# **Standard Operating Procedures Truck Repair**

## **Back Side Reinforcement (SMC, FRP, Composites)**



#### Clean the Damaged Area

Clean the repair area with soap and water followed by a VOC compliant surface cleaner making sure to minimize the exposure of damaged or exposed fibers to the cleaners. Thoroughly dry the part. Do not apply any other cleaners throughout the remainder of the repair procedure.



#### **Surface Preparation**

Grind the backside of the repair with a grade 60 3M™ Roloc™ Abrasive Disc on a pistol grip grinder set at a low speed. When finished the sanded area should be at least 2 in. larger than the repair area. Remove sanding debris from the surface using clean compressed air and a clean, dry rag.



#### Adhesion Promoter

No adhesion promoter is needed for SMC or FRP repairs. If repairing Metton® Liquid Molding Resin, apply a light, consistent coat of 3M™ Polyolefin Adhesion Promoter to the repair area. Allow to dry for at least 5 minutes.



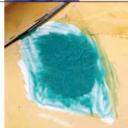
#### Alignment

Align the front side of the repair and cover the damaged area with Scotch® Auto Body Repair Tape to keep the adhesive from the back side from flowing through to the front side.



#### **Prepare and Apply Reinforcement Material**

Cut a piece of fiberglass matting 1-1/2 in. larger than the damaged area. Following product instructions, apply a "tight coat" of matting adhesive to the repair area to ensure good contact with the composite. Place the fiberglass mat on a clean, dry work surface. Saturate the entire section of mat with matting adhesive on both sides and apply it over the "tight coat" on the repair. Apply more 3M™ Fiberglass Mat Adhesive if necessary.



Allow the matting adhesive to cure for 45 minutes at 75°F.

Visit 3MCollision.com for more SOPs and videos

#### **Product List**

3M™ Car Wash Soap Concentrate, 5 gallons, PN 38378

3M™ Specialty Adhesive Remover, 15 oz. aerosol, PN 38987

3M<sup>™</sup> Cubitron<sup>™</sup> II Fibre Roloc™ Disc, grade 60+, 3 in. (75mm), PN 33391

3M™ Pistol Grip Disc Sander, PN 33577

3M™ Polyolefin Adhesion Promoter, PN 05907

Scotch® Auto Body Repair Tape, 2 in. x 125 in., PN 95331

3M™ Aluminum Foil Tape 425, Silver, 2 in. x 60 yd., 4.6 mil, PN 95072

Scotch® Performance Green Masking Tape 233+, 48mm width (1.9 in.), PN 26340

Dynatron™ Fiberglass Mat, 8 sq. ft., PN 00688

3M™ Fiberglass Mat Adhesive, 400mL, PN 08277

3M™ Performance Pneumatic Applicator for 400mL cartridges, PN 08280

Marson® Yellow Spreaders, PN 20395





















### **Think About Your Health**

3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300

3M<sup>™</sup> Half Facepiece Respirator, PN 07182

3M™ Virtua™ CCS Protective Evewear with Foam Gasket. PN 11872



Not a complete list. Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.

# **Individual Product Instruction and Safety Information**

For individual product instructions and applicable precautions see product labels and associated literature for the individual product at **3MCollision.com** 

For product material safety data sheets see 3MCollision.com

**Technical Information:** The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.

**Product Use:** Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user's method of application.

Warranty, Limited Remedy and Disclaimer: Unless an additional warranty is specifically stated on the applicable 3M product packaging or product literature, 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY IMPLIED WARRANTY OR CONDITION ARISING OUT OF A COURSE OF DEALING, CUSTOM OR USAGE OF TRADE. If the 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M's option, replacement of the 3M product or refund of the purchase price.

Limitation of Liability: Except where prohibited by law, 3M will not be liable for any loss or damage arising from the 3M product, whether direct, indirect, special, incidental or consequential, regardless of the legal theory asserted, including warranty, contract, negligence or strict liability.

**IMPORTANT NOTE:** There are of course many factors and variables that can affect an individual repair, so the technician and repair facility need to evaluate each specific application and repair process, including relevant vehicle, part and OEM guidelines, and determine what is appropriate for that repair.



3M Automotive Aftermarket Division 3M Center, Building 223-6N-01 St. Paul, MN 55144-1000 U.S.A.

3M, Accuspray, Dynatron, E-A-R, Green Corps, Highland, Hookit, Lexa, Perfect-It, Platinum, Roloc, Scotch, Scotchblok, Scotch-Brite, Skull Screws, Trizact and Virtua are trademarks of 3M Company. Marson is a trademark of Alcoa, Inc. Metton is a trademark of Metton America, Inc.

Please recycle. Printed in U.S.A. © 3M 2017. All rights reserved.