

Important note on process safety
Always wear Personal Protective Equipment

- Comfort Particle Mask P3 
- Hearing Protection 
- Comfort Goggles 
- Reusable Overall 
- Safety Gloves 

<p>1 Cleaning of the surface</p>		<ul style="list-style-type: none"> ▶ Degrease the surface using 3M™ VHB Surface Cleaner to remove any oil or grease on surface. ▶ Degreasing the surface helps to provide optimal bonding of the adhesive. 	 <p>3M™ VHB Surface Cleaner 3M™ Professional Panel Wipes</p>
<p>2 Pre-sanding of the repair area</p>		<ul style="list-style-type: none"> ▶ Prepare area with 3M™ Cubitron™ II Roloc™ Discs 80+. <p>Note: Plastic is a very soft substrate! Pay special attention as using excessively coarse abrasives can badly damage the surface and plastic fibres.</p>	 <p>3M™ Pistol Grip Disc Sander 3M™ Cubitron™ II Roloc™ Discs</p>
<p>3 Preparation of the repair area</p>		<ul style="list-style-type: none"> ▶ Drill several holes of 3 - 6 mm in diameter in the remaining part of the tab to increase the strength of the repair. 	
<p>4 Cleaning of the surface</p>		<ul style="list-style-type: none"> ▶ Clean the area with 3M™ VHB™ Surface Cleaner. 	 <p>3M™ VHB Surface Cleaner 3M™ Professional Panel Wipes</p>
<p>5 Application of Adhesion Promoter</p>		<ul style="list-style-type: none"> ▶ Apply 3M™ Polyolefin Adhesion Promoter on the repair area and allow 10 minutes to dry. <p>Attention: Do not use an adhesion promoter on ABS-type plastics.</p>	 <p>3M™ Polyolefin Adhesion Promoter</p>
<p>6 Application of 3M™ Superfast Plastic Repair Adhesive</p>		<ul style="list-style-type: none"> ▶ Cut the 3M™ Contour Sheet to the size of the tab to be repaired. ▶ Extrude the 3M™ Superfast Plastic Adhesive onto the 3M™ Contour Sheet and press the film with the adhesive from below. 	 <p>3M™ Plastic Contour Sheet 3M™ Super Fast Repair Adhesive 3M™ Manual Gun for 2 part cartridges</p>
<p>7 Processing 3M™ Superfast Plastic Repair Adhesive</p>		<ul style="list-style-type: none"> ▶ Place 3M™ Superfast Plastic Adhesive onto the contour sheet, immediately folding around the damaged area covering both sides of the repair. ▶ Hold in place for 90 seconds and remove film once the 3M™ Superfast Plastic Adhesive cured. ▶ Allow to fully cure for 5 minutes before starting sanding steps. 	
<p>8 Rough Shape Damaged Tab</p>		<ul style="list-style-type: none"> ▶ Rough shape the repaired tab area with a 3M™ Cubitron™ II Roloc™ Discs 80+ to restore original tab dimensions. ▶ Drill a hole if required to create a new fixing point. 	 <p>3M™ Pistol Grip Disc Sander 3M™ Cubitron™ II Roloc™ Discs</p>
<p>9 Fine sanding of the repair area</p>		<ul style="list-style-type: none"> ▶ 3M™ Cubitron™ II Disc P220+ grade. ▶ Please do observe the recommendations of your paint manufacturer when selecting and applying the recommended fillers and procedures for plastic parts. 	 <p>3M™ Cubitron™ II Hookit™ Clean Sanding Abrasive Disc 75 mm, 220+ 3M™ Random Orbital Sander, 75 mm</p>

