

**Important note on process safety**  
Always wear Personal Protective Equipment

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

<p><b>1</b> Cleaning of the surface</p>		<ul style="list-style-type: none"> <li>▶ Degrease the surface using 3M™ VHB Surface Cleaner to remove any oil or grease on surface.</li> <li>▶ Degreasing the surface helps to provide optimal bonding of the adhesive.</li> </ul>	<p>3M™ VHB Surface Cleaner      3M™ Professional Panel Wipes</p>
<p><b>2</b> Pre-sanding of the repair area</p>		<ul style="list-style-type: none"> <li>▶ Prepare area with 3M™ Cubitron™ II Roloc™ Discs 80+.</li> </ul> <p><b>Note:</b> 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><b>3</b> Preparation of the repair area</p>		<ul style="list-style-type: none"> <li>▶ Drill several holes of 3 - 6 mm in diameter in the remaining part of the tab to increase the strength of the repair.</li> </ul>	
<p><b>4</b> Cleaning of the surface</p>		<ul style="list-style-type: none"> <li>▶ Clean the area with 3M™ VHB™ Surface Cleaner.</li> </ul>	<p>3M™ VHB Surface Cleaner      3M™ Professional Panel Wipes</p>
<p><b>5</b> Application of Adhesion Promoter</p>		<ul style="list-style-type: none"> <li>▶ Apply 3M™ Polyolefin Adhesion Promoter on the repair area and allow 10 minutes to dry.</li> </ul> <p><b>Attention:</b> Do not use an adhesion promoter on ABS-type plastics.</p>	<p>3M™ Polyolefin Adhesion Promoter</p>
<p><b>6</b> Application of 3M™ Superfast Plastic Repair Adhesive</p>		<ul style="list-style-type: none"> <li>▶ Cut the 3M™ Contour Sheet to the size of the tab to be repaired.</li> <li>▶ Extrude the 3M™ Superfast Plastic Adhesive onto the 3M™ Contour Sheet and press the film with the adhesive from below.</li> </ul>	<p>3M™ Plastic Contour Sheet      3M™ Super Fast Repair Adhesive      3M™ Manual Gun for 2 part cartridges</p>
<p><b>7</b> Processing 3M™ Superfast Plastic Repair Adhesive</p>		<ul style="list-style-type: none"> <li>▶ Place 3M™ Superfast Plastic Adhesive onto the contour sheet, immediately folding around the damaged area covering both sides of the repair.</li> <li>▶ Hold in place for 90 seconds and remove film once the 3M™ Superfast Plastic Adhesive cured.</li> <li>▶ Allow to fully cure for 5 minutes before starting sanding steps.</li> </ul>	
<p><b>8</b> Rough Shape Damaged Tab</p>		<ul style="list-style-type: none"> <li>▶ Rough shape the repaired tab area with a 3M™ Cubitron™ II Roloc™ Discs 80+ to restore original tab dimensions.</li> <li>▶ Drill a hole if required to create a new fixing point.</li> </ul>	<p>3M™ Pistol Grip Disc Sander      3M™ Cubitron™ II Roloc™ Discs</p>
<p><b>9</b> Fine sanding of the repair area</p>		<ul style="list-style-type: none"> <li>▶ 3M™ Cubitron™ II Disc P220+ grade.</li> <li>▶ Please do observe the recommendations of your paint manufacturer when selecting and applying the recommended fillers and procedures for plastic parts.</li> </ul>	<p>3M™ Cubitron™ II Hookit™ Clean Sanding Abrasive Disc 75 mm, 220+      Festool Automotive Systems LEX 3 77</p>

