3- FOR EPOXY RESIN

Use only for RTM thermosetting plastics

Repair-40x01x45x10-02x60-1-1-1.xml

XSL version : 3.02 du 22/07/11

PLASTICMATERIALBODYWORKCOMPONENT:REPAIR

Note, one or more warnings are present in this procedure

1. PROCEDURES FOR REPAIRING PLASTICS

WARNING

Always wear protective gear (gloves, goggles and breathing masks).

Use extra ventilation source.

Use a supplied air mask if the area is not ventilated.

1- SPECIAL NOTES FOR REPAIRING PLASTICS

- Procedure 1 : repairing a deep scratchon a plastic chassis element.
- Procedure 2 : repairing a crackon a plastic chassis element.
- Procedure 3 : repairing a holeon a plastic chassis element.
- Procedure 4 : repairing a mounting bracketon a plastic chassis element.
- Procedure 5 : partial replacementof an element by cuting.
- Procedure 6 : partial replacementof an element by cuting with patcht drilling.

2. PROCEDURE 1

Repairing a deep scratch on a plastic chassis element

1- BONDING METHOD

Note:

Before any repairs, check the reparability of components made from plastic materials.

(see 50A, General information, Products for plastic material bodywork components: Description) .

(see 50A, General information, Plastic material bodywork component: Precautions for the repair) .

- Wash the component in soapy water and rinse in clean water.

- Clean the area to be repaired with a LINT-FREE CLOTHsoaked in ANTISTATIC THINNERVehicle: Parts and consumables for the repair (04B, Consumables - Products).

- Wipe the area with a clean, dry LINT-FREE CLOTHVehicle: Parts and consumables for the repair (04B, Consumables - Products).

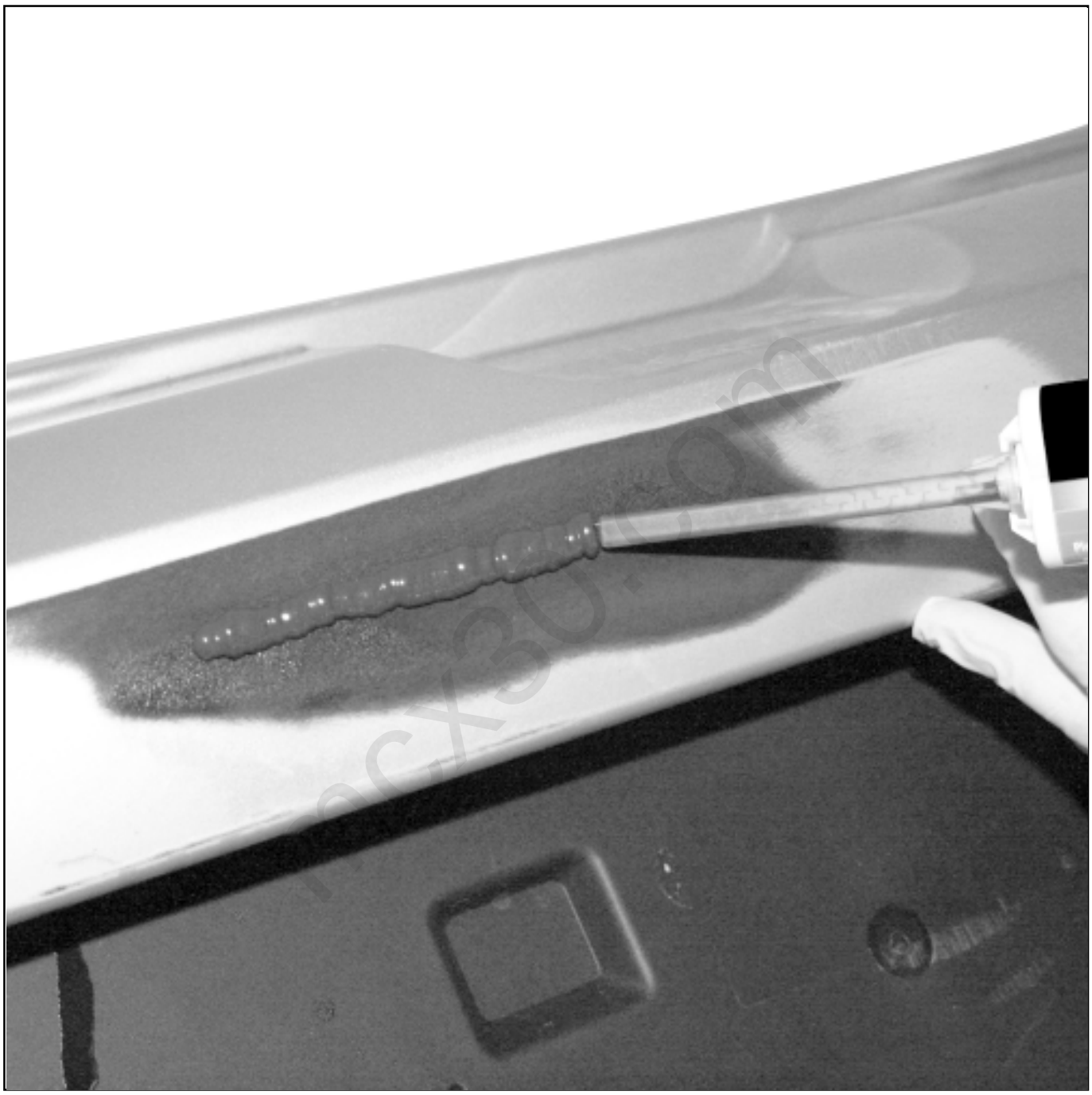
Surface the scratch using the orbital sander with a P 150.

- Blow the component and clean the area to be repaired with the cleaner included in the Plastic repair kit .

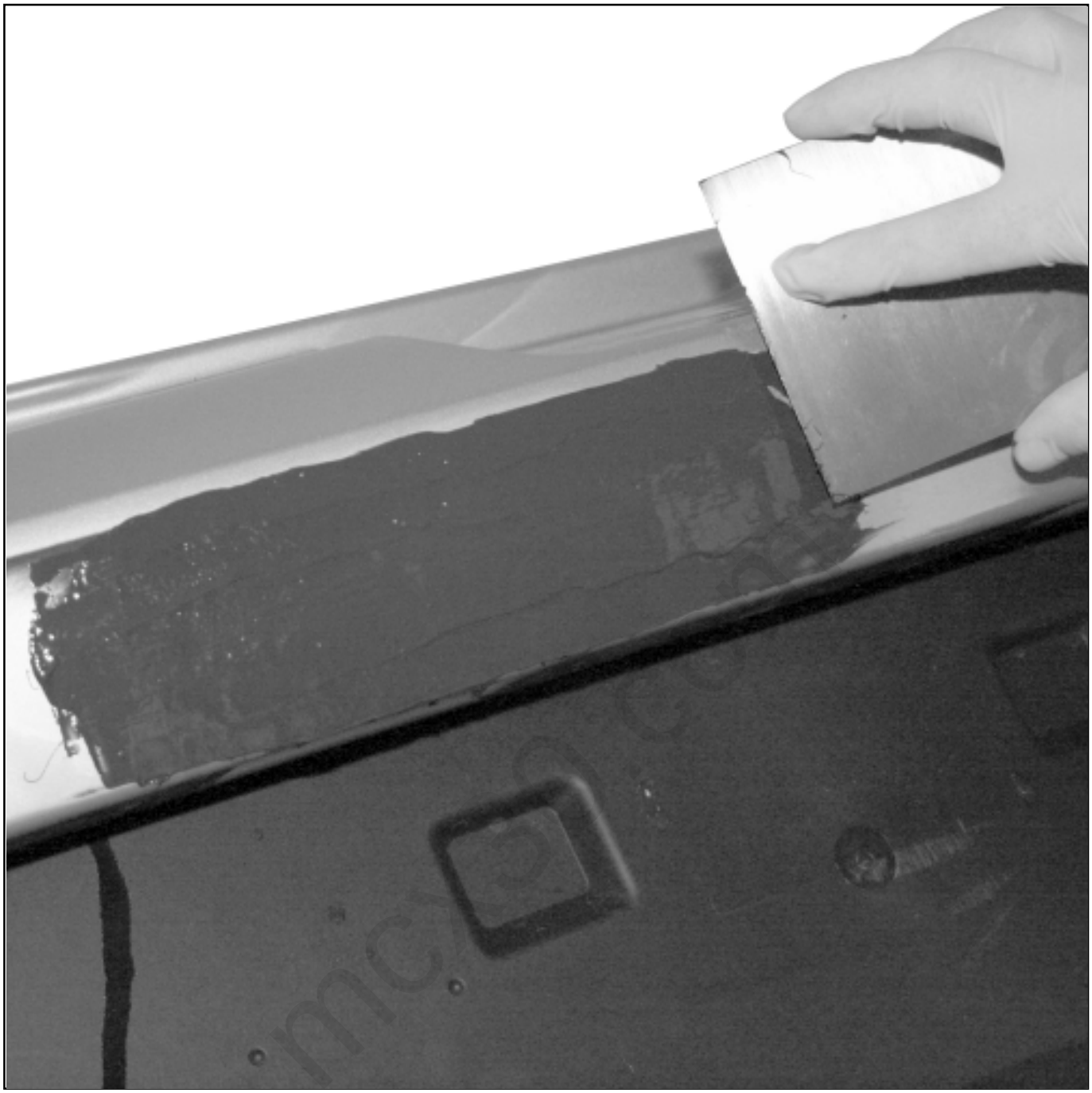
- Apply the adhesive primerincluded in the Plastic repair kitto the damaged area.

- Leave the adhesive primerto dry (see product technical sheet).

Prepare the bi-component repair mastic(see 50A, General information, Products for plastic material bodywork components: Description) .



Apply the bi-component repair masticto the component.



Smooth using a mastic block creating a dome shape.

Leave the bi-component repair masticto dry (see product technical sheet).

- Surface with a P 150then finish with a P 240.

- Blow the component and clean the area to be repaired with the cleaner included in the Plastic repair kit .

If necessary, apply a finishing mastic(see product technical sheet) **Vehicle: Parts and consumables for the repair** (04B, Consumables - Products).

Sand the finishing masticwith a P 150then finish with a P 240.

Follow the paint application procedure according to the material concerned:

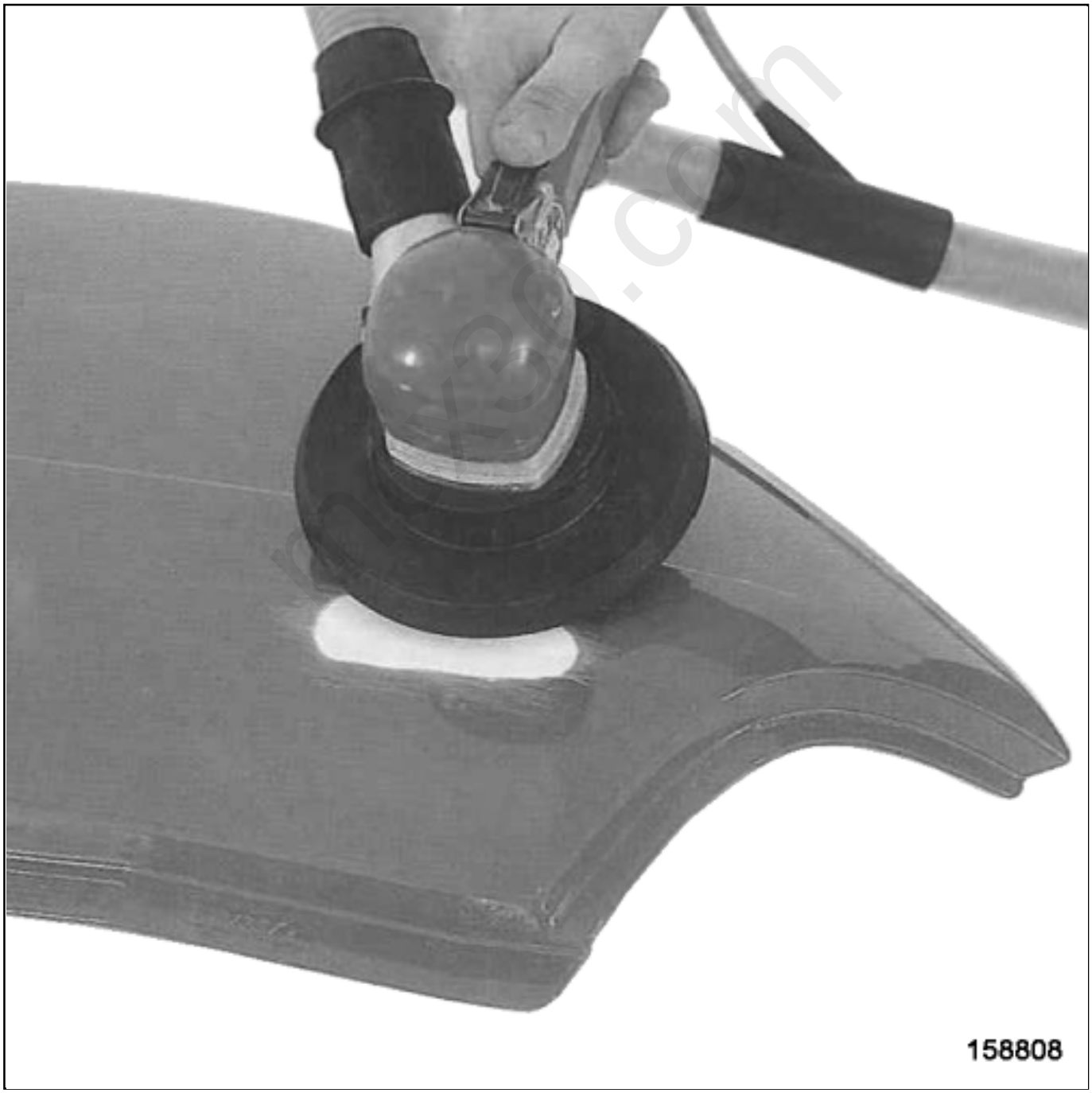
- SMC bodywork component: Preparation and paint range (Technical Note 592A, 95A, Paint application procedure on plastic),
- Polypropylene / polyethylene bodywork component: Preparation and paint range (Technical Note 592A, 95A, Paint application procedure on plastic),
- Noryl bodywork component: Preparation and paint range (Technical Note 592A, 95A, Paint application procedure on plastic),

ABS bodywork component: Preparation and paint range (Technical Note 592A, 95A, Paint application procedure on plastic).

2- RESIN EPOXY METHOD

Note:

Method apply only on RTM component.



Chamfering 20 to 30mm around the crack using the orbital sander with a P 150.

Sand the paint around the zone to be repaired using the orbital sander with a P 150

Blow the component and clean the area to be repaired with the Acetone(see product techincal sheet).

Prepare the Epoxy resin(see 50A, General information, Products for plastic material bodywork components: Description) .

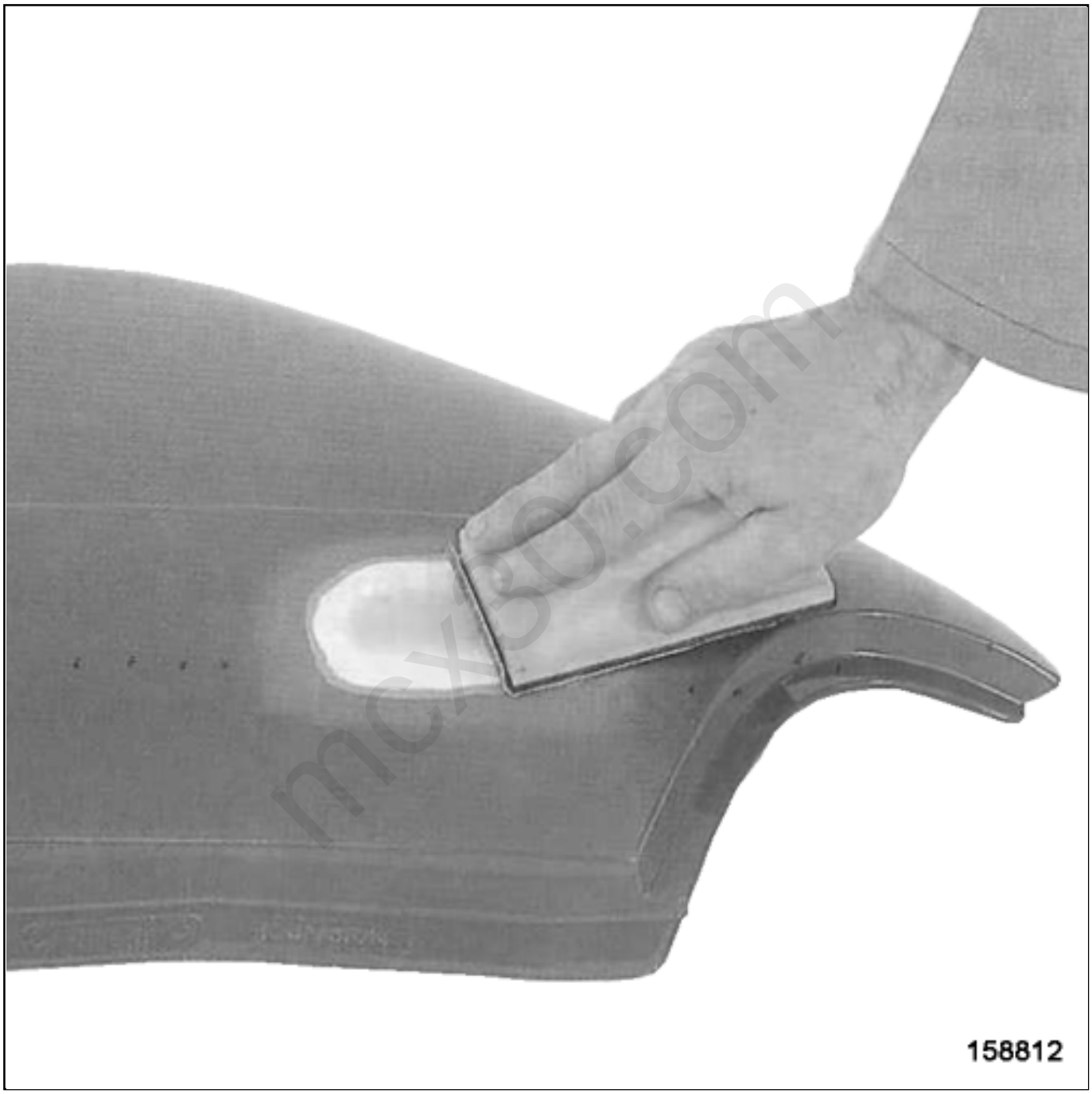
Wet the chamfer using à brush soaked with Epoxy resin.

