



## Procedure For Repairing Truck Bumpers With Fusor® Body Repair Systems

### Materials Needed:

- Adhesion Prep/Cleaner
- Fusor #200 Quik Stik
- Fusor #702 Fiberglass Cloth
- Fusor #T11 Truck Plastic Repair Adhesive (Fast-Set)
- Fusor #304 Pneumatic Dispense Gun or #301 Manual Dispense Gun
- Fusor #704 Saturation Roller (Heat-Set)
- Fusor #140/141 Clear Plastic Structural Installation Adhesive (Fast-Set)
- Fusor #602 Plastic/Bumper Trim Surface Modifier (Aerosol Spray)

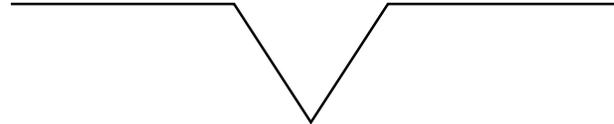
*When application instructions are carefully followed, Fusor® bumper repair products will produce Class-A repairs on a regular basis.*

### Surface Preparation

1. Cover the damaged area of the bumper with masking tape.
2. Clean the repair area using adhesion prep/cleaner. For hardened tar and sap deposits, consider using a wax and grease remover. Repeat Steps 1 and 2 on the back of the bumper if a backing patch is needed.
3. If necessary, align the damaged area with tape, clamp or use Fusor Quik Stik (Stock #200).
4. Using a D/A sander with 80-grit sandpaper at low RPMs, remove paint surrounding the damaged area. Cove out the damaged area, leaving rounded edges, rather than V-groove it (**See Illustrations A and B**). **Caution: Sand slowly to avoid melting the plastic. Melted plastic cannot always be detected with the unaided eye, and it cannot be bonded.**
5. If a backing patch is being applied, D/A sand the back of the bumper with 80-grit sandpaper at low RPMs to remove paint and roughen the surface surrounding the damaged area.
6. Follow the D/A sanding with 80-grit hand-sanding to remove any melted plastic on the surface. Blow off the repair area with an air gun. Be sure that the air does not have any oil or water in it.

**Note: Do not use any cleaners, as you may contaminate the repair area.**

**Illustration A: V-Groove : DO NOT USE!**



**Illustration B: Taper/cove: USE!**



Note: Not drawn to scale

### Application Procedure

#### Backing Patch

*A backing patch is required if the damage penetrates through the bumper cover.*

1. Cut a piece of Fusor Fiberglass Cloth (Stock #702) to cover the entire repair area.
2. Cut a piece of the pink plastic membrane that is larger than the patch.
3. Set up a dispensing gun using Fusor Truck Plastic Repair Adhesive (Fusor #T11, Fast-Set) as follows:
  - a. Insert cartridge into the dispense gun.
  - b. Remove the plastic end caps and squeeze out a small amount of material until both parts of the adhesive dispense equally.
  - c. Attach the mixer to the end of the collar and secure tightly. Dispense a small amount of the adhesive through the mixer (approximately a mixer length).
4. Apply the Fusor Truck Plastic Repair Adhesive onto the plastic membrane. The adhesive should cover about the size of the patch. Spread the adhesive out and lay the fiberglass patch in the adhesive. Dispense more adhesive and spread it over the fiberglass patch.  
**Option: Use two layers of fiberglass mesh/cloth to reinforce the bumper even more.**
5. Lay the patch onto the repair area with the plastic membrane facing out. With a Fusor

Saturation Roller (Stock #704), smooth out the material and let it cure with the plastic membrane left on. Once cured, remove the plastic membrane.

**Cosmetic Side**

1. Apply Fusor Truck Plastic Repair Adhesive in two layers. Work the first layer into the plastic with an acid brush or spreader. Immediately apply a second, thicker coat and spread it over the entire area. Feather-edge onto the undamaged area.

**Note: The repair material should be slightly higher than the bumper surface to allow for sanding. As an alternative, Fusor Truck Plastic Adhesive can be applied in one step.**

2. Place the plastic membrane over the repair. Allow at least 20 minutes cure time before rough-sanding. One to two hours is preferred on the TPO and TPE bumpers before final sanding.
3. Slowly rough-sand the repair material with a D/A sander using 80-grit sandpaper. Start in the middle of your repair material and work toward the outer edges. Then, move to 180-grit sandpaper. This will provide better feather-edging. For optimal results, contour with a block sander using 220-grit or 320-grit sandpaper.
4. Paint per manufacturer's recommendations using a high-build primer.

**Bumper Tab**

*Torn tabs on the bumpers can be repaired in a manner similar to that described in this repair procedure.*

1. Hand-sand the area around the torn tab. Blow away any debris.
2. Apply Fusor Surface Modifier (Stock #602) and let it dry 10 - 15 minutes.
3. Cut a patch of Fusor Fiberglass Cloth (Stock #702) to use as reinforcement.
4. Apply Fusor Clear Plastic Structural Installation Adhesive (Stock #141/140, Fast-Set) to the fiberglass reinforcement. Spread the adhesive

with the end of the adhesive mixer and wrap the adhesive-coated fiberglass on both sides of the tab area. Make sure that good contact with the bumper is made.

5. Hold the patch in place for about 3 minutes, or until it will stay in place by itself. After this cures, drill a hole to simulate the original tab.

**Technical Tips:**

- If a bumper was hit and appears to be dented, apply light heat to the damaged area to allow the plastic to come back to its natural state. If you don't, it may come out in the bake oven, resulting in a "bull's-eye" in the repair area.
- When working in difficult areas such as corners, apply the adhesive to the repair area and lightly spread it. Then, lay a piece of plastic membrane over the repair. This will help contour the repair material to the bumper.