                    |  | <p><b>Sand Flexible Filler</b></p> <p>DA sand the flexible filler material with a P120 abrasive disc. Block sand the repair area with a P180 abrasive sheet.</p>  |
| <b>7</b>                                    |  | <p><b>Final Sand and Inspect</b></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>  |

| Product List  |   |
|---|---|
| <p>3M™ Purple Clean Sanding Hookit™ Disc, 76mm, P80, PN 30283<br/>76mm, P180, PN 30279<br/>76mm, P320, PN 30275<br/>150mm, P320, PN 01812</p> |    |
| <p>3M™ Cubitron™ II Clean Sanding Hookit™ Abrasive Disc, 150mm, 80+, PN 31371<br/>150mm, 120+, PN 31373<br/>150mm, 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 Aerosol 350g, PN 05907</p>  |   |
| <p>3M™ EZ Fix Flexible Patch Kit (with adhesion promoter wipes), 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<br/>50ml, PN 35887</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 Face Welding Respirator Kit, PN 6228</p>  |  |
| <p>3M™ Secure Fit™ 200 Series Anti-fog Eyewear, Clear Frame, PN 201AF-AS</p>  |  |
| <p><b>Not a complete list.</b> 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.**