

Repair Process Board

Bumper Repair



1

Drill a hole of 4-6mm in diameter at the base of the crack in order to release stress and prevent further extension of the crack.



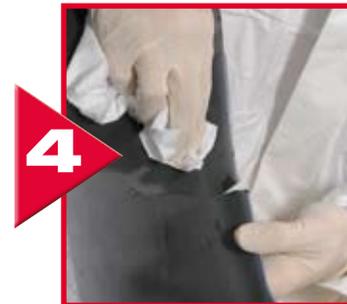
2

Prepare the area around the crack using a 3M™ Hookit™ Abrasive Disc P80 (for hard plastics) or P180. Avoid overheating and melting the plastic.



3

Increase the bonding surface by opening out the crack using a 3M™ Roloc Disc P80. For a crack reaching the edge of the panel, open the end to make a 'V' shape. Remove plastic residue with a sharp knife.



4

Clean the area using 3M™ VHB™ Surface Cleaner or 3M™ General Purpose Adhesive Cleaner 08984 applied with a 3M™ Professional Panel Wipe 34567.



5

To achieve maximum adhesion use 3M™ Automix™ Patch Adhesion Promoter 06396 to the back side of the repair. Allow 5 minutes to dry.



6

Cut the 3M™ Automix™ Instant Plastic Repair Patch 05888 to size (at least 2-3cm larger than the repair area) and place firmly over the entire crack on the back side of the bumper.



7

Spray Polyolefin Adhesion Promoter 05917 on the front side of the bumper around the cracked area. Allow 10 minutes to dry.



8

Using 3M™ Applicator 08190 apply 3M™ Flexible Parts Repair Material 05901 to the cracked area.



9

Spread and smooth 3M™ Flexible Parts Repair Material 05901 into the crack and allow to dry for 20 minutes.



10

Cut excess 3M™ Automix™ Instant Plastic Repair Patch 05888 and shape. Sand over the cracked area using 3M™ Hookit™ Abrasive Disc P80 and P180.