

**Important note on process safety**  
Always wear Personal Protective Equipment

• Comfort Particle Mask P3



• Hearing Protection



• Comfort Goggles



• Reusable Overall



• Safety Gloves



### 1 Cleaning of the surface



- Degrease the surface using 3M™ VHB Surface Cleaner to remove any oil or grease on surface.
- Degreasing the surface helps to provide optimal bonding of the adhesive.



3M™ VHB Surface Cleaner



3M™ Professional Panel Wipes

### 2 Pre-sanding of the repair area



- Prepare area with 3M™ Cubitron™ II Roloc™ Discs 80+.
- Note:** Plastic is a very soft substrate! Pay special attention as using excessively coarse abrasives can badly damage the surface and plastic fibres.



3M™ Pistol Grip Disc Sander



3M™ Cubitron™ II Roloc™ Discs

### 3 Preparation of the repair area



- Drill several holes of 3 - 6 mm in diameter in the remaining part of the tab to increase the strength of the repair.

### 4 Cleaning of the surface



- Clean the area with 3M™ VHB™ Surface Cleaner.



3M™ VHB Surface Cleaner



3M™ Professional Panel Wipes

### 5 Application of Adhesion Promoter

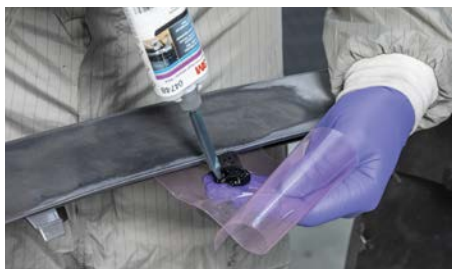


- Apply 3M™ Polyolefin Adhesion Promoter on the repair area and allow 10 minutes to dry.
- Attention:** Do not use an adhesion promoter on ABS-type plastics.



3M™ Polyolefin Adhesion Promoter

### 6 Application of 3M™ Superfast Plastic Repair Adhesive



- Cut the 3M™ Contour Sheet to the size of the tab to be repaired.
  - Extrude the 3M™ Superfast Plastic Adhesive onto the 3M™ Contour Sheet and press the film with the adhesive from below.
- Note:** When using a new cartridge, squeeze out a small amount of material until both components are equally extruded. Then discard the first 2 - 4 cm of extruded material, to remove any improperly mixed material.



3M™ Plastic Contour Sheet



3M™ Super Fast Repair Adhesive



3M™ Manual Gun for 2 part cartridges

### 7 Processing 3M™ Superfast Plastic Repair Adhesive



- Place 3M™ Superfast Plastic Adhesive onto the contour sheet, immediately folding around the damaged area covering both sides of the repair.
- Hold in place for 90 seconds and remove film once the 3M™ Superfast Plastic Adhesive cured.
- Allow to fully cure for 5 minutes before starting sanding steps.

### 8 Rough Shape Damaged Tab



- Rough shape the repaired tab area with a 3M™ Cubitron™ II Roloc™ Discs 80+ to restore original tab dimensions.
- Drill a hole if required to create a new fixing point.



3M™ Pistol Grip Disc Sander



3M™ Cubitron™ II Roloc™ Discs

### 9 Fine sanding of the repair area



- 3M™ Cubitron™ II Disc P220+ grade.
- Please do observe the recommendations of your paint manufacturer when selecting and applying the recommended fillers and procedures for plastic parts.



3M™ Cubitron™ II Hookit™ Clean Sanding Abrasive Disc 75 mm, 220+



3M™ Random Orbital Sander, 75 mm