- Add short fibres with resin(50 % maxi.).

- Apply the mixture using a spatula.

Note:

After 15 minutes,accelerate the hardening in drying oven or in infrared drying device(60° C maxi at a distance of 70 cm).



Sand using the orbital sander with a P 80then with a P180and P240.

Apply if necessary a finishing mastic(see product technical sheet). (see **Vehicle: Parts and consumables for the repair**)

Sand the finishing masticusing a P 150then finish using a P240.

3. PROCEDURE 2

Repairing cracks on a plastic chassis element.

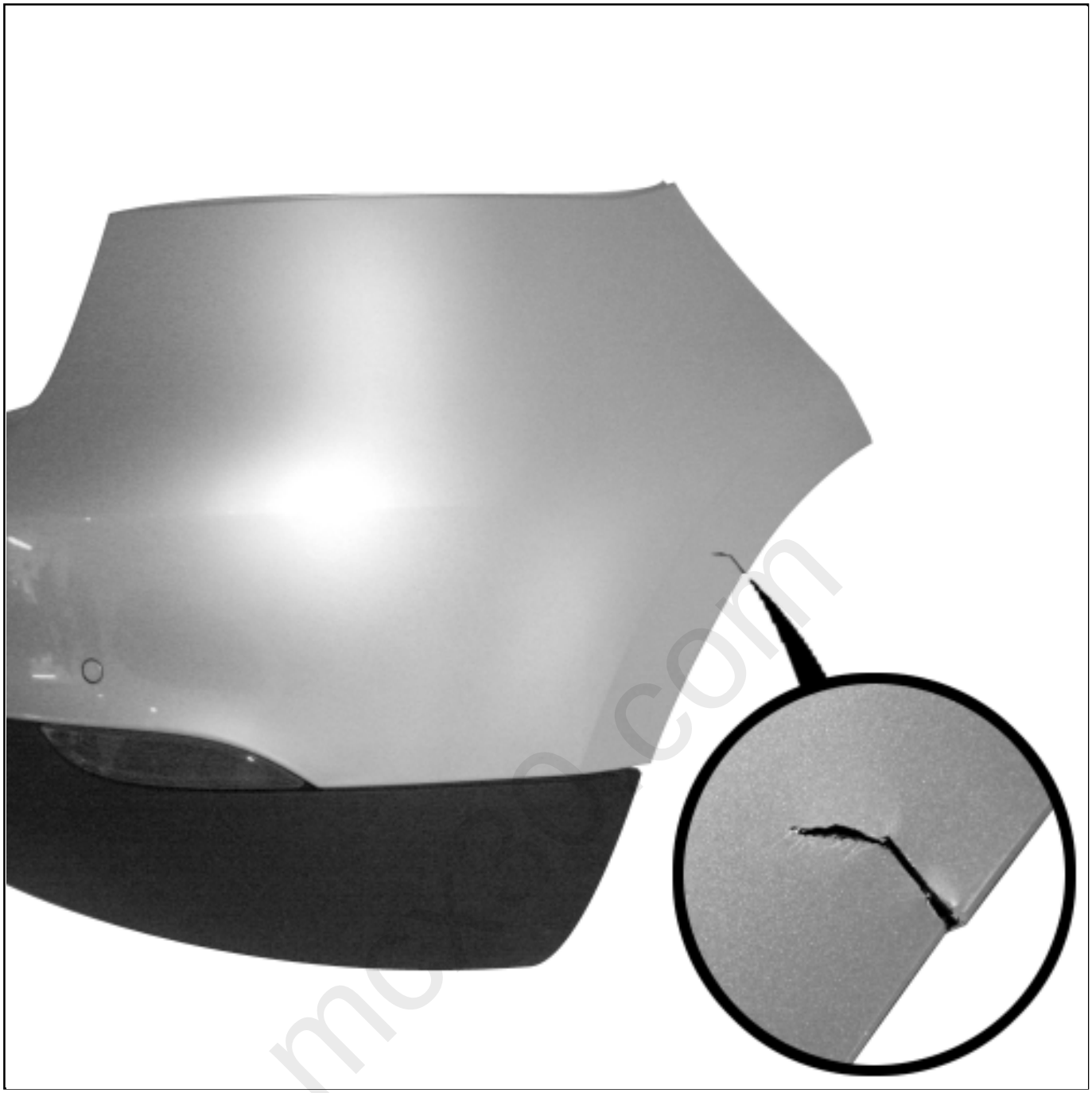
1- BONDING METHOD

Note:

Before any repairs, check the reparability of components made from plastic materials.

(see 50A, General information, Products for plastic material bodywork components: Description) .

(see 50A, General information, Plastic material bodywork component: Precautions for the repair) .



Wash the component in soapy water and rinse in clean water.

Clean the area with a clean, dry LINT-FREE CLOTH**Vehicle: Parts and consumables for the repair** (04B, Consumables - Products).

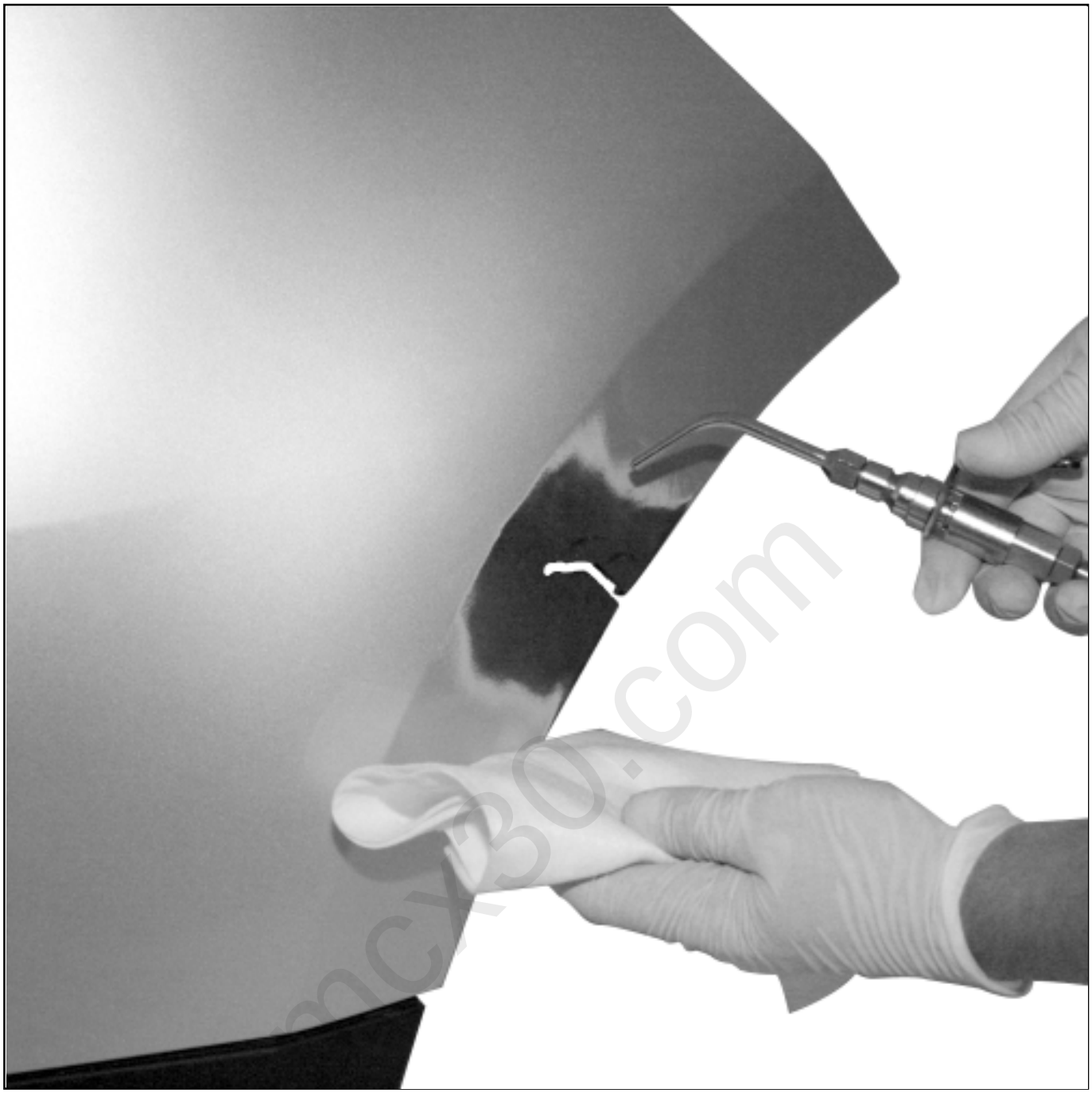
Wipe the area with a clean, dry LINT-FREE CLOTH**Vehicle: Parts and consumables for the repair** (04B, Consumables - Products).

Drill the end of the crack using a 4 mmdrill bit to stop it spreading.

Extend the length of the crack by 2 mmusing an angle grinderor a sharp tool.

Chamfer the crack on the exterior side using an angle grinder or a belt sander equipped with a P 120 abrasive pad.

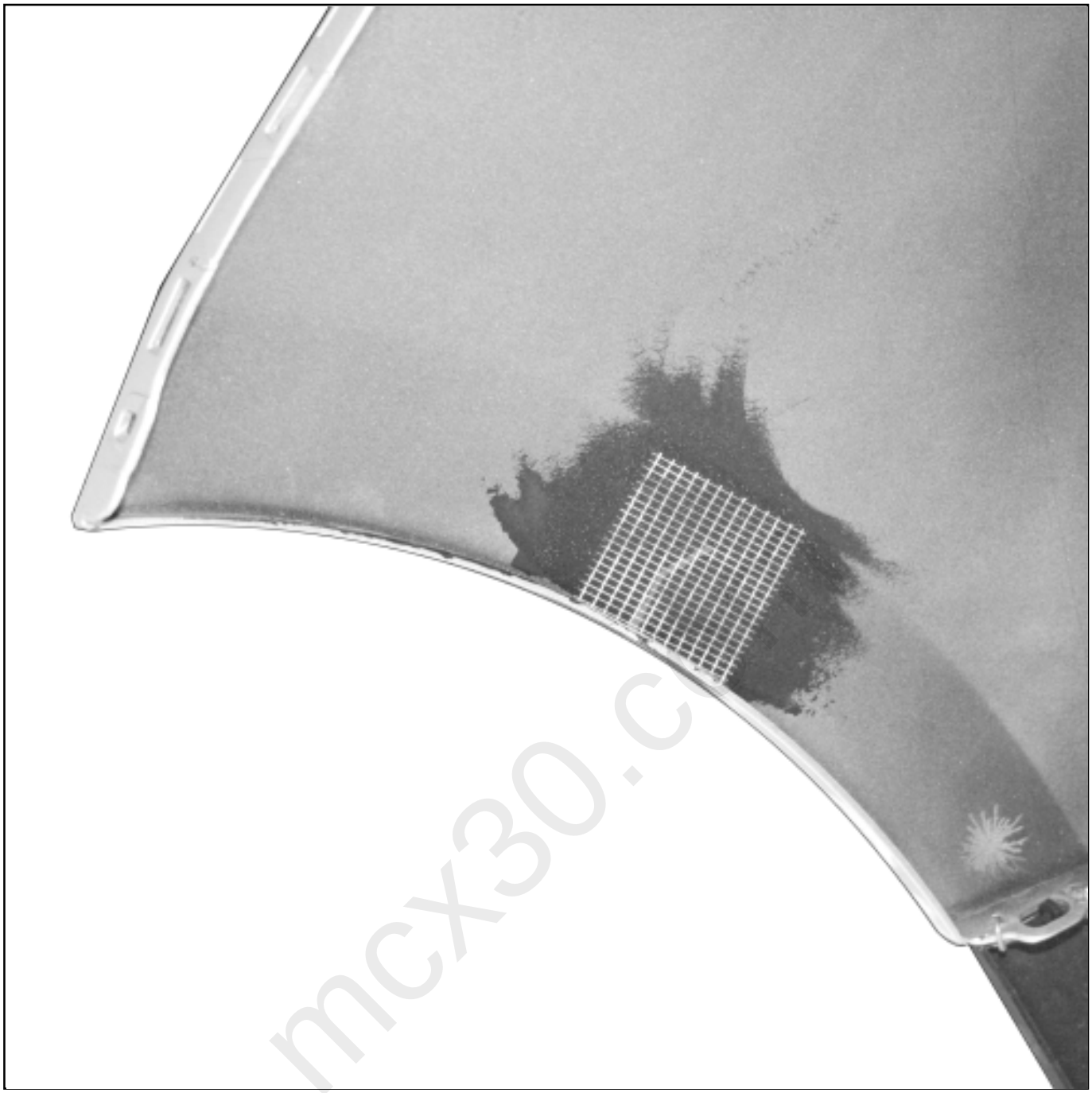
Surface the interior and exterior areas to be repaired with a P 150.



Blow the component and clean the area to be repaired with the cleaner included in the plastic repair kit box.

Apply the adhesive primerincluded in the plastic repair kitto the interior and exterior areas.

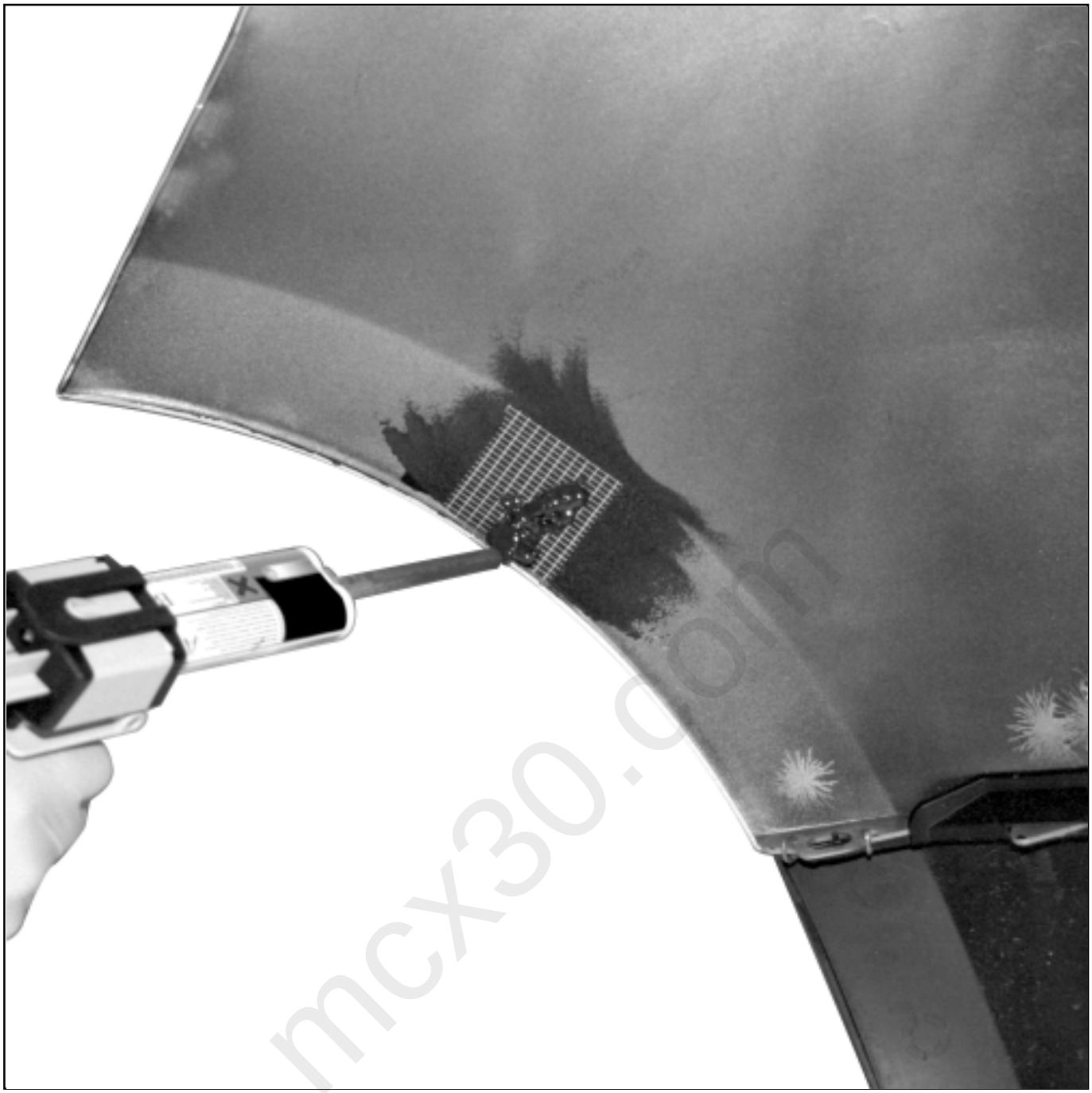
Leave the adhesive primerto dry (see product technical sheet).



