



PLASTIC REPAIR STRUCTURAL

BEST PRACTICE

RECOMMENDED PRODUCTS

Identify the Type of Repair

For structural repair (damage that penetrated the bumper cover) perform steps S1 thru S6 on the backside of the bumper followed by the cosmetic steps C1 thru C6 on the face of the bumper. For small tears, gouges and cosmetic damage only (damage that did not penetrate the bumper) skip to the cosmetic steps (starting with C2) after preparing the surface.

S1 Prepare the Surface

For best results, use when the temperature of the product and the surface is between 70°F and 75°F (21°C and 24°C). Clean the repair area first with soap and water followed by a non-solvent based cleaner then dry thoroughly.

Objective: Eliminate contaminants so they are not sanded into the plastic.



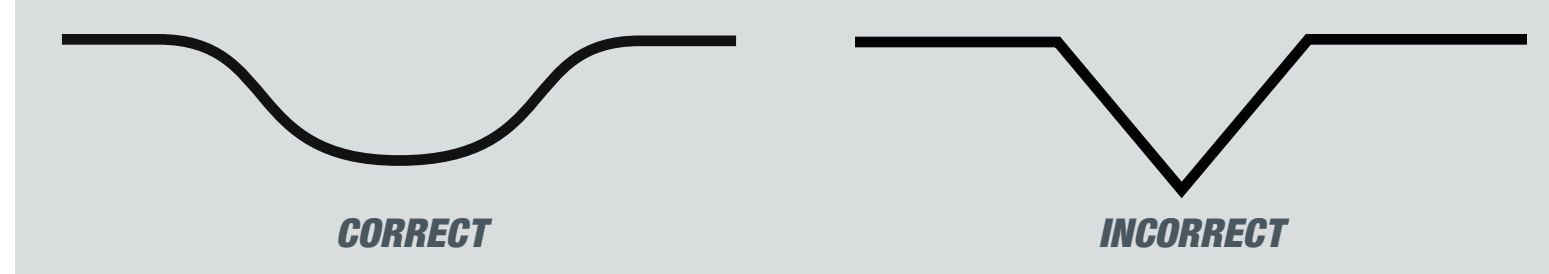
PRODUCT	PART NO.
GP Waterbased Cleaner	99458

S2 Sand the Backside of Tear

Sand the rip or tear area with a 80 or 100 grit using a DA. Blow off with clean, dry air.

Objective: Ensure adhesion of the repair material. Improve repair strength and aid feathering by leveling and enlarging the bond area.

Tip: Do not use any cleaners after the damaged area has been sanded.



SIZE	GRIT	PREMIER RED STICK-ON	PREMIER RED GRIP-ON
3"	P80	—	70019
3" Back-Up Pad		—	99306
5"	P80	18114	20269
5" Back-Up Pad	P100	18113	20267
6"	P80	18173	20289
6" Back-Up Pad	P100	18172	20288
6" Back-Up Pad		99319	99323

S3 Apply Adhesion Promoter

Apply adhesion promoter and wait 10 minutes or flash off with a heat gun, being careful not to overheat the part.

Objective: Plastic identification is not necessary with the Carborundum adhesion promoter; however, it must be allowed to flash off for 10 minutes to work properly.



EZ REPAIR ADHESION PROMOTER	PART NO.
330 grams Aerosol	99411
118 ml Brushtop	99410

S4 Basics to Follow for Best Results

- Apply masking tape to the front side of the damaged area to keep adhesive from dripping through the tear.
- Cut the length of nylon tape needed and have it handy to apply.
- Purge the EZ Repair adhesive to ensure both cartridges are flowing. Do this without the mixing tip attached.
- Attach the mixing tip and equalize the adhesive until a consistent color is achieved, which indicates the proper mix.



MASKING TAPE	1-1/2"	2"
Tan Tape	70408	70409
Gold Tape	99367	99368

EZ REPAIR	PART NO.
2" x 65' Nylon Reinforcing Tape	04632
1 minute Urethane	99400
220 ml Manual Gun	41400

S5 Apply Adhesive and Patch

- Apply adhesive around the repair area keeping in mind the "work window" of the product.
 - Apply the reinforcing tape extending 1" beyond all edges of the damage.
- The reinforcing tape can be applied first followed by the adhesive application. Either method is acceptable.

Objective: Reinforce the repair.



S6 Spread Adhesive Over Patch

Spread adhesive flush with the surface and apply pressure to ensure the patch has good contact and to eliminate air pockets. Once the adhesive is cured, remove the tape from the front side to start the cosmetic repair.

Objective: Repair the damage and make sure that resulting patch does not interfere with other components.



PRODUCT	PART NO.
Mixing Spreader	06396



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