



PD-700

Bumper Repair Systems

BUMPER REPAIR

This data sheet explains the steps necessary to repair or refinish fenders, bumper covers, dashboards and interior trim panels. Our repair procedures identify the three basic categories: flexible, rigid and extra rigid and then recommend specific procedures and products for repairing each type of plastic.



Features

- Suitable for rigid and flexible plastics
- Complete systems from repair to refinish

Compatible Surfaces

Rigid Plastics

- ABS - Acrylonitrile Butadiene Styrene
- E/P-TPO - Ethylene/Propylene Thermoplastic Olefin
- PC - Polycarbonate
- PP - Polypropylene
- TPO - Thermoplastic Olefin
- TPE - Thermoplastic Elastomer

- UP - Polyester Thermoset
- EPDM - Ethylene Propylene Diene Monomer
- Similar plastics

Flexible Plastics

- PUR - Polyurethane
- TPUR - Thermoplastic Polyurethane
- Similar plastics

Extra Rigid Plastics

- SMC - Sheet Molded Compound
- FRP - Fiberglass Reinforced Polyester
- PC/ABS
- HPA - Honda Polymer Alloy
- PPO/PA- Rigid Polymer Alloy
- GTX - Alloy blend of nylon
- Similar plastics

Related Products

- SX1002 Sanding Paste
- SX1004 Plastic Cleaner & Prep
- SXA1030 Black Guide Coat
- SX1040 Accessory Black - Gloss
- SX1041 Bumper Black
- SXA1043 Flexible Sealer
- SX1044 High Build Flexible Surfacer
- SX1046 Accessory Black - Matte
- SX1047 High Build WB Flexible Surfacer
- SX1048 2K Polyester Glaze
- SX1049 Plasti-Bond
- SX1052 2-Pack Urethane Filler
- SX1053 Repair Tape
- SX1056 Flexible 2K Sealer
- SX1057 Flexible 2K Surfacer



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Surface Preparation:



1. Apply **SX1002 Sanding Paste** and abrade with a gray scuff pad, then rinse well with water.
2. Apply **SX1004 Plastic Cleaner & Prep** using a clean, lint free towel and wipe in one direction.
3. Rinse well with water and dry.

NOTE: You do not have to bake (sweat) bumpers before painting.

Repairing Flexible Plastics:



1. Grind repair areas with 24 grit at low RPM's to prevent the melting of the plastic. Make a "V" Shape groove. Feather edge the repair area with 80 grit. If there is a tear or a hole use **SX1053 Repair Tape** to reinforce the area on the back and front.
2. Re-clean with **SX1004 Plastic Cleaner & Prep**.
3. Apply a sufficient amount of **SX1052 2-Pack Urethane Filler*** to fill area to be repaired.
4. Allow to dry 15-20 minutes before sanding with 80-180 grit sandpaper.
5. Low spots can be filled with **SX1048 Polyester Glaze** and re-sanded.

Repairing Rigid Plastics:



1. Grind repair areas with 24 grit at low RPM's to prevent the melting of the plastic. Make a "V" Shape groove. Feather edge the repair area with 80 grit. If there is a tear or a hole use **SX1053 Repair Tape** to reinforce the area on the back and front.
2. Re-clean with **SX1004 Plastic Cleaner & Prep**.
3. Apply a sufficient amount of **SX1049 Plasti-Bond*** into the fill area to be repaired.
4. Allow to dry 15-20 minutes before sanding with 80-180 grit sandpaper.
5. Low spots can be filled with **SX1048 Polyester Glaze** and re-sanded.

NOTE: Sand all surfaces at low speed to prevent melting of plastic.

***The SX1054 Cartridge Applicator Gun should be used to apply the SX1052 2-Pack Urethane Filler and SX1049 Plasti-Bond.**

1. Insert **SX1052** or **SX1049** cartridge into **SX1054 Cartridge Applicator Gun**.
2. Squeeze trigger to dispense 2-3 inches of test material to make certain color is uniform before applying to job.
3. Dispense repair material and apply 2-3 inches beyond the damaged area.
4. Spread mixture with a plastic spreader or putty knife. Press material firmly in repair area to avoid air pockets. Build repair material higher than surrounding area to allow for sanding.
5. After the repair has cured 15-20 minutes, sand with 80 grit paper.
6. For slight imperfections, re-apply a skin coat of the repair material or **SX1048 2K Polyester Glaze**.
7. Finish with 180 grit paper and refinish the repair area.

Refinishing the Repair Area:

1. Wipe surfaces clean using a clean dry towel and tack off with a tack rag.



2. Apply 2 medium coats of **SX1043 Flexible Sealer** allowing 5-10 minutes between coats. Allow 30 minutes dry before priming.



3. To fill in minor scratches and imperfections, apply 2-3 coats of **SX1044 High Build Flexible Surfacer** or **SX1047 High Build WB Flexible Surfacer**. Using a 1.8-2.0 fluid tip (conventional) or 1.4-1.6 fluid tip (HVLP). Allow 30-40 minutes dry time before sanding when using WB sealer.



4. Apply one light coat of **SX1030 Black Guide Coat** before sanding to assist in finding high and low spots.

5. Final sand with 320-400 grit sandpaper.

Topcoat with **SX1041 Bumper Black**, **SX1040/SX1046 Accessory Black** or the appropriate PPG topcoat color system. Refer to the appropriate PPG bulletin for specific instructions.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.

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