






## Personal Safety

• Respiratory Protection  • Hearing Protection  • Face Protection  • Reusable Workwear  • Safety Gloves 

Safety First! Always select appropriate personal protective equipment - eyewear, gloves, hearing and respiratory protection for your job and workplace.

Pre-Cleaning



- Degrease the surface using paint company or other recommended VOC compliant water-based and solvent-based products. Always follow the manufacturer's instructions for surface cleaning instructions.

Initial Prep Sand



- Grind the broken tab using a 60-grade or coarse non-woven file belt, creating a tapered edge. Using a 3 in. / 75mm DA sander, sand the repair area with an 80-grade abrasive disc to refine 60-grade sand scratches and remove any melted plastic.



3M™ File Belt Sander



3M™ Cubitron™ II File Belt, grade 60+,



3M™ Cubitron™ II Hookit™ Clean Sanding Abrasive Disc, 3 in. / 75mm, grade 80+,

Prepare the Tab



- Drill 1/8 in. / 3mm pinning holes in the damaged area 1/4 in. / 6mm from tapered edge and 1/4 in. / 6mm apart. Apply aerosol adhesion promoter, allowing it to dry for 10 minutes.

Note: Avoid over-applying adhesion promoter. Doing so may cause the adhesive bond to fail. Apply one light coat over a sanded surface and allow to dry for 10 minutes. If the repair surface becomes contaminated or if the adhesive is not applied within 30 minutes, re-sand the surface and apply fresh adhesion promoter.



3M™ Polyolefin Adhesion Promoter, 12 oz. / 354ml aerosol

Mix and Apply Super-Fast Repair Material



- Cut contour film 3 times the length of the tab. Mix and apply repair material to the contour sheet and apply to the damaged tab, shaping as you work. Allow to cure for 5 – 10 minutes. Remove contour film. Note: Do not force removal of the contour film.



3M™ Plastic Contour Sheet, 5 in. (127mm) x 12 ft (3.6m)



3M™ Super Fast Repair Adhesive, 200mL



3M™ Performance Manual Applicator, 200mL

Rough Shape Damaged Tab



- Rough shape the repaired tab area with a 60-grade file belt. Using a 3-inch / 75mm DA sander, sand the repair area with an 80-grade abrasive disc to restore the original tab dimensions. Re-drill mounting holes as necessary.



3M™ File Belt Sander

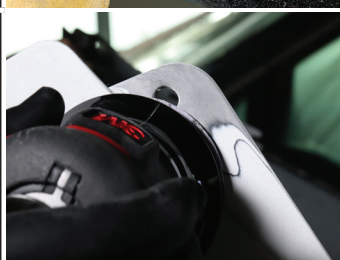


3M™ Cubitron™ II File Belt, grade 60+,



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Final Sand and Inspect



- Using a 3-inch / 75mm DA sander, finish sand the repair area and the surrounding area using a 180-grade abrasive disc. Blow off the repair area and inspect for quality.



3M™ Cubitron™ II Hookit™ Clean Sanding Abrasive Disc, 3 in. / 75mm, grade 180+