

Back Side Reinforcement (SMC, FRP, Composites)

1



Clean the Damaged Area

Clean the repair area with soap and water followed by a VOC compliant surface cleaner making sure to minimize the exposure of damaged or exposed fibers to the cleaners. Thoroughly dry the part. Do not apply any other cleaners throughout the remainder of the repair procedure.

2



Surface Preparation

Grind the backside of the repair with a grade 60 3M™ Roloc™ Abrasive Disc on a pistol grip grinder set at a low speed. When finished the sanded area should be at least 2 in. larger than the repair area. Remove sanding debris from the surface using clean compressed air and a clean, dry rag.

3



Adhesion Promoter

No adhesion promoter is needed for SMC or FRP repairs. If repairing Metton® Liquid Molding Resin, apply a light, consistent coat of 3M™ Polyolefin Adhesion Promoter to the repair area. Allow to dry for at least 5 minutes.

4



Alignment

Align the front side of the repair and cover the damaged area with Scotch® Auto Body Repair Tape to keep the adhesive from the back side from flowing through to the front side.

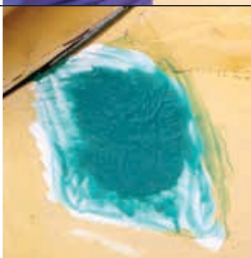
5



Prepare and Apply Reinforcement Material

Cut a piece of fiberglass matting 1-1/2 in. larger than the damaged area. Following product instructions, apply a "tight coat" of matting adhesive to the repair area to ensure good contact with the composite. Place the fiberglass mat on a clean, dry work surface. Saturate the entire section of mat with matting adhesive on both sides and apply it over the "tight coat" on the repair. Apply more 3M™ Fiberglass Mat Adhesive if necessary.

6



Dry

Allow the matting adhesive to cure for 45 minutes at 75°F.

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Product List

3M™ Car Wash Soap Concentrate, 5 gallons, PN 38378



3M™ Specialty Adhesive Remover, 15 oz. aerosol, PN 38987

3M™ Cubitron™ II Fibre Roloc™ Disc, grade 60+, 3 in. (75mm), PN 33391



3M™ Pistol Grip Disc Sander, PN 33577



3M™ Polyolefin Adhesion Promoter, PN 05907



Scotch® Auto Body Repair Tape, 2 in. x 125 in., PN 95331



3M™ Aluminum Foil Tape 425, Silver, 2 in. x 60 yd., 4.6 mil, PN 95072



Scotch® Performance Green Masking Tape 233+, 48mm width (1.9 in.), PN 26340



Dynatron™ Fiberglass Mat, 8 sq. ft., PN 00688



3M™ Fiberglass Mat Adhesive, 400mL, PN 08277



3M™ Performance Pneumatic Applicator for 400mL cartridges, PN 08280



Marson® Yellow Spreaders, PN 20395



Think About Your Health

3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300



3M™ Half Facepiece Respirator, PN 07182



3M™ Virtua™ CCS Protective Eyewear with Foam Gasket, PN 11872



Not a complete list. Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.

Individual Product Instruction and Safety Information

For individual product instructions and applicable precautions see product labels and associated literature for the individual product at **3MCollision.com**

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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.



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