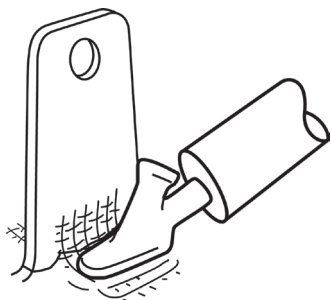


Repairing Flexible Tabs on TEO Plastics

Many TEO bumpers have mounting tabs that have to flex during installation. These can be repaired very durably with the mesh and FiberFlex®. First, rough grind the area with a coarse sandpaper disc.

Cut 2045W stainless steel wire mesh to size to fit in the corner areas on both sides of the tab. Using the hot welder tip, bury the mesh directly into the plastic. After you've melted the mesh into the plastic, scuff the melted plastic with coarse sandpaper to remove the gloss.

Melt on a thin layer of FiberFlex® over the mesh just to cover. In this repair, the mesh provides the strength and flexibility while the FiberFlex® just gives a cosmetic covering.



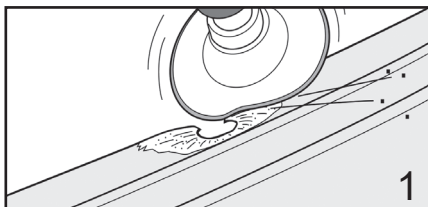
Repairing Torn Tabs

Rough grind the area surrounding the crack with a coarse Roloc™ disc.

Cut 2045W stainless steel wire mesh to size to fit in the corner areas. Using the hot welder tip, bury the mesh directly into the plastic. (This won't work on urethane parts since they don't melt. See Page 7). After you've melted the mesh into the plastic, scuff the melted plastic with coarse sandpaper to remove the gloss.

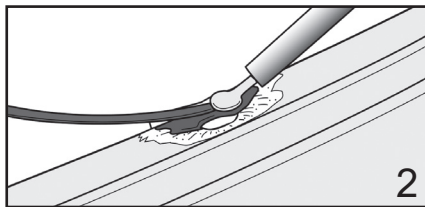
Melt either the FiberFlex® or the matching standard plastic rod over the mesh. If using the standard rod, keep the heat on the plastic to make sure the rod melts thoroughly with the base material. Keep adding more rod to make a bigger fillet and increase strength.

Repairing Torn Bolt Holes in TPO with FiberFlex®



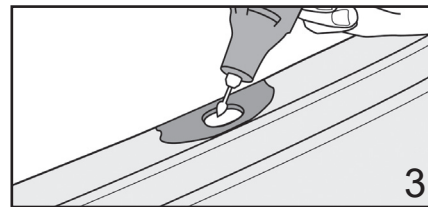
Taper both side of plastic to a point with a coarse sandpaper disc. Grind and taper around the edges of the entire bolt hole. Taper back about 1 inch on all sides. Remove paint and radius into taper with 80 grit in a DA.

Apply aluminum tape across the gap to support the melted rod while it's hot.



Melt 2045W Stainless Steel Reinforcing Mesh into the plastic across the gap if desired for extra strength. This step is often not necessary because FiberFlex® is blended with glass fibers for strength.

Apply FiberFlex® to area using the instructions on Page 6. After cooling, remove aluminum tape and repeat on opposite side.



Allow FiberFlex® to cool completely. Open the hole with a die grinder or drill bit, then sand with 80 grit in a DA at low speed to finish the repair.

Padded Dash Repair

Clean the damaged area with 1000 Super Prep Plastic Cleaner or 1001-4 EcoPrep Plastic Cleaner. Bevel the edges of the area to be welded with a drum sander on an electric die grinder and open up a cavity at least 1/4" deep in the foam backing and vinyl cover. Sand and bevel the vinyl cover around the cavity to allow for featheredging of filler.

Using the R01 urethane or R10 FiberFlex® welding rod, start your weld at the bottom of the cavity using your airless plastic welder. Fill the cavity up with melted plastic and spread it out so that it overlaps the edges of the vinyl cover about 1/4".

After allowing the weld area to cool, grind the weld area smooth with a drum sander. Rough up the surrounding area to improve adhesion of the filler. Mix 2050-9 Padded Dash Filler and apply with plastic squeegee. Cover an area larger than the weld in order to feather out the repair to a smooth contour.

Allow the filler to cure at least 15 minutes, then sand to a smooth contour. Finish sand with 220 grit paper. Retexture the panel with 3804 FlexTex VT texture material according to directions on the can. Do not try to spot retexture. Retexture and blend the leading edge or most visible area of the pad all the way across. If there is a noticeable difference in texture, retexture the entire pad.