Adjust a piece of reinforcing film (cloth)suitable for repairing the inside of the component.

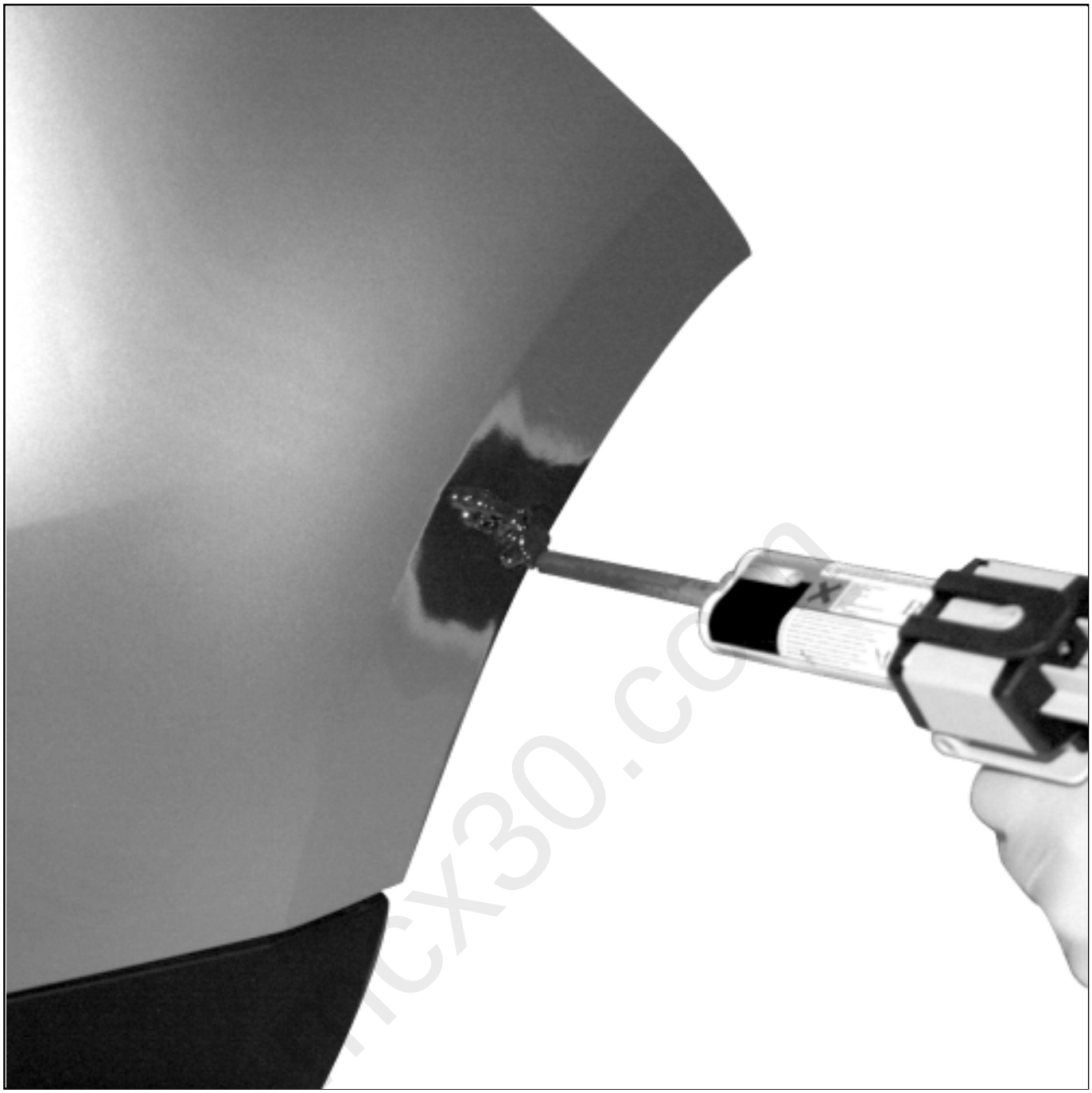
Prepare the bi-component repair mastic(see 50A, General information, Products for plastic material bodywork components: Description) .

Extrude a narrow bead around the area to be repaired on the inside of the component and apply reinforcing film (cloth).

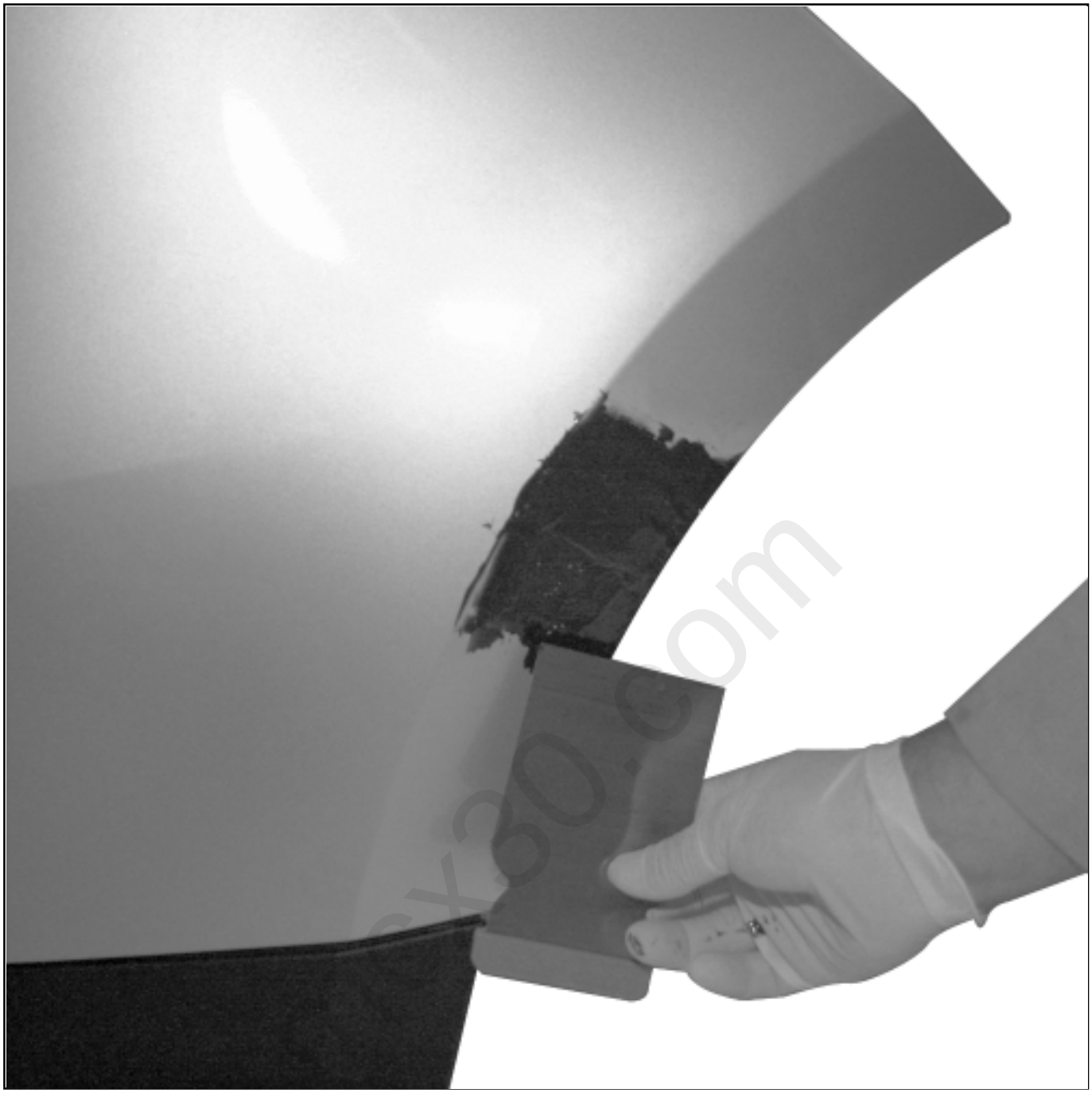


Extrude a thick bead on the reinforcing film at the crack.

Smooth using a spatula.



Extrude a thick bead in the chamfer on the exterior side.



Smooth using a spatula.

Leave the bi-component repair masticto dry (see product technical sheet).

Surface on the exterior side with a P 150then finish with a P 240.

Blow the component and clean the area to be repaired with the cleaner included in the Plastic repair

kit .

If necessary, apply a finishing mastic(see product technical sheet) Vehicle: Parts and consumables for the repair (04B, Consumables - Products).

Sand the finishing masticwith a P 150then finish with a P 240.

Follow the paint application procedure according to the material concerned:

- SMC bodywork component: Preparation and paint range (Technical Note 592A, 95A, Paint application procedure on plastic),
- Polypropylene / polyethylene bodywork component: Preparation and paint range (Technical Note 592A, 95A, Paint application procedure on plastic),
- Noryl bodywork component: Preparation and paint range (Technical Note 592A, 95A, Paint application procedure on plastic),

ABS bodywork component: Preparation and paint range (Technical Note 592A, 95A, Paint application procedure on plastic).

2- WELDING METHOD

Note:

Before any repairs, check the reparability of components made from plastic materials.

(see 50A, General information, Products for plastic material bodywork components: Description) .

(see 50A, General information, Plastic material bodywork component: Precautions for the repair) .

- Wash the component in soapy water and rinse in clean water.
- Clean the area to be repaired with a LINT-FREE CLOTHsoaked in ANTISTATIC THINNERVehicle: Parts and consumables for the repair (04B, Consumables - Products).
- Wipe the area with a clean, dry LINT-FREE CLOTHVehicle: Parts and consumables for the repair (04B, Consumables - Products).

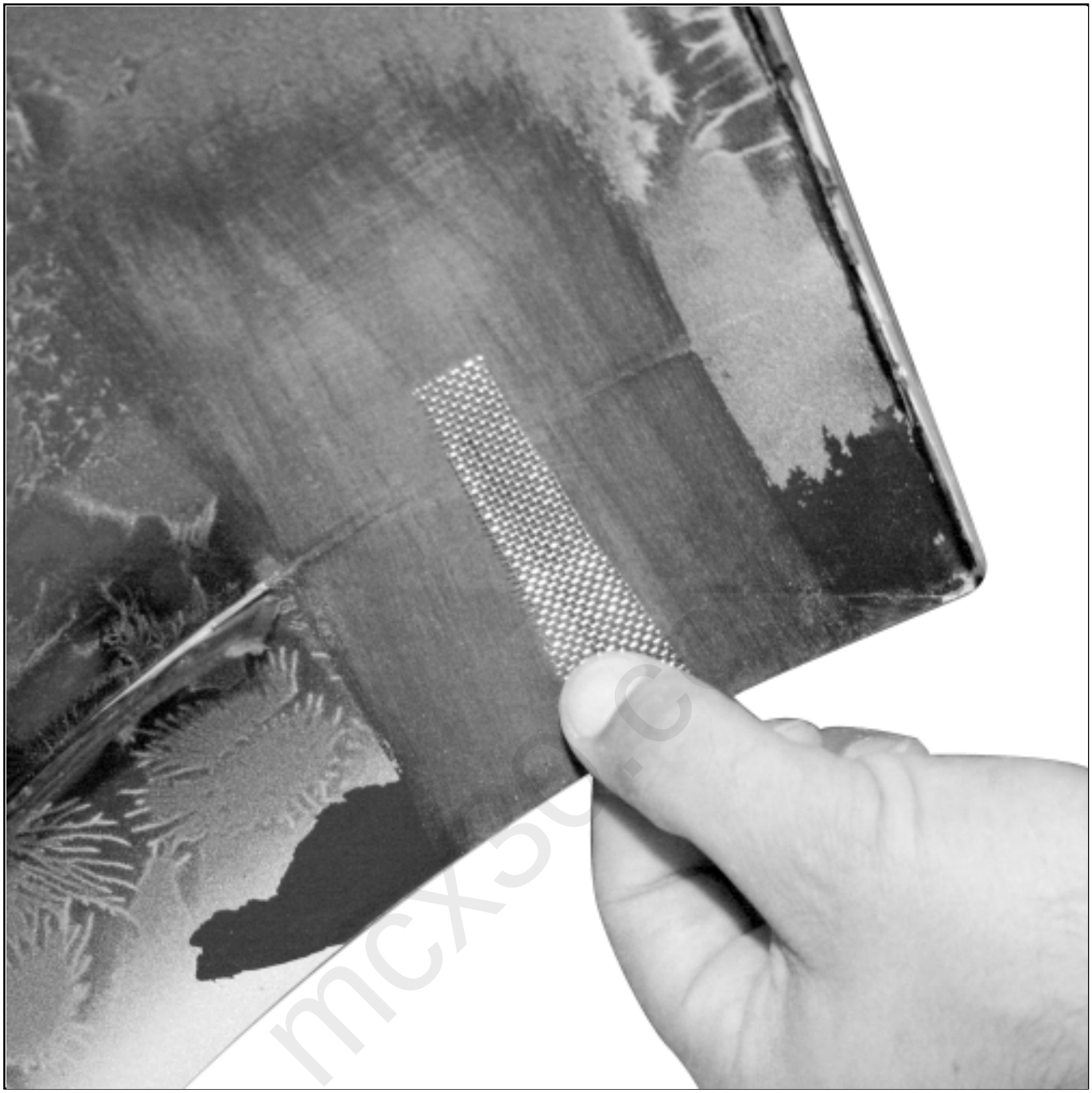
Strip the paint with a P 150over a width of 50 mm.

- Blow the component and clean the area to be repaired with a LINT-FREE CLOTHsoaked in ANTISTATIC THINNER Vehicle: Parts and consumables for the repair (04B, Consumables - Products).

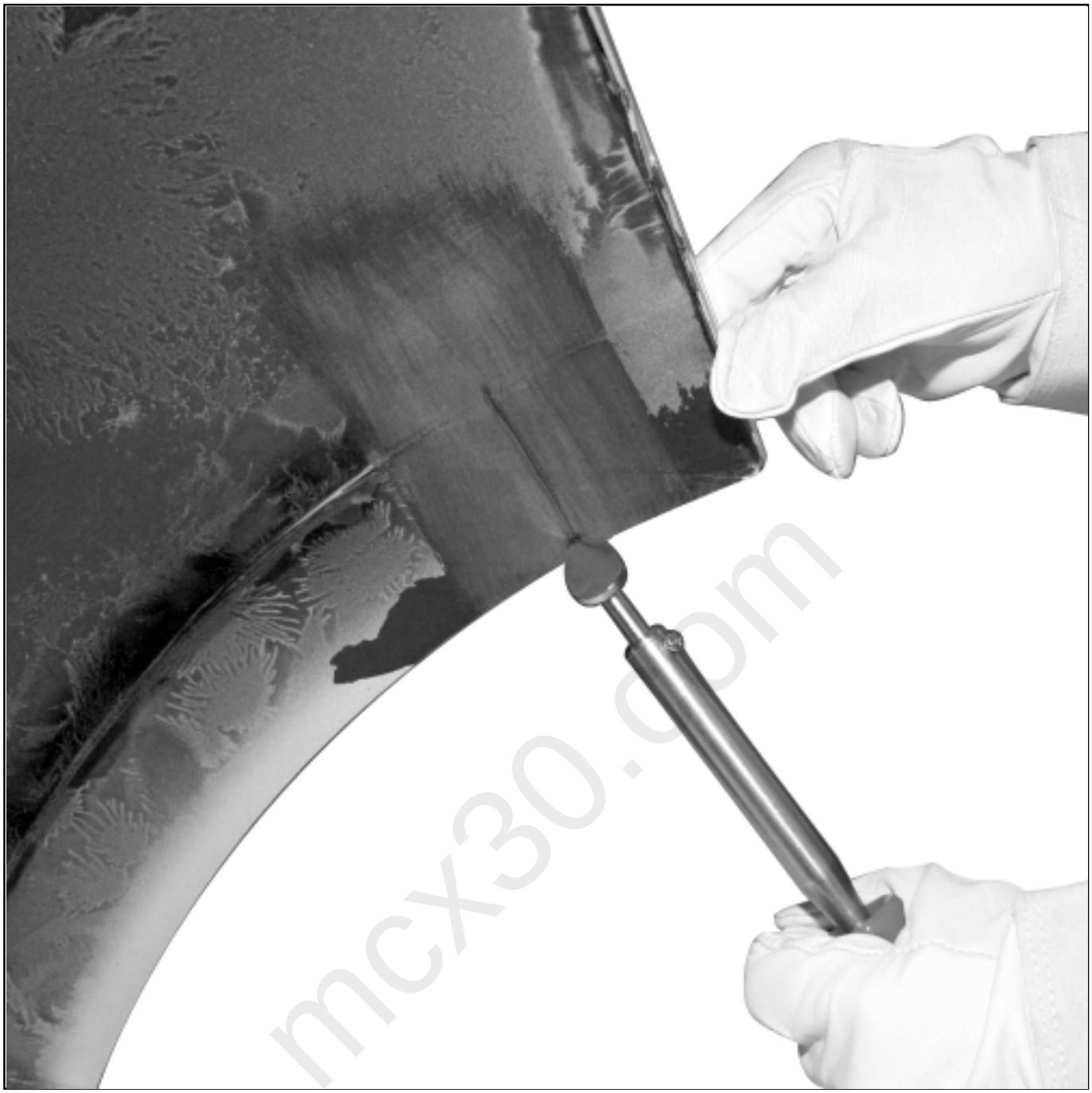
- Wipe the area with a clean, dry LINT-FREE CLOTHVehicle: Parts and consumables for the repair (04B, Consumables - Products).

