



PLASTIC REPAIR STRUCTURAL

BEST PRACTICE

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 Mothers® Auto Wash, and rinse, followed by a non-solvent based cleaner and dry thoroughly.

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



RECOMMENDED PRODUCTS

PRODUCT	PART #
Waterbased Cleaner	076607-21937
Mothers® Auto Wash 1 Gallon	078175-80138

Sand the Repair Area

Sand at least two inches around the rip or tear area on both sides of the bumper with an 80 grit using a DA. Dish out the area on the back side (see diagram) for optimal adhesion. 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.



DRY ICE A975 P80 GRIT	PART #
3" NorGrip	636425-05990
6" PSA	662611-40512
6" NorGrip	662611-40532
6" NorGrip Multi-Air Cyclonic	776960-07770

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 Norton adhesion promoter; however, it must be allowed to flash off for 10 minutes to work properly.



SPEEDGRIP ADHESION PROMOTER	PART #
330 grams Aerosol	636425-04625
118 grams Brushtop	636425-04624

Basics to Follow for Best Results

- Apply masking tape to the front side of the damaged area to keep adhesive from squeezing through the tear.
- Cut the length of nylon tape needed and have it handy to apply.
- Purge the SpeedGrip 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	PART #
American brand PG 36mm	087143-00312
American brand PG 48mm	087143-00313

SPEEDGRIP	PART #
2" x 65' Nylon Reinforcing Tape	636425-04632
1 Minute Urethane	636425-04615
220ml Manual Gun	636425-41400

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.



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 and sand with 80 grit to remove any tape residue or adhesive that might have squeezed through. Blow off with clean, dry air and proceed to cosmetic repair.

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



PRODUCT	PART #
Mixing Spreader	636425-06396

