

# Minor Repair Process - Plastic



**STEP 1:** Clean and inspect damage. Use **Permaloid® Silicone Remover 7010** and **Audurra Degreasing Cloth**.



**STEP 2:** Sand with **Audurra Premium Sanding Disc B/C** to remove damage.



**STEP 3:** For deep damage apply **Raderal® Plastic Putty 2015 black**. Optional: Prior to the putty apply **Permacron® 1K Elastic Primer 3410**.



**STEP 4:** Sand to shape with **Audurra Premium Sanding Strip B** refine the repair surface with grade C.



**STEP 5:** Feather the repair area with **Audurra Premium Sanding Disc C/D** Hand sand corners and edges with **Audurra Sanding Sponge Green** or **Soft roll D**.



**STEP 6:** Apply **Permacron® 1K Elastic Primer 3410**. Flash off. Apply a suitable **Permasolid® HS Surfacer** elastified with **Permasolid® Elastic Additive 9050**.



**STEP 7:** Hand sand corners and edges with **Audurra Ultrafine Sanding Sponge Flex**. Machine sand with **Audurra Premium Disc D** with suitable soft backing pad. Remove sanding dust and clean.



Follow the particular OEM process/ guidance on bumper repair. Pay attention to the film build limitations/sensor requirements. Follow relevant Spies Hecker product TDS's. For detailed information regarding suitable plastic substrates, please refer to the Spies Hecker Plastic Painting System TDS - SHPlasticSystem.

This Minor Repair Process - Plastic has been performed using products from the Spies Hecker product range.



Spies Hecker – simply closer.