- Preheat the soldering iron.

Cut the stainless steel mesh wider at the start of the crack.

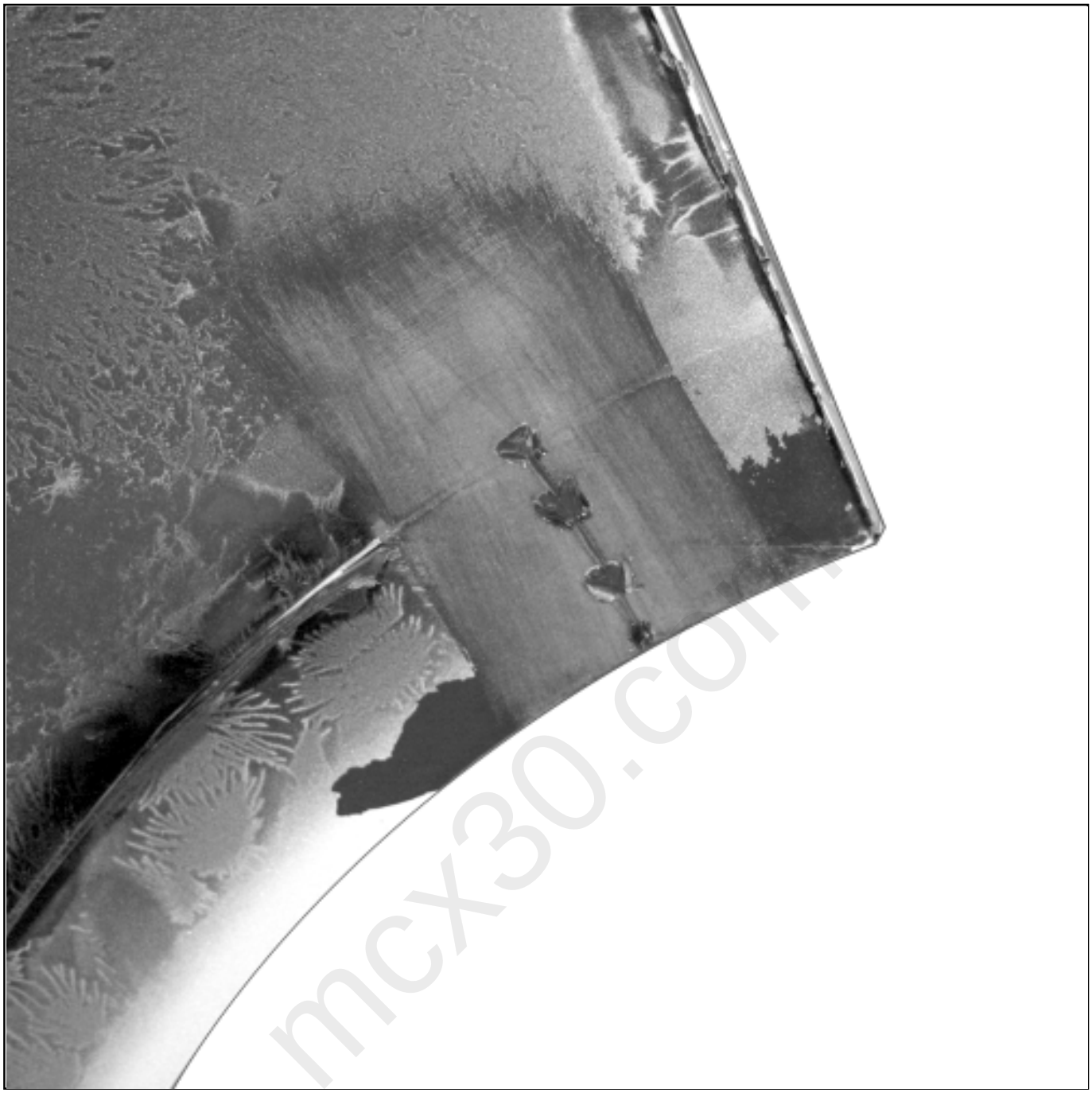


Adjust the stainless steel mesh according to the shape of the support.



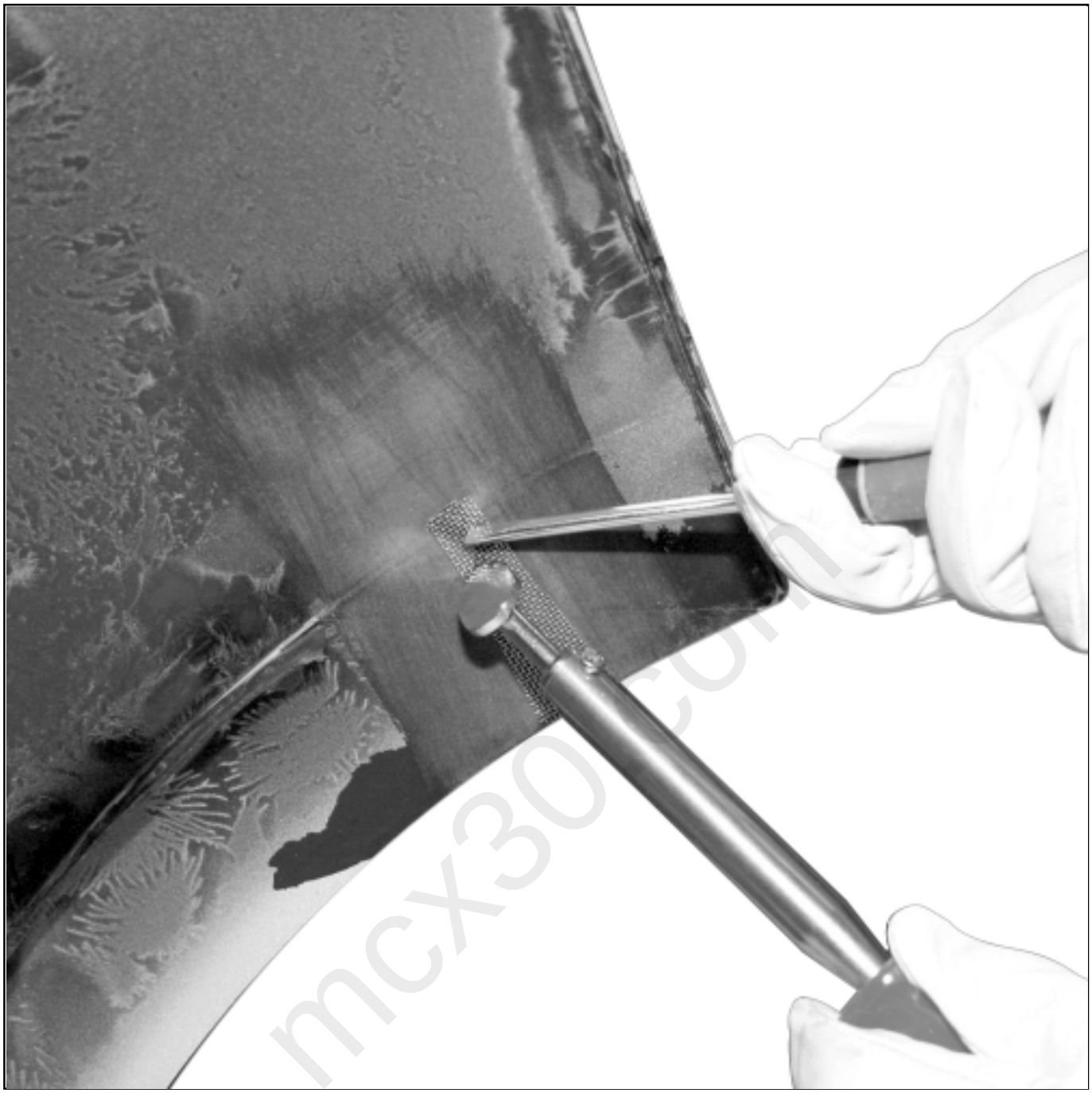
Spot-weld the start of the crack with the tip of the soldering iron in order to maintain the shape.

Cool the spot weld, for two seconds, vigorously with the cooler[Vehicle: Parts and consumables for the repair](04B, Consumables - Products).

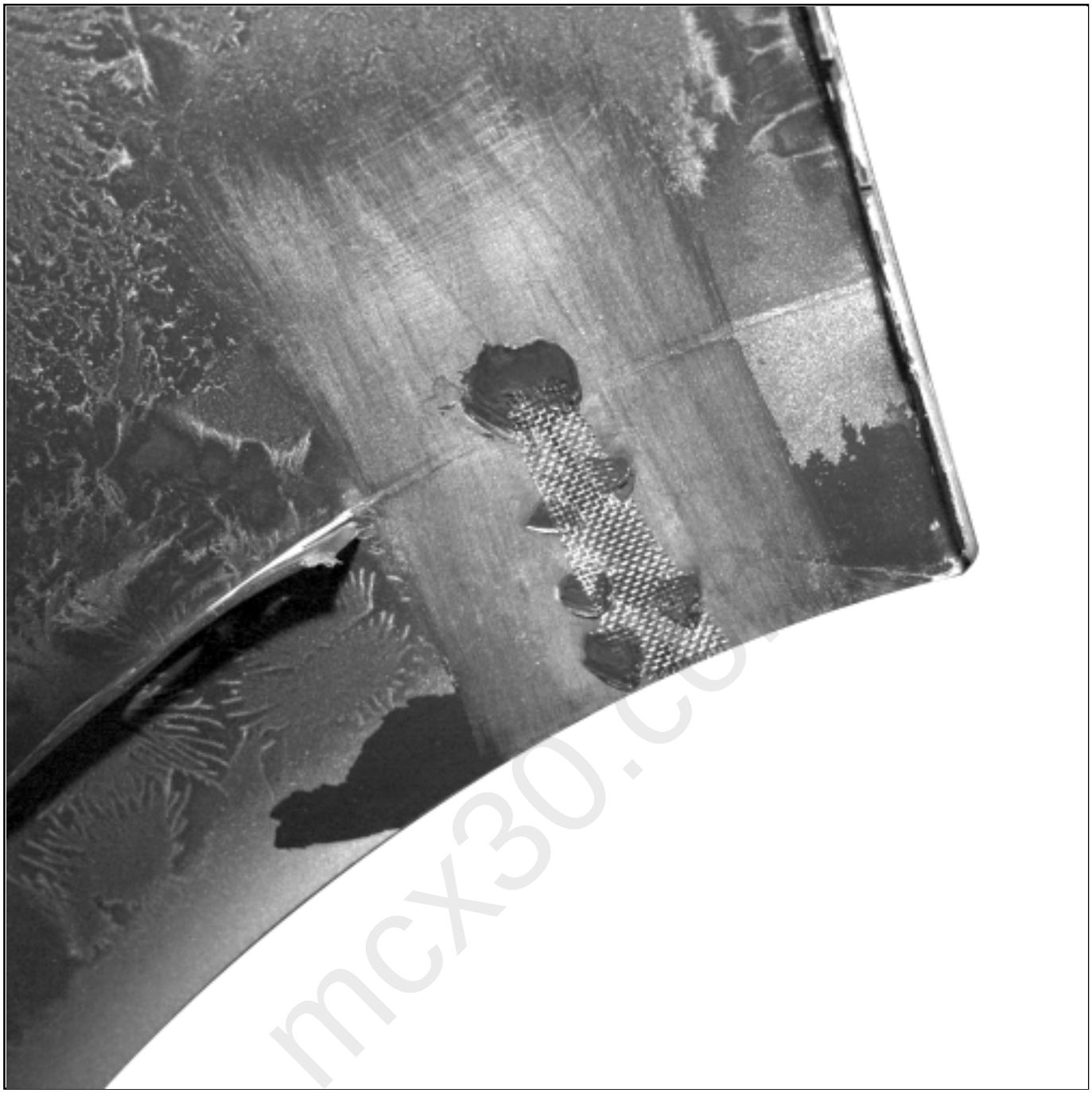


Repeat this operation along the length of the crack.

Cool each spot weld, for two seconds, vigorously with the cooler[Vehicle: Parts and consumables for the repair](#) (04B, Consumables - Products).

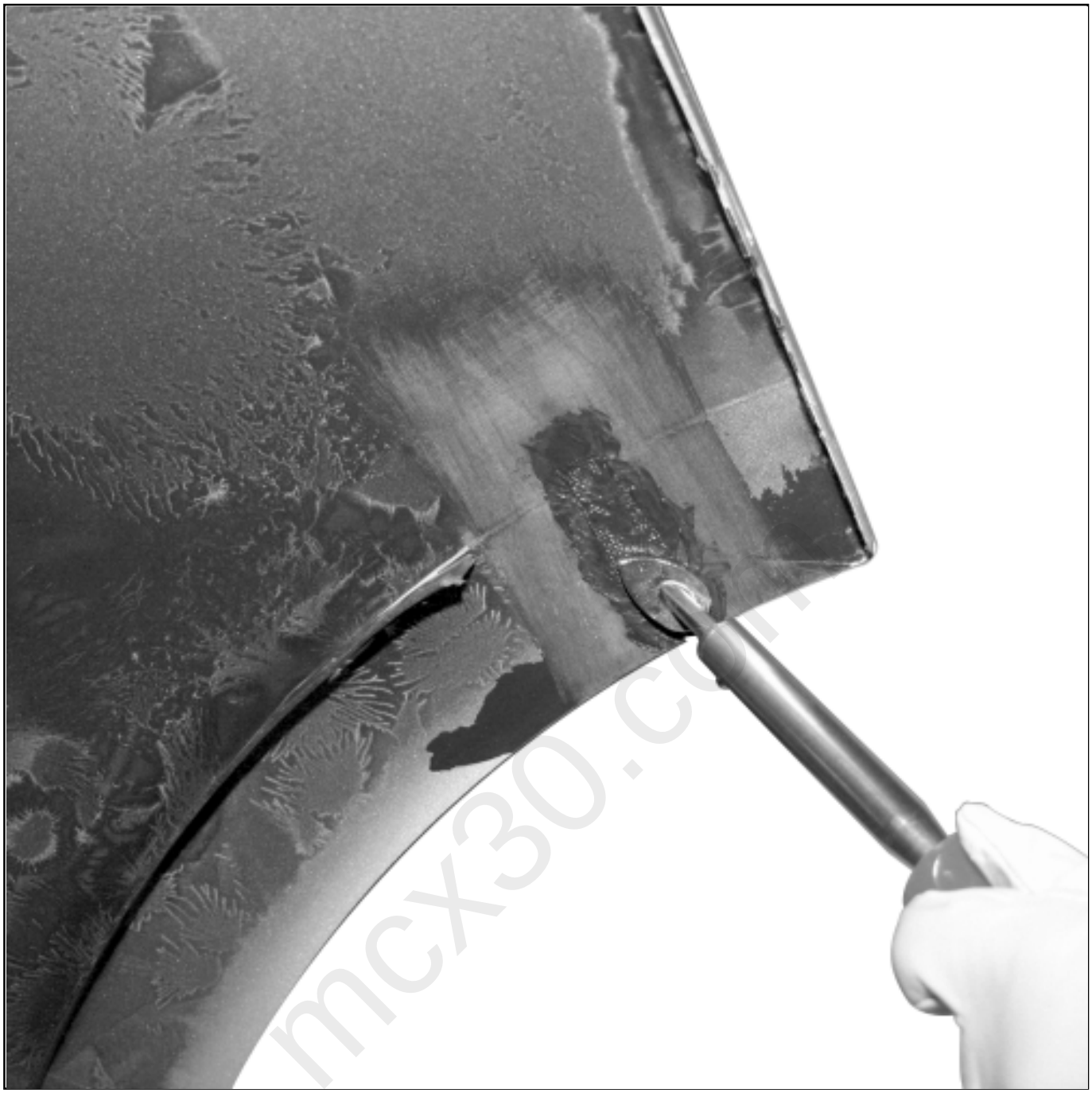


Position the stainless steel mesh and hold it using a dedicated tool.



