

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		<ul style="list-style-type: none"> • 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. 	
Prepare for Reinforcement Material		<ul style="list-style-type: none"> • Apply a heavy duty tape, or multiple layers of masking 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 an 80-grade abrasive disc to sand at least two inches beyond the damaged area where the reinforcement patch will be applied. Blow off with clean, dry air and apply adhesion promoter, allowing to dry for 5-10 minutes. 	  <p>3M™ Polyolefin Adhesion Promoter, 12 oz. (354ml) aerosol</p> <p>3M™ Cubitron™ II Hookit™ Clean Sanding Abrasive Disc, 3 in., grade 80+,</p>
Apply Reinforcement Material		<ul style="list-style-type: none"> • Apply a thin, tight coat of semi-rigid plastic repair material. Follow the tight coat with alternating layers of repair material and reinforcement patch material over the damaged area, starting with the repair material. Allow a dry time of 15 minutes at 24°C (75°F). 	  <p>3M™ Semi-Rigid Plastic Repair Material, 200mL cartridge</p> <p>3M™ Reinforcement Patch, 5 in. x 12 ft. roll</p>
Tapering the Front Side		<ul style="list-style-type: none"> • Remove the aluminum tape. Grind the front damage using a 60-grade or coarse non-woven file belt at a low speed to create a gradual "dish out" area 3 inches / 75mm wide and deep enough to expose a 1/4-inch / 6mm wide strip of the black adhesive through the center of the damage. 	  <p>3M™ File Belt Sander</p> <p>3M™ Cubitron™ II File Belt, grade 60+,</p>
Preparing the Repair Area		<ul style="list-style-type: none"> • Use a 3 inch / 75mm DA with 80-grade abrasive disc to create a smooth transition into the dish area. Remove any melted plastic and create a fuzzy surface for the adhesive. No shiny plastic areas should remain. Abrade with 180-grade around the dish area where the adhesive will eventually be featheredged. 	 <p>3M™ Cubitron™ II Hookit™ Clean Sanding Abrasive Disc, 3 in. / 75mm, grade 80+, 180+</p>
Mix and Apply Flexible Filler		<ul style="list-style-type: none"> • Blow off the front side repair area with clean dry air. Apply aerosol adhesion promoter • Mix and apply flexible repair material with an initial "tight coat" immediately followed by additional coats to fill in all low areas. Allow 15 minutes to cure at 24°C (75°F). <p>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 5 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.</p>	    <p>3M™ Polyolefin Adhesion Promoter, 12 oz. (354ml) aerosol</p> <p>3M™ EZ Sand Multi-Purpose Repair Material, 200mL, 600mL DMS</p> <p>3M™ Performance Manual Applicator, 200mL</p> <p>3M™ Dynamic Mixing Applicator — Pneumatic</p>
Sand Flexible Filler		<ul style="list-style-type: none"> • Use a DA sander to rough shape the adhesive with an 80-grade disc. Block sand the repair area with 180-grade sheet to finish shaping and featheredging the repair. 	  <p>3M™ Cubitron™ II Hookit™ Clean Sanding Abrasive Disc, 3 in. / 75mm, grade 80+,</p> <p>3M™ Cubitron™ II Hookit™ Clean Sanding Sheet Roll, 70mm x 12m / 2 3/4\"</p>
Final Sand and Inspect		<ul style="list-style-type: none"> • Use a DA sander to finish sand the repair area using a 320-grade abrasive disc. Blow off and inspect the repair quality. 	 <p>3M™ Cubitron™ II Hookit™ Clean Sanding Abrasive Disc, 3 in. / 75mm, grade 320+</p>