

Best Practices for Two-Sided Bumper Repair Using Adhesives

- **Wash Entire Bumper with soap and water.**
- **Clean bumper with a water based wax & grease (W&G) remover.**
- **Always wear proper PPE when repairing a plastic part.**
- **Sand front and back of bumper with 80 grit DA (at low speeds so that the rubber does not melt).**
- **Clean sanded area with water based W&G Remover (using a solvent base wax and grease remover will lead to a bumper repair failure) to remove mold release material.**



- **Apply Aluminum tape with a squeeze, to the front side of the repair.**



- **Apply 2 part epoxy repair material to the backside repair area and push material into the bumper for epoxy to be higher than the surrounding area on the front of the bumper (sand front side epoxy flush with surrounding area of the repair—a second coat of epoxy will not be necessary) No adhesion promoter is needed with Kent Automotive plastic adhesives (3M needs an adhesion promoter before applying their adhesives).**



- **Apply two strips of reinforcing tape to the backside of the bumper (second strip is applied at 45 degree angle to first strip).**
- **Apply 2 part epoxy over the reinforcement tape on the backside repair a smooth with a plastic spreader.**



- **Allow to dry and remove aluminum tape from the front side of the repair.**



- **Sand front side with 80 grit DA.**
- **Clean with water based W&G Remover.**
- **Apply 2 part epoxy ES to front side.**



- **Sand area with 220 grit DA.**
- **Primer as necessary (Use Kent High Built primer with built in flex additive or equivalent to save time and materials).**

This document is courtesy of Kent Automotive's Partners in Profitability Program