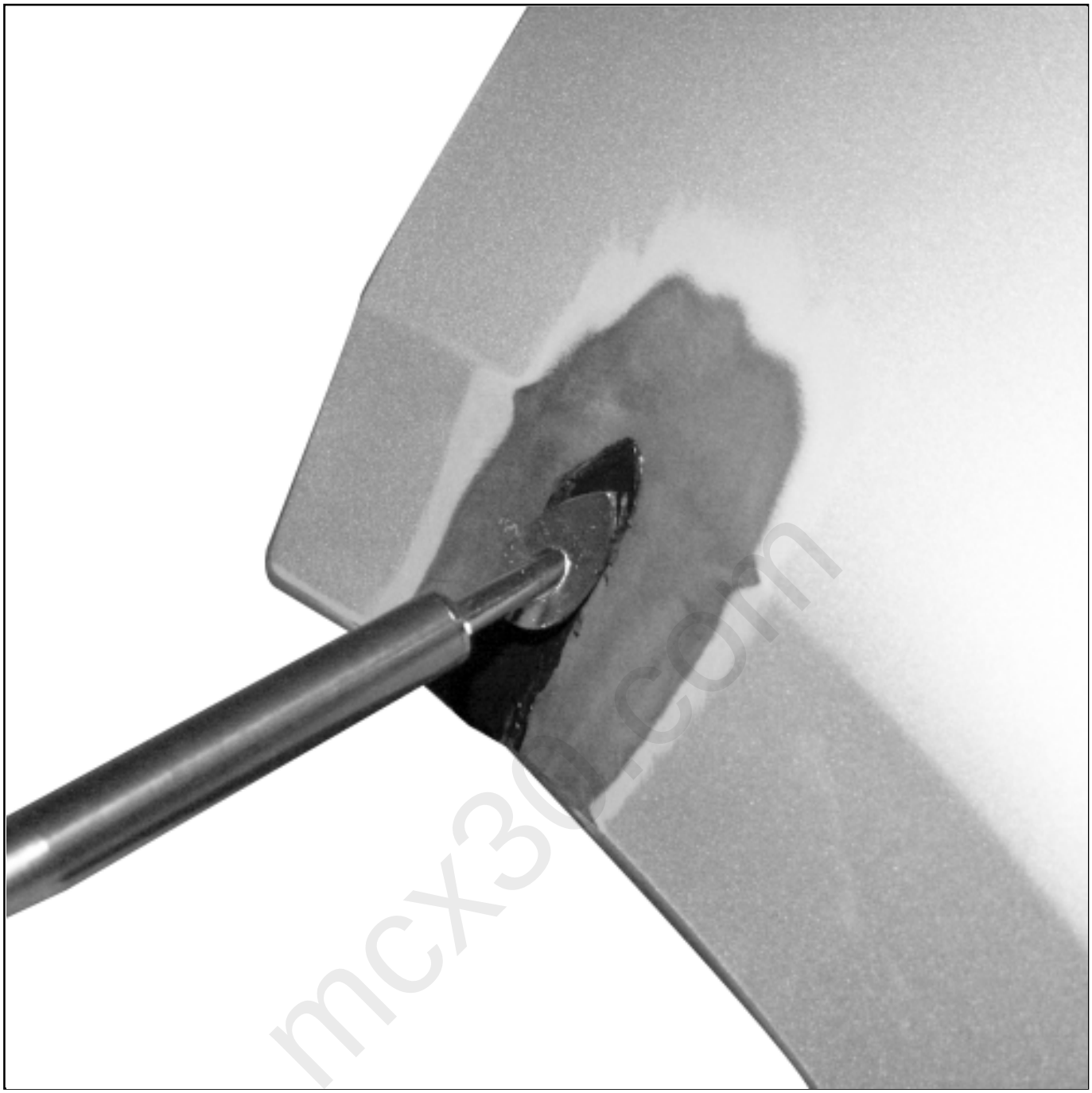
- Spot-weld the stainless steel mesh.

- Cool each spot weld, for two seconds, vigorously with the cooler[Vehicle: Parts and consumables for the repair](#) (04B, Consumables - Products).



Enclose the stainless steel mesh in the plastic material along the length of the crack.

Cool the whole of the repaired area for two seconds, vigorously with the cooler[Vehicle: Parts and consumables for the repair](#) (04B, Consumables - Products).



Weld the exterior part of the bumper.

Add material by preheating the welding rod with the tip of the soldering iron (except for ABS, ASA and Polycarbonatetype materials).

Note:

For ABS, ASAand Polycarbonate, fill the crack with the surrounding material

Cool the whole of the repaired area for two seconds, vigorously with the cooler**Vehicle: Parts and consumables for the repair** (04B, Consumables - Products).

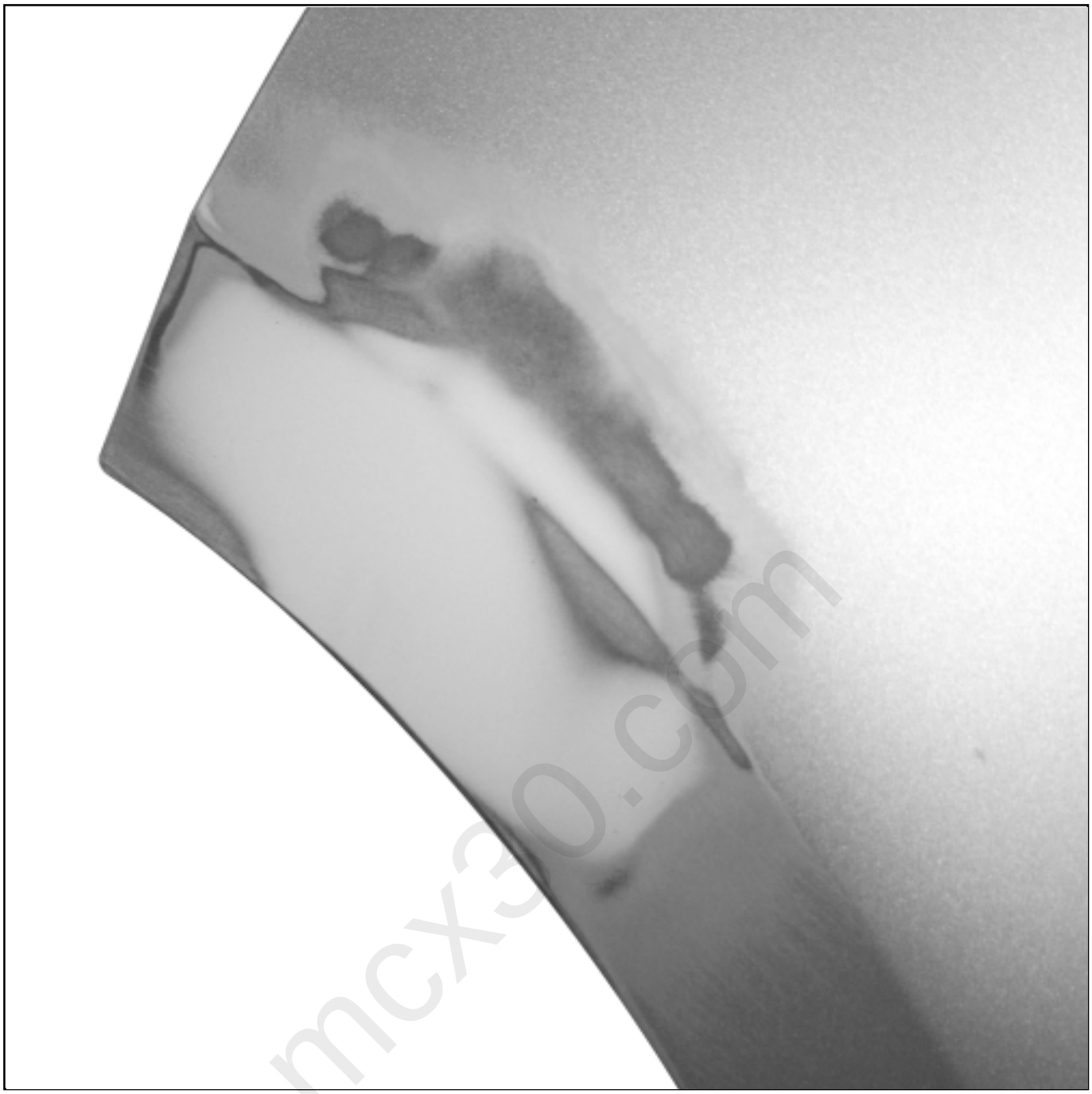
Surface with a P 80to P 150then finish with a P 240.

Blow the component and clean the area to be repaired with a LINT-FREE CLOTHsoaked in ANTISTATIC THINNER **Vehicle: Parts and consumables for the repair** (04B, Consumables - Products).

Wipe the area with a clean, dry LINT-FREE CLOTHVehicle: Parts and consumables for the repair (04B, Consumables - Products).

If necessary, apply a finishing mastic(see product technical sheet) Vehicle: Parts and consumables for the repair (04B, Consumables - Products).

Sand the finishing masticwith a P 150then finish with a P 240.



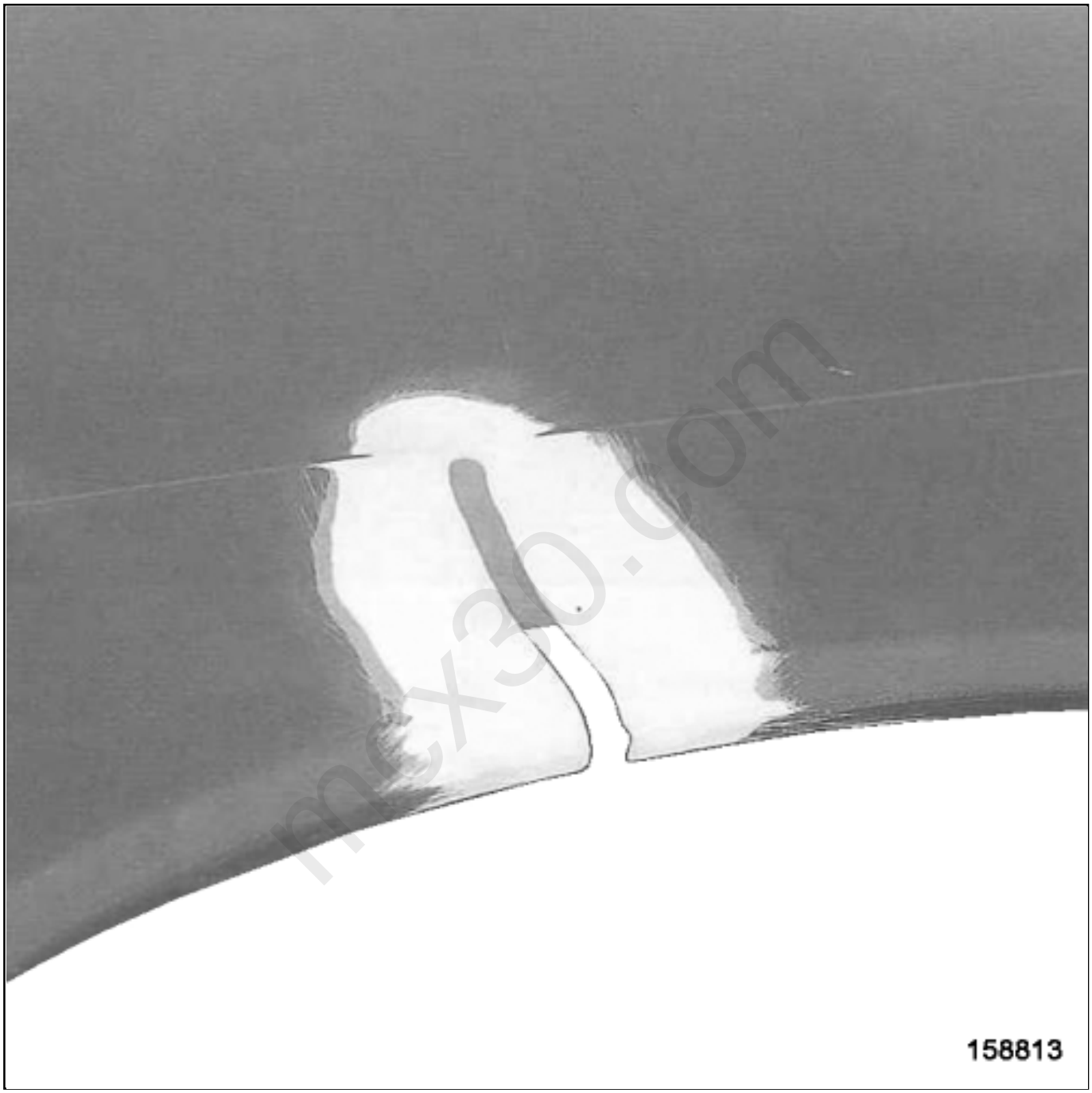
Follow the paint application procedure according to the material concerned:

- **Polypropylene / polyethylene bodywork component: Preparation and paint range** (Technical Note 592A, 95A, Paint application procedure on plastic),
- **ABS bodywork component: Preparation and paint range** (Technical Note 592A, 95A, Paint application procedure on plastic).

3- EPOXY RESINE METHOD

Note:

Method apply only on RTM component.



Open the crack to let a hole of 10 mmwide.

Chamfering between 30to 40 mmaround the crack using the orbital sander with a P80.

Sand the paint around the zone to be repaired using the orbital sander with a P 150

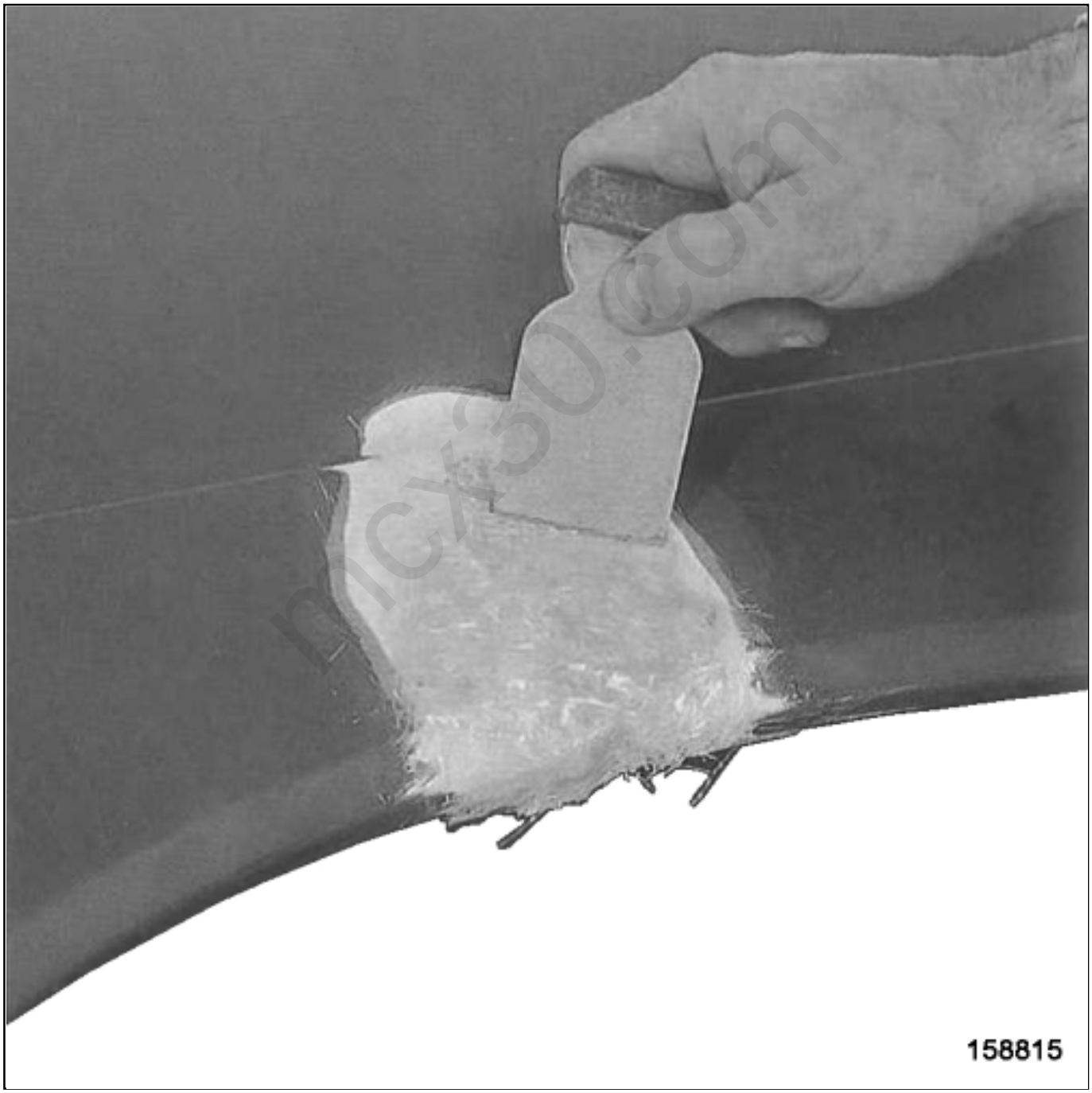
Blow the component and clean the area to be repaired with the Acetone(see product techincal sheet).

