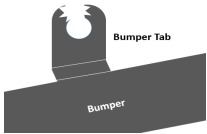

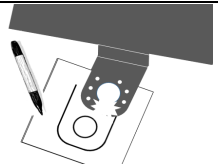
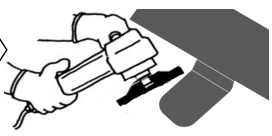


Plastic Tab Repair

Repair of Broken Bumper Tab on Rigid & Semi-Rigid Plastic

Inspect	1	Inspect the broken tab. If tab is torn, follow steps below. If tab is completely missing, re-create the tab or bond on another tab.	
	2	Wash part with warm water & soap (silicone & oil free) to remove contaminates. Assure all silicones are removed. Dry part completely.	
Clean	3	Clean with water-borne degreaser, Aqua SCAT 2 #1391/4.	
Sand	4	Using a 50-80 grit disc, grind the end of the tab. Grind front & back of tab to a taper.	
	5	Sand repair area with 80 grit on palm sander.	
	6	Feather back using 150 grit on palm sander. Sand 1" from damage area where adhesive will be applied.	
Drill	7	Drill 1/8" holes along broken edge of tab area approximately 1/4" apart - to allow adhesive to flow from one side of tab to other side.	
Clean	8	Blow off part. Clean with water-borne degreaser, Aqua SCAT 2 #1391/4. Blow off again to remove lint.	
Prep	9	Spray light coat of Mul-Tie Adhesion Promoter, #1031/33 onto repair area. Allow to flash for 15 minutes.	
	10	From Universal Quick Adhesive #1458 package (foil bag), cut a piece of packaging material. Trace shape of tab onto packaging material using a permanent marker.	
	11	Insert cartridge in gun. Equalize cartridge by dispensing material until both components flow equally. Then attach nozzle. Gun out nozzle length of material to ensure proper mixing. Refer to TDS.	
Repair	12	With bumper laying flat & tab facing up, align packaging material with traced tab behind broken tab. Support packaging material with a spreader or hands. Then gun out Universal Quick Adhesive #1458 onto packaging material. Make sure adhesive extends 1" past original length & width of plastic tab.	
	13	Wrap packaging material around the tab location. Apply light pressure & sandwich adhesive between plastic packaging to create proper thickness. Do not apply excess pressure & cause adhesive to be too thin.	
	14	Allow adhesive to set-up 30-60 seconds, then release pressure & allow to finish drying.	
Cut	15	After 1-2 minutes, before completely drying, rough cut the new tab slightly larger than the desired tab size.	
Sand	16	Once tab is fully cured (approx 5 minutes) remove plastic from around tab. Grind rough formed tab into final shape using 50-80 grit disc. Important: If plastic bag adheres to the tab, remove foil with grinder.	
	17	Sand tab & repair area with 150 grit on DA sander.	
Drill	18	Drill hole in tab to proper size for clip / bolt to attach bumper to vehicle.	

● For finishing repaired plastic, see SOP 251.

SUGGESTED MATERIALS FOR JOB

- Soap & water ● Lint-free Towels ● Transtar Waterborne degreaser, #1394 ● Grinder & 50-80 grit disc ● Drill & Bits
- Razor Blade / Knife ● Marker / Sharpie ● Transtar Mul-Tie Adhesion Promoter #1031
- Transtar 2-Part Universal Quick Adhesive #1458 ● Transtar Dual-Mix Side-Load Gun #4440
- Adhesive Spreader ● Sandpaper – various grits ● Sanding blocks ● DA Sander

* Always refer to Transtar Technical Data Sheet (TDS) for specific product application, suitable substrates & other product information.