

**Two-Sided Bumper Repair**  
Cracks, Holes & Punctures

<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.</p>
<b>2</b>		<p><b>Prepare for Reinforcement Material</b></p> <p>Apply aluminum autobody repair tape to the front side of the repair to align and secure the damage while the back side reinforcement is being completed. On the back side, use a DA with grade 80 abrasive disc to sand the repair area where the reinforcement patch will be applied. Blow off with clean, dry air and apply adhesion promoter, allowing 5 minutes to dry.</p>
<b>3</b>		<p><b>Apply Reinforcement Material</b></p> <p>Apply alternating applications of thin, wet coats of semi-rigid plastic repair material and reinforcement cloth on the damaged area. Allow dry time of 15 minutes at 75°F.</p>
<b>4</b>		<p><b>Tapering the Front Side</b></p> <p>Remove the aluminum tape. Grind the front damage using a 3 in. grade 60 disc or grade 36 file belt at a low speed to create a gradual "Dish Out" area 3 in. wide and deep enough to expose a 1/4-inch wide strip of the back side reinforcement material through the center of the damage.</p>
<b>5</b>		<p><b>Preparing the Repair Area</b></p> <p>Use a DA with grade 80 abrasive disc to create a smooth transition into the dished area, remove any melted plastic and create a fuzzy surface for the adhesive. No shiny plastic areas should remain. Abrade with grade 180 around the dished out area where the adhesive will eventually be featheredged.</p>
<b>6</b>		<p><b>Mix and Apply Flexible Filler</b></p> <p>Blow off the front side repair area with clean dry air, apply aerosol adhesion promoter and allow to dry for 5 minutes. Mix and apply flexible filler material with an initial "tight coat" immediately followed by additional coats to fill in all low areas. Allow 15 minutes to cure at 75°F.</p>
<b>7</b>		<p><b>Sand Flexible Filler</b></p> <p>Use a DA to sand the flexible filler material with a grade 150 abrasive disc, followed by a block with grade 180.</p>
<b>8</b>		<p><b>Final Sand and Inspect</b></p> <p>Use a DA sander to finish sand the repair area using P320 abrasive disc. Blow off and inspect the repair quality. Repeat steps 6 and 7 as necessary.</p>

Visit [www.3MCollision.com](http://www.3MCollision.com) for more SOPs and videos

**Product List**

<p>3M™ Polyolefin Adhesion Promoter, 12 oz. aerosol, PN 05907</p>	
<p>3M™ Plastic Repair Material Semi-Rigid, 200mL cartridge, PN 04240</p>	
<p>3M™ Reinforcement Patch, 5 in. x 12 ft., roll, PN 04904</p>	
<p>3M™ Cubitron™ II Fibre Roloc™ Disc, grade 60+, PN 33391</p>	
<p>3M™ File Belt Sander, 0.6 HP, PN 28366</p>	
<p>3M™ Cubitron™ II File Belt, 3/8 in. x 13 in. (10 x 330mm), grade 36+, PN 33443</p>	
<p>3M™ EZ Sand Multi-Purpose Flexible Adhesive, 200mL, PN 05887; 600mL DMS, PN 55887</p>	
<p>3M™ Performance Manual Applicator, 200mL, PN 08117</p>	
<p>3M™ Dynamic Mixing Applicator — Pneumatic, PN 05846</p>	
<p>3M™ Purple Clean Sanding Hookit™ Disc, 3 in., P320, PN 30275; 6 in., P320, PN 01812</p>	
<p>3M™ Cubitron™ II Clean Sanding Hookit™ Abrasive Disc, 3 in, 80+, PN 31361 3 in, 150+, PN 31363 3 in, 180+, PN 31364 6 in, 80+, PN 31371 6 in, 150+, PN 31373 6 in, 180+, PN 31374</p>	

**Think About Your Health**

<p>3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300</p>	
<p>3M™ Half Facepiece Respirator, PN 07182</p>	
<p>3M™ Lexa™ Protective Eyewear, PN 15200</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.**

## Individual Product Instruction and Safety Information

For individual product instructions and applicable precautions see product labels and associated literature for the individual product at [www.3MCollision.com](http://www.3MCollision.com)

For product material safety data sheets see [www.3MCollision.com](http://www.3MCollision.com)

**Technical Information:** The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.

**Product Use:** Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user's method of application.

**Warranty, Limited Remedy and Disclaimer:** Unless an additional warranty is specifically stated on the applicable 3M product packaging or product literature, 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY IMPLIED WARRANTY OR CONDITION ARISING OUT OF A COURSE OF DEALING, CUSTOM OR USAGE OF TRADE. If the 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M's option, replacement of the 3M product or refund of the purchase price.

**Limitation of Liability:** Except where prohibited by law, 3M will not be liable for any loss or damage arising from the 3M product, whether direct, indirect, special, incidental or consequential, regardless of the legal theory asserted, including warranty, contract, negligence or strict liability.

**IMPORTANT NOTE:** There are of course many factors and variables that can affect an individual repair, so the technician and repair facility need to evaluate each specific application and repair process, including relevant vehicle, part and OEM guidelines, and determine what is appropriate for that repair.



3M Automotive Aftermarket Division  
3M Center, Building 223-6N-01  
St. Paul, MN 55144-1000  
U.S.A.

3M, Accuspray, Body Schutz, Cubitron, E-A-R, Green Corps, Hookit, Lexa, Perfect-It, Platinum, PPS, Roloc, Scotch, Scotchblok, Scotch-Brite, Skull Screws, SUN GUN and Trizact are trademarks of 3M. All other trademarks are property of their respective owners.

Web: [www.3MCollision.com](http://www.3MCollision.com)

Please recycle. Printed in U.S.A. © 3M 2016. All rights reserved. (Rev 5/2016)