Align the borders of the component using a plate pad(local manufactured)and fix them with plate screws.

Cut 2 strips of materialwith repair length, first of 50mmwide and second of 100 mmwide.

Blow the component and clean the area to be repaired with the Acetone(see product techincal sheet).

Prepare the Epoxy resin(see 50A, General information, Products for plastic material bodywork components: Description) .



Fit the strip of materiel.

Soaked the component interior with Epoxy resin.

Note:

After 15 minutes,accelerate the hardening in drying oven or in infrared drying device(60° C maxi at a distance of 70 cm).

Remove the plate pads.

Cut a stripcovering the chamfer.

Chamfering the screws holes.

Fit the strip soaking with resin.

Note:

Pay particular attention at output screw area and at strips junction reinforcement to prevent the air bubbles form.

Add short fibres with resin(50 % maxi.).

Apply the mixture using a spatula.

Note:

After 15 minutes,accelerate the hardening in drying oven or in infrared drying device(60° C maxi at a distance of 70 cm).

Sand using the orbital sander with a P 80then with a P180and P240.

Apply if necessary a finishing mastic(see product technical sheet). (see **Vehicle: Parts and consumables for the repair**)

Sand the finishing masticusing a P 150then finish using a P240.

4. PROCEDURE 3

Repairing a hole on a plastic chassis element.

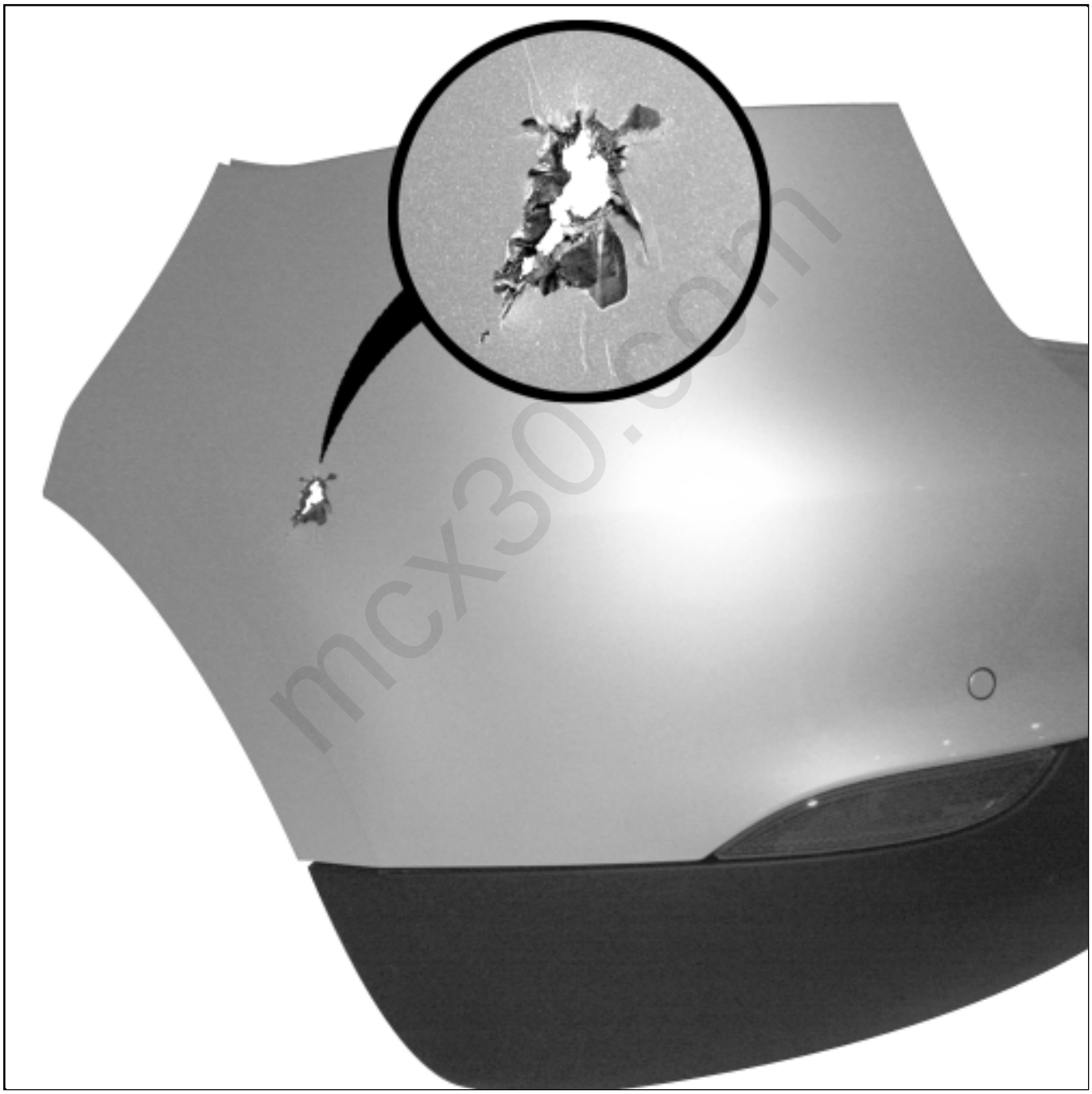
1- BONDING METHOD

Note:

Before any repairs, check the reparability of components made from plastic materials.

(see 50A, General information, Products for plastic material bodywork components: Description) .

(see 50A, General information, Plastic material bodywork component: Precautions for the repair) .



Wash the component in soapy water and rinse in clean water.

Clean the area to be repaired with a LINT-FREE CLOTHsoaked in ANTISTATIC THINNERVehicle: Parts and consumables for the repair (04B, Consumables - Products).

Wipe the area with a clean, dry LINT-FREE CLOTHVehicle: Parts and consumables for the repair (04B, Consumables - Products).

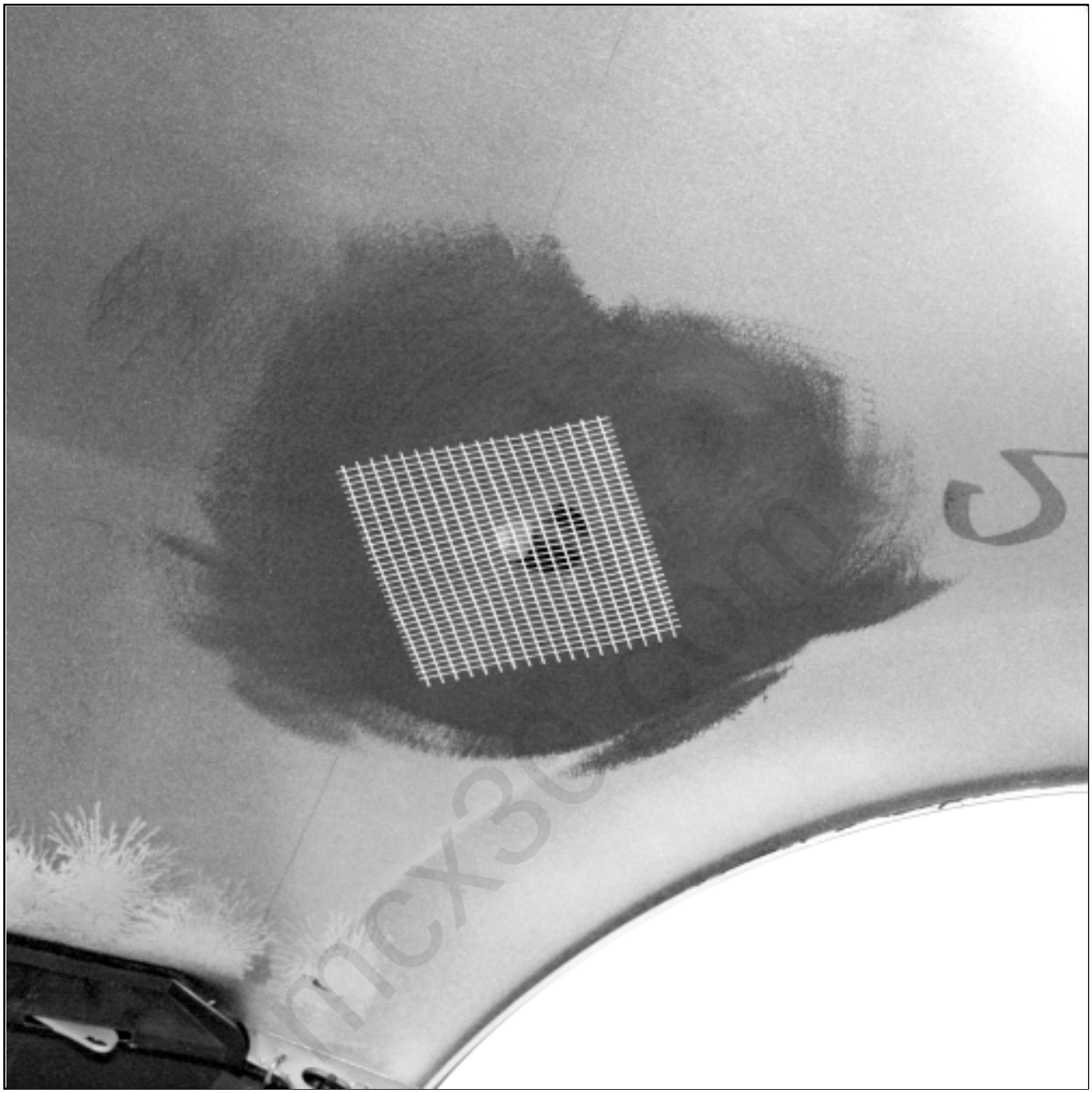
Chamfer on the exterior side using an angle grinderor a belt sanderequipped with a P 120abrasive pad.

Surface the interior and exterior areas with the orbital sander using a P 150.

Blow the component and clean the area to be repaired with the cleaner included in the plastic repair kit box.

Apply the adhesive primerincluded in the plastic repair kitto the interior and exterior areas.

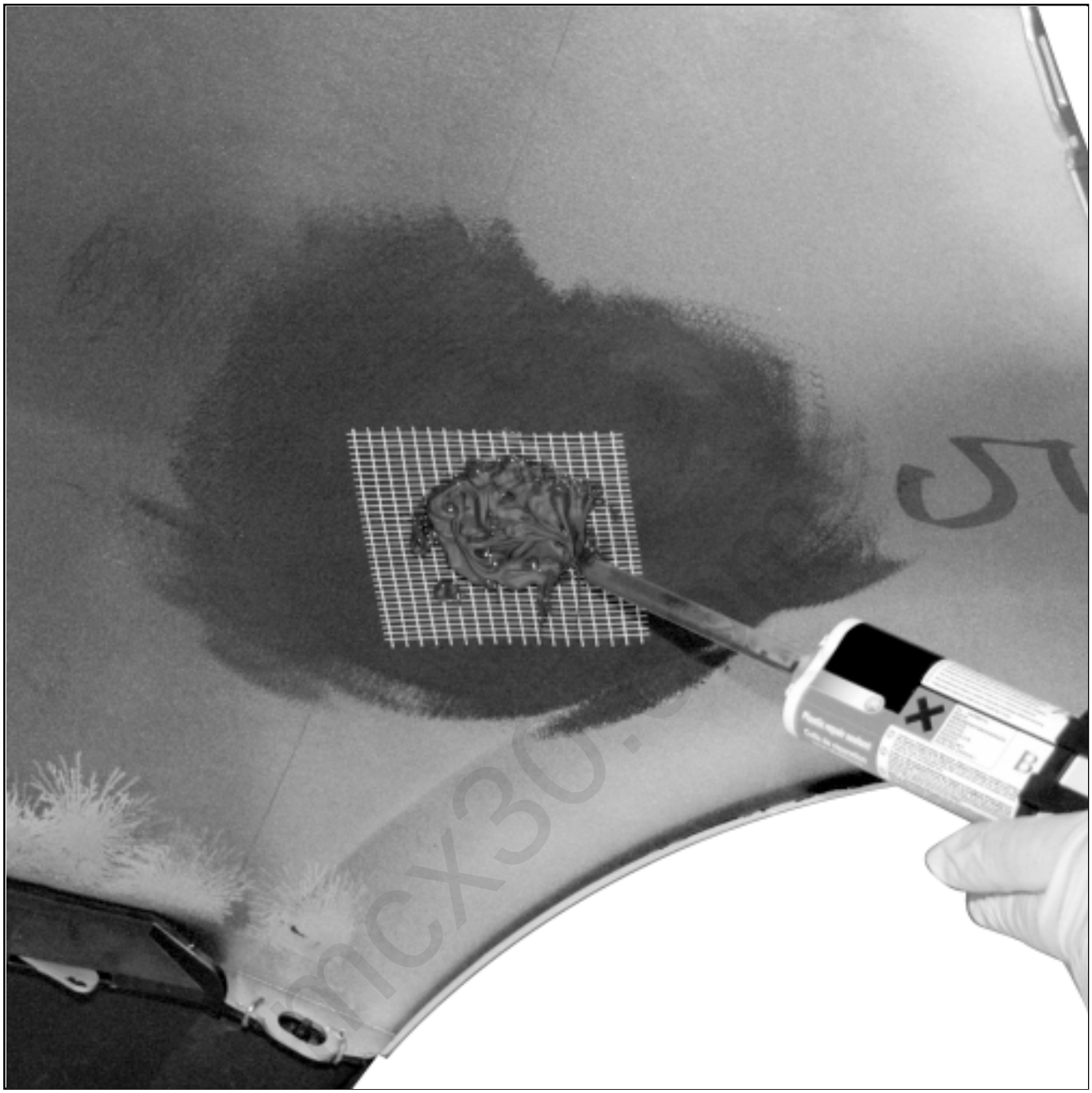
Leave the adhesive primerto dry (see product technical sheet).



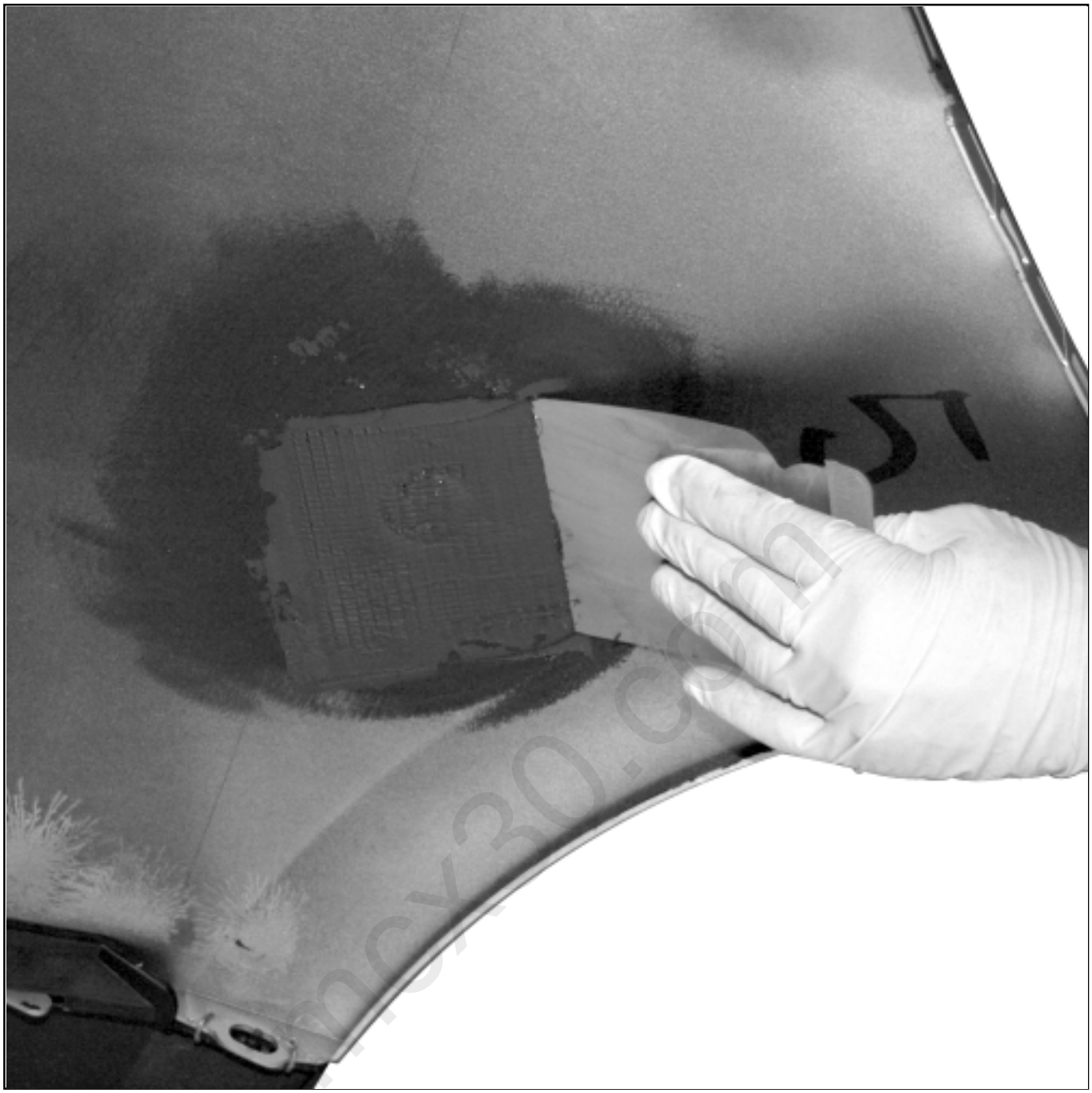
Adjust a piece of reinforcing film (cloth)suitable for repairing the inside of the component.

Prepare the bi-component repair mastic(see 50A, General information, Products for plastic material bodywork components: Description) .

Extrude a narrow bead around the areas to be repaired on the inside of the component and apply reinforcing film (cloth).

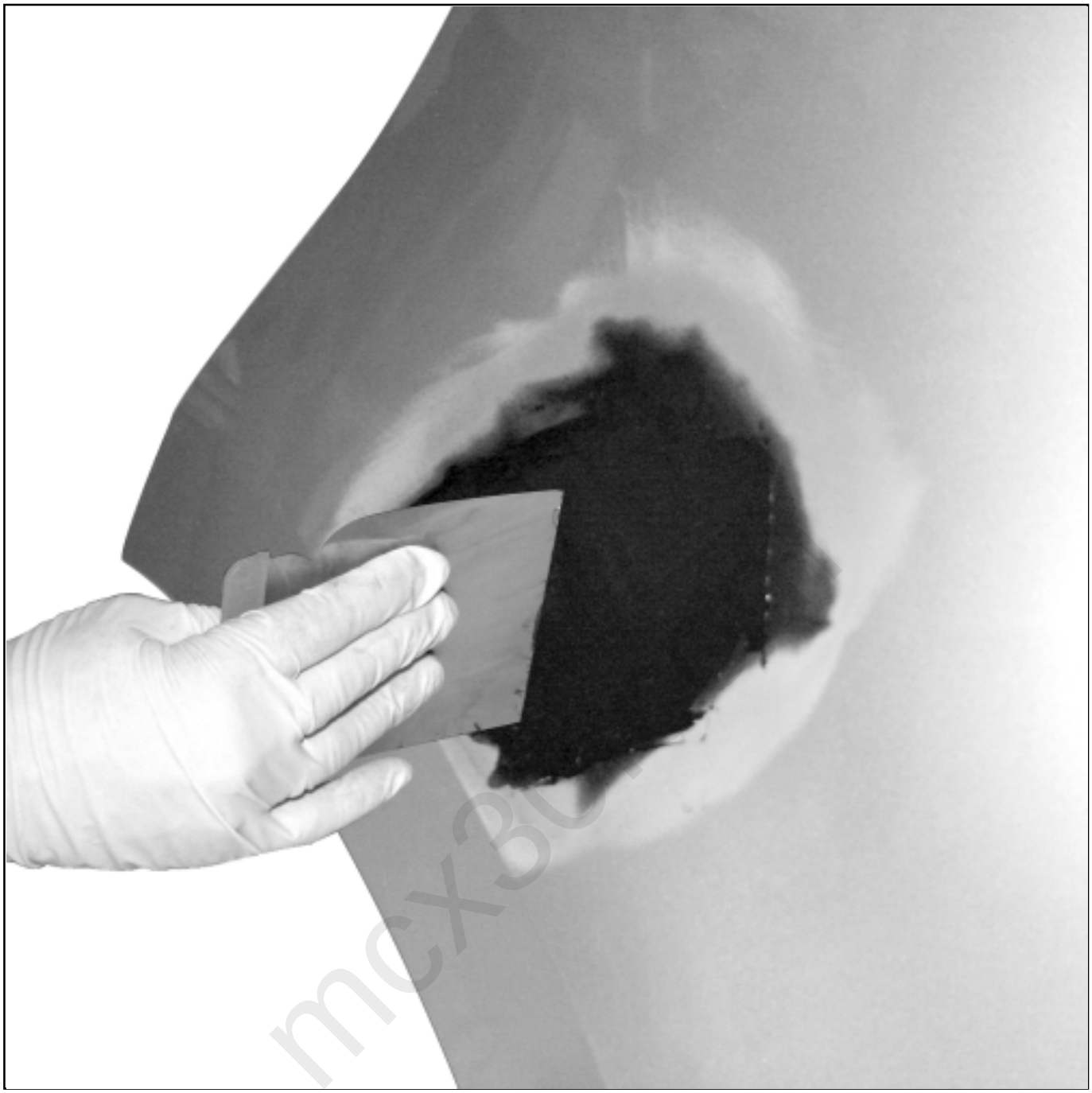


Extrude a thick bead on the reinforcing film (cloth)at the hole.



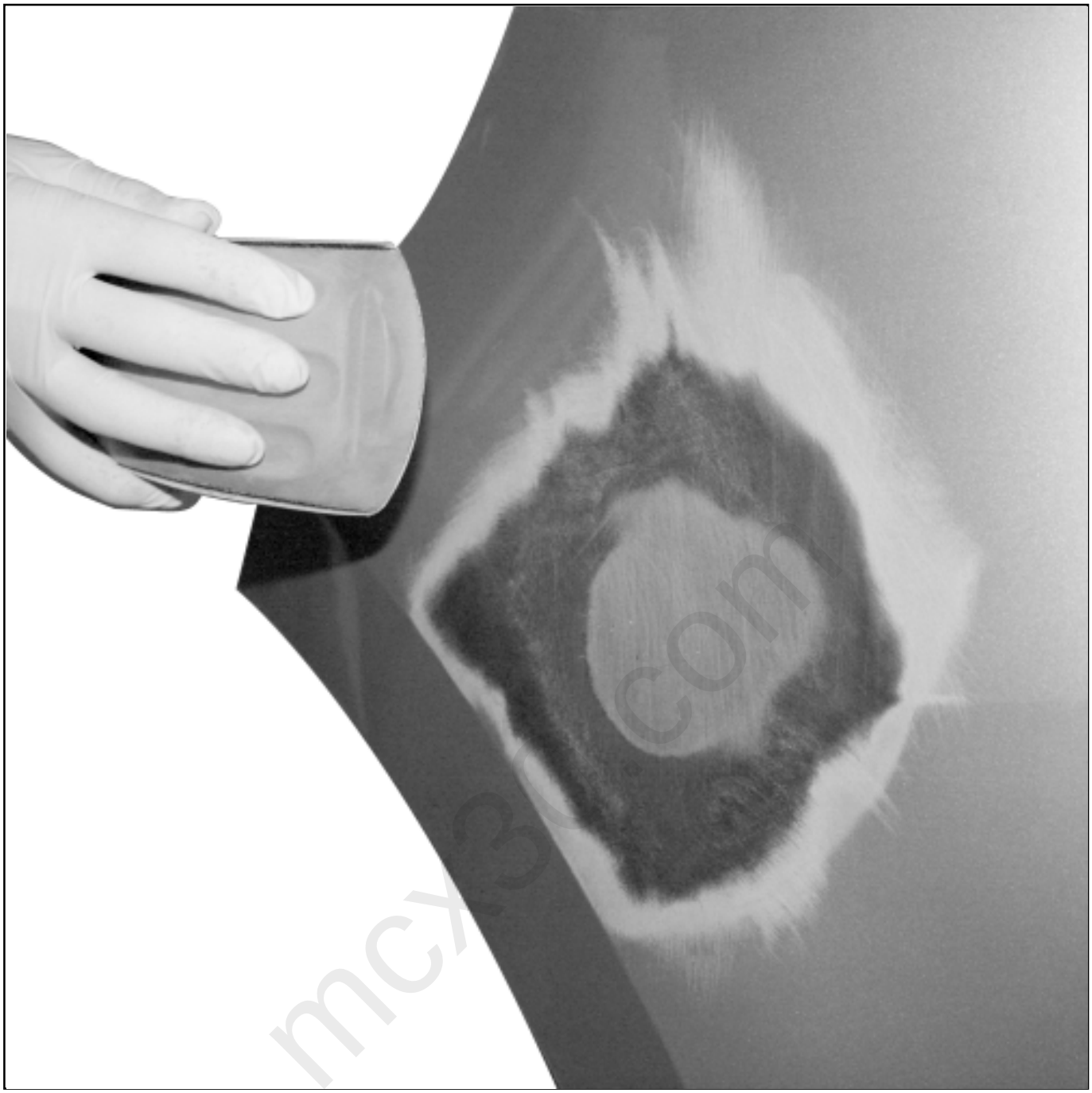
Smooth using a spatula.

Extrude a thick bead on the reinforcing film (cloth)at the hole on the exterior.

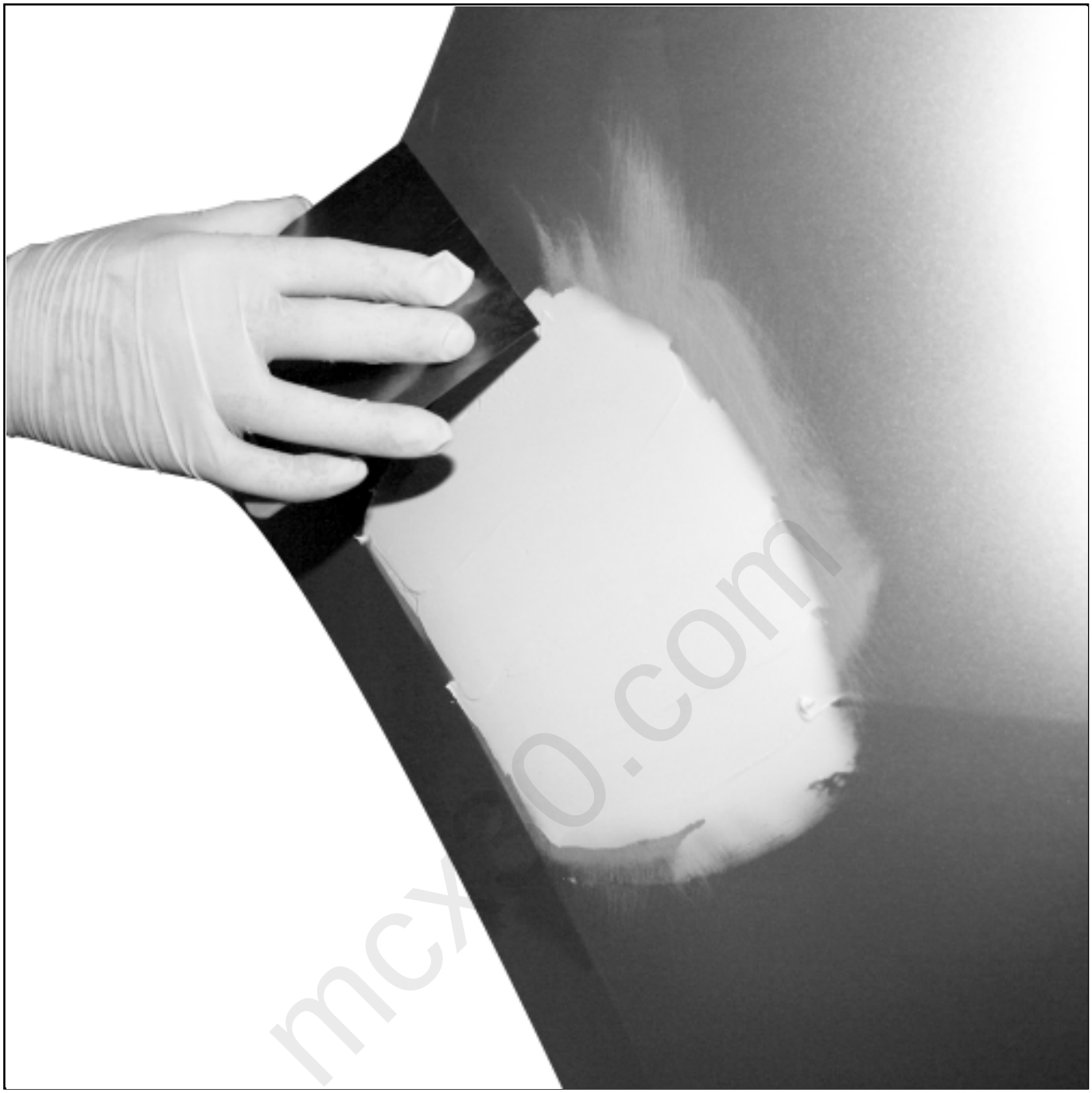


- Smooth using a spatula.

- Leave the bi-component repair mastic to dry (see product technical sheet).

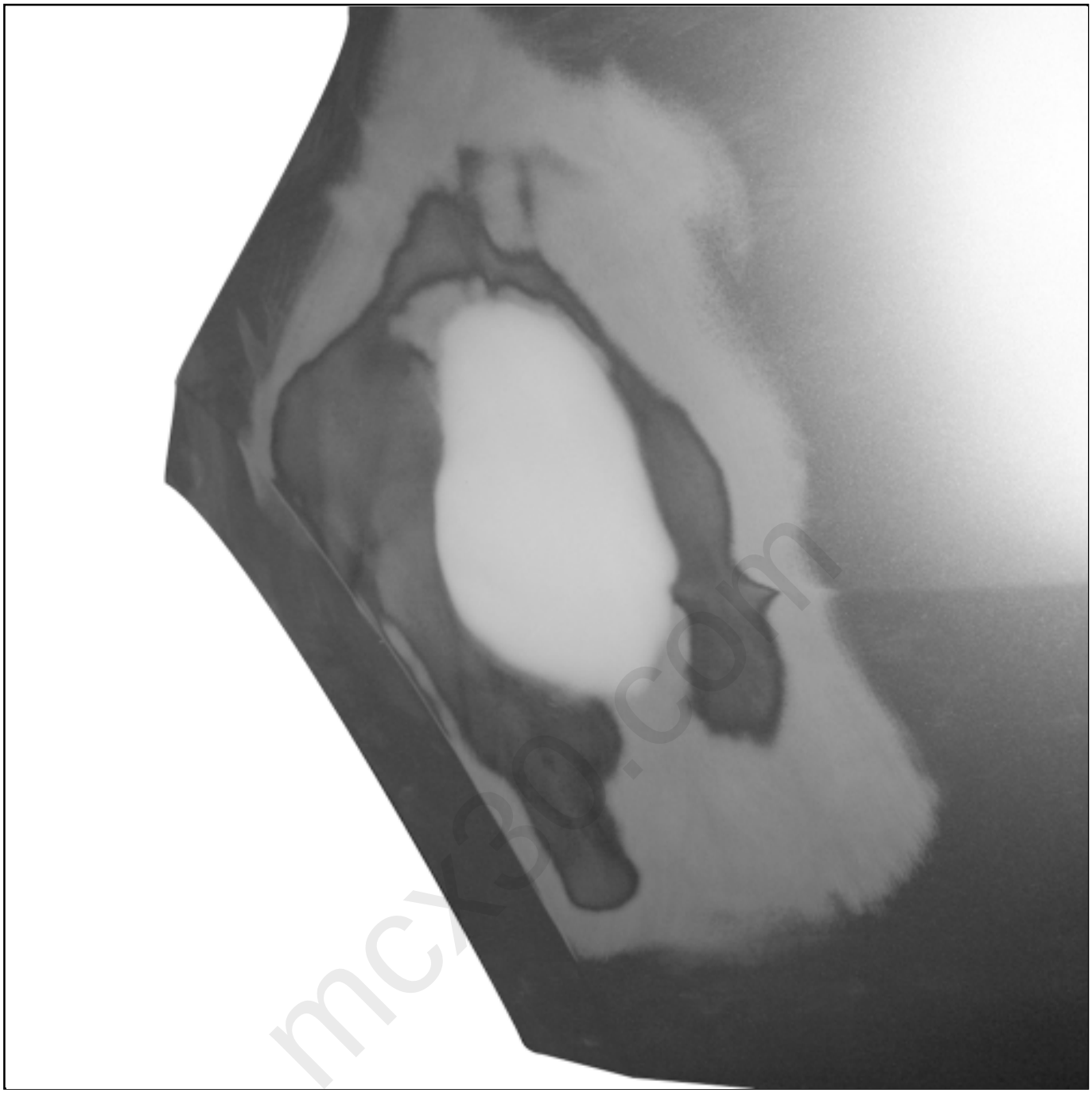


Surface on the exterior side with a P 150then finish with a P 240.



If necessary, apply a finishing mastic(see product technical sheet) Vehicle: Parts and consumables for the repair (04B, Consumables - Products).

Sand the finishing masticwith a P 150then finish with a P 240.



Follow the paint application procedure according to the material concerned:

- SMC bodywork component: Preparation and paint range (Technical Note 592A, 95A, Paint application procedure on plastic),
- Polypropylene / polyethylene bodywork component: Preparation and paint range (Technical Note 592A, 95A, Paint application procedure on plastic),
- ABS bodywork component: Preparation and paint range (Technical Note 592A, 95A, Paint application procedure on plastic),

Noryl bodywork component: Preparation and paint range (Technical Note 592A, 95A, Paint application procedure on plastic).

2- WELD METHOD

Note:

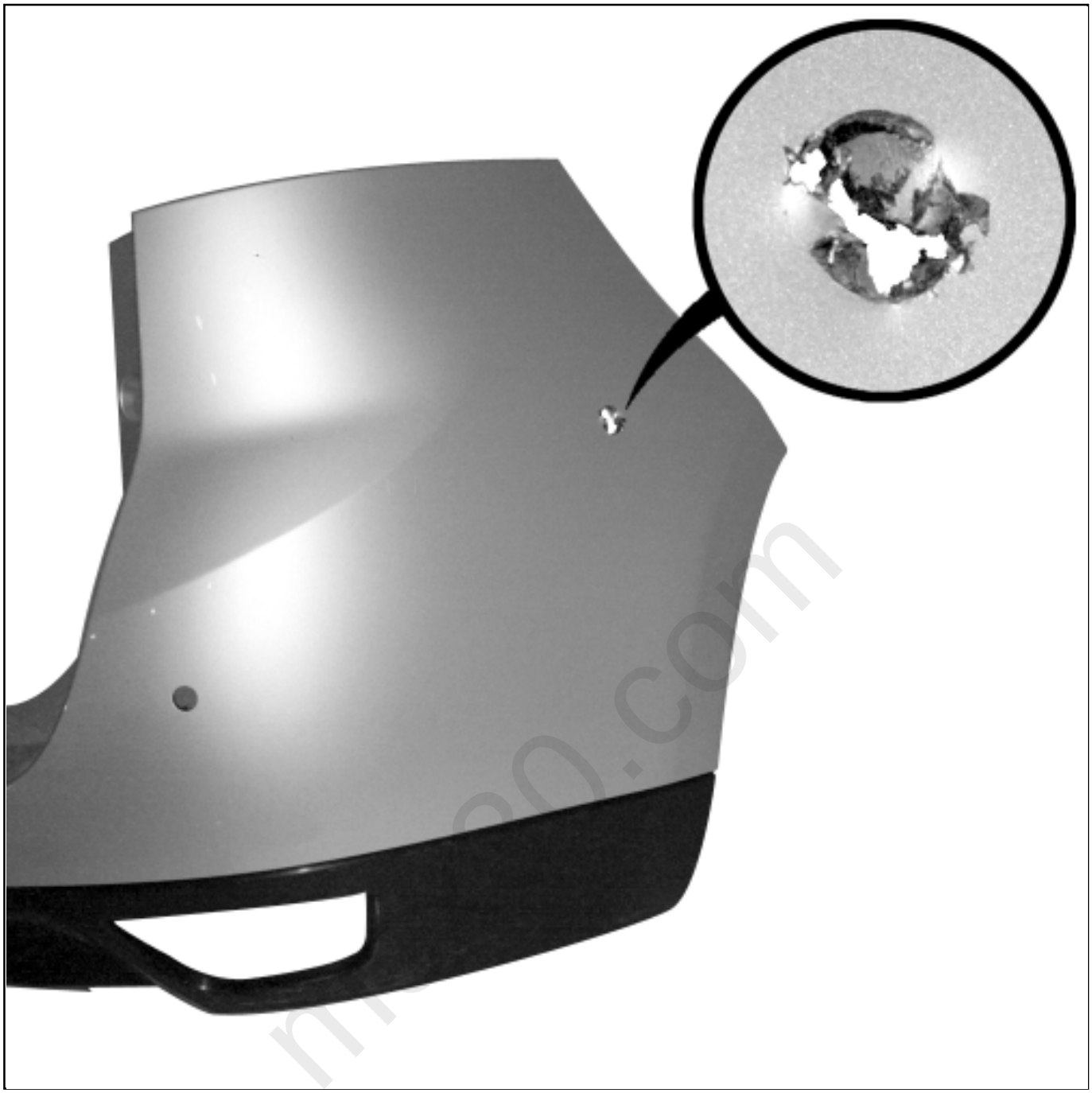
Before any repairs, check the reparability of components made from plastic materials.

(see 50A, General information, Products for plastic material bodywork components: Description) .

(see 50A, General information, Plastic material bodywork component: Precautions for the repair) .

Note:

This repair cannot be carried out on ABS, ASAand Polycarbonateplastics.



- Wash the component in soapy water and rinse in clean water.

- Clean the area to be repaired with a LINT-FREE CLOTHsoaked in ANTISTATIC THINNERVehicle: Parts and consumables for the repair (04B, Consumables - Products).

- Wipe the area with a clean, dry LINT-FREE CLOTHVehicle: Parts and consumables for the repair (04B, Consumables - Products).

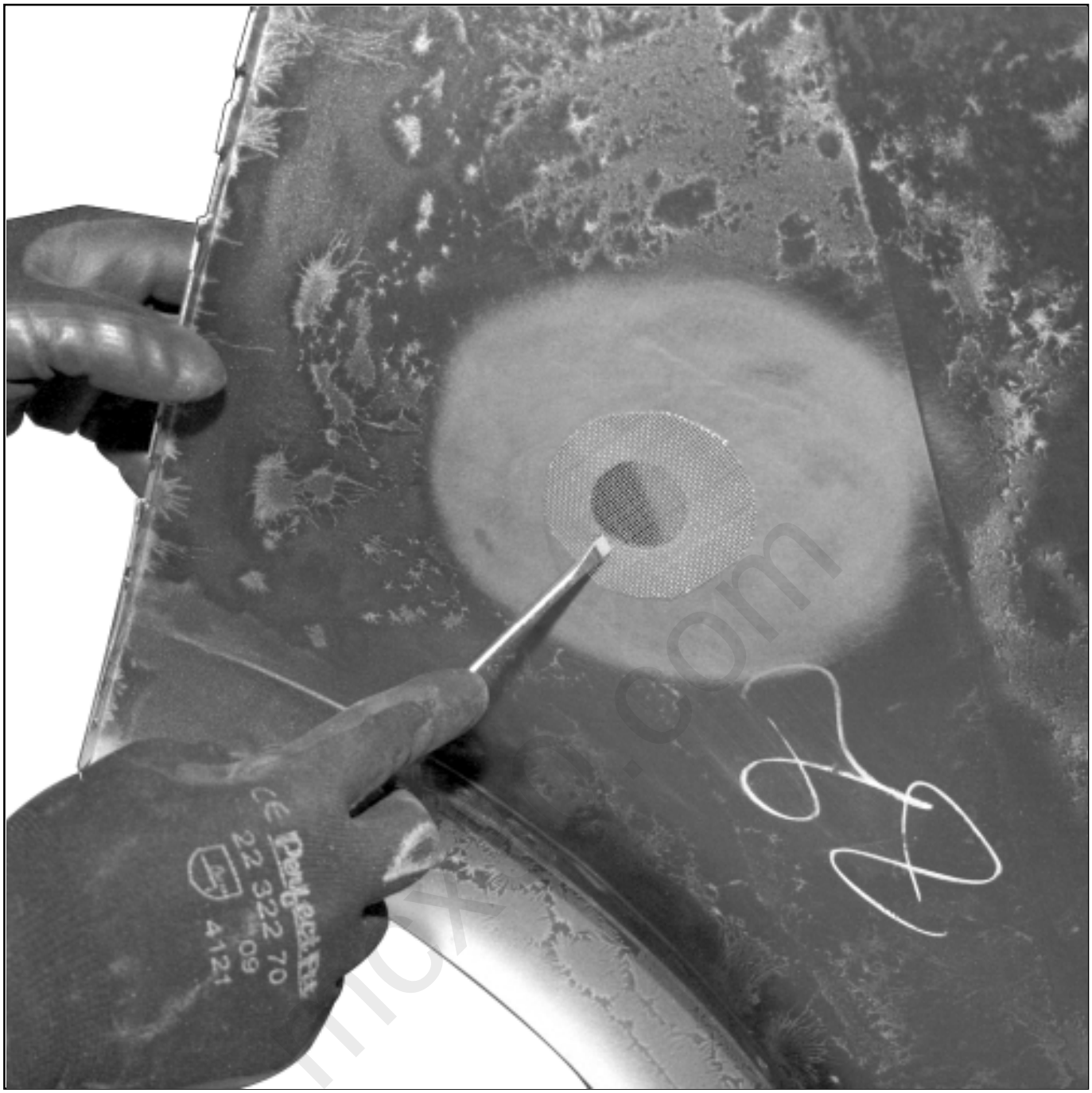
Strip the paint with a P 150over a radius of 100 mm.

Blow the component and clean the area to be repaired with a LINT-FREE CLOTHsoaked in ANTISTATIC THINNER Vehicle: Parts and consumables for the repair (04B, Consumables - Products).

Wipe the area with a clean, dry LINT-FREE CLOTHVehicle: Parts and consumables for the repair (04B, Consumables - Products).

Preheat the soldering iron.

Cut the stainless steel mesh suitable for the repair.



Adjust the stainless steel mesh and hold it using a dedicated tool.

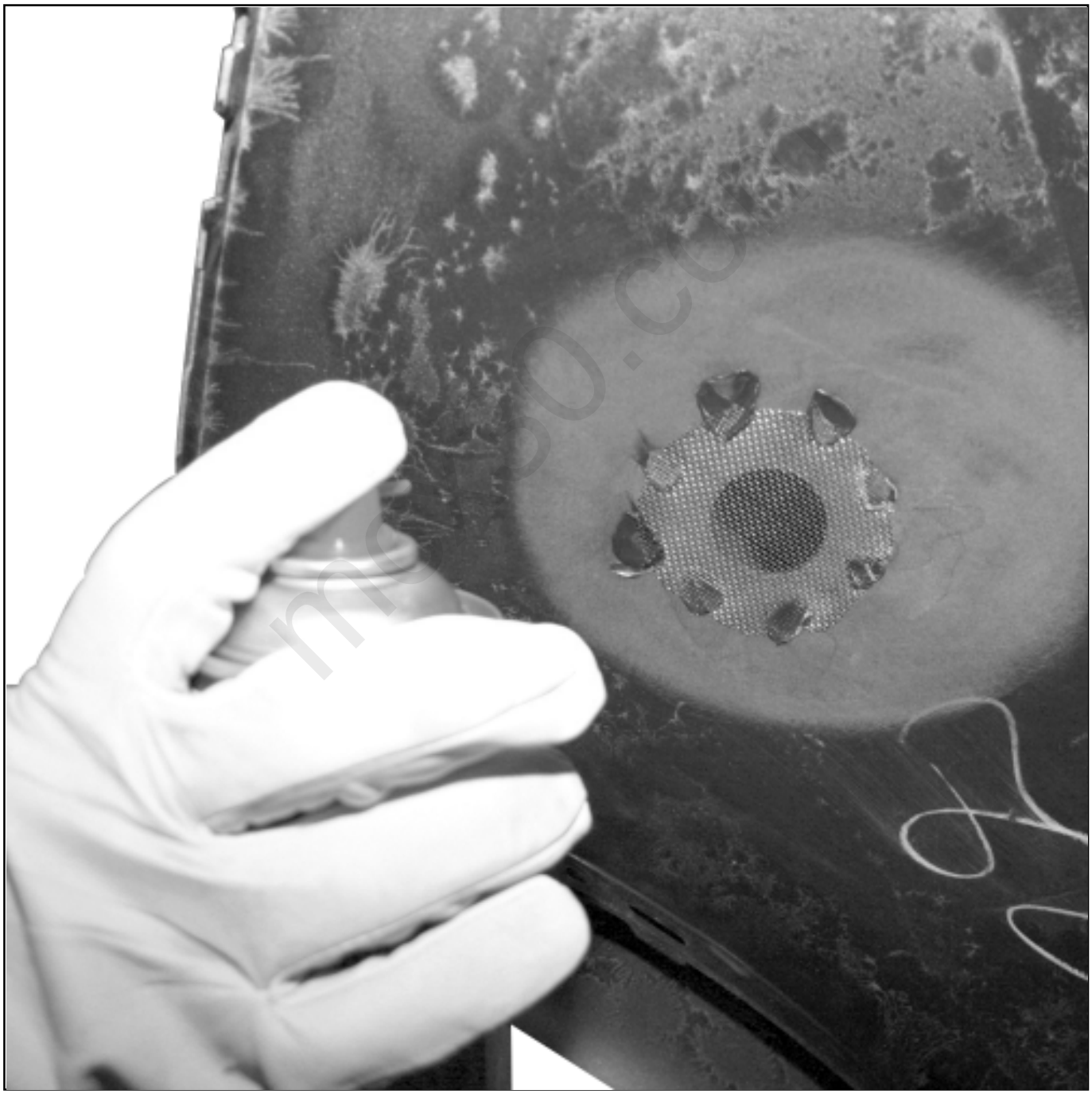
Spot weld around the edge of the stainless steel mesh frame with the tip of the soldering iron.

Note:

For noryl:

Add material around the edge of the hole by preheating the welding rod with the tip of the soldering iron.

Enclose the stainless steel mesh in the additional material.

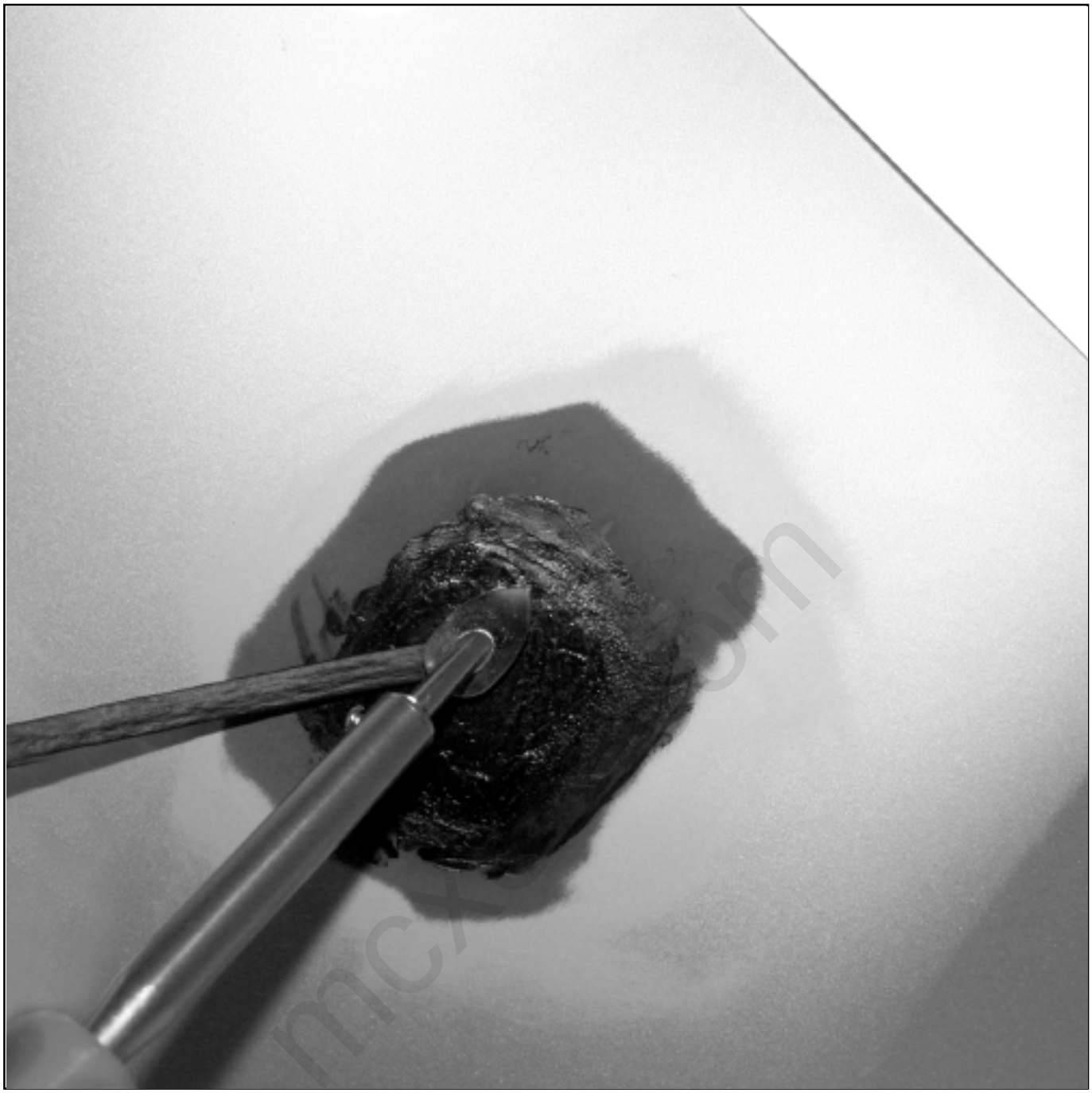


Cool each spot weld, for two seconds, vigorously with the cooler Vehicle: Parts and consumables for the repair (04B, Consumables - Products).

Enclose the stainless steel frame in the plastic material.

Cool the whole of the repaired area for two seconds, vigorously with the cooler Vehicle: Parts and consumables for the repair (04B, Consumables - Products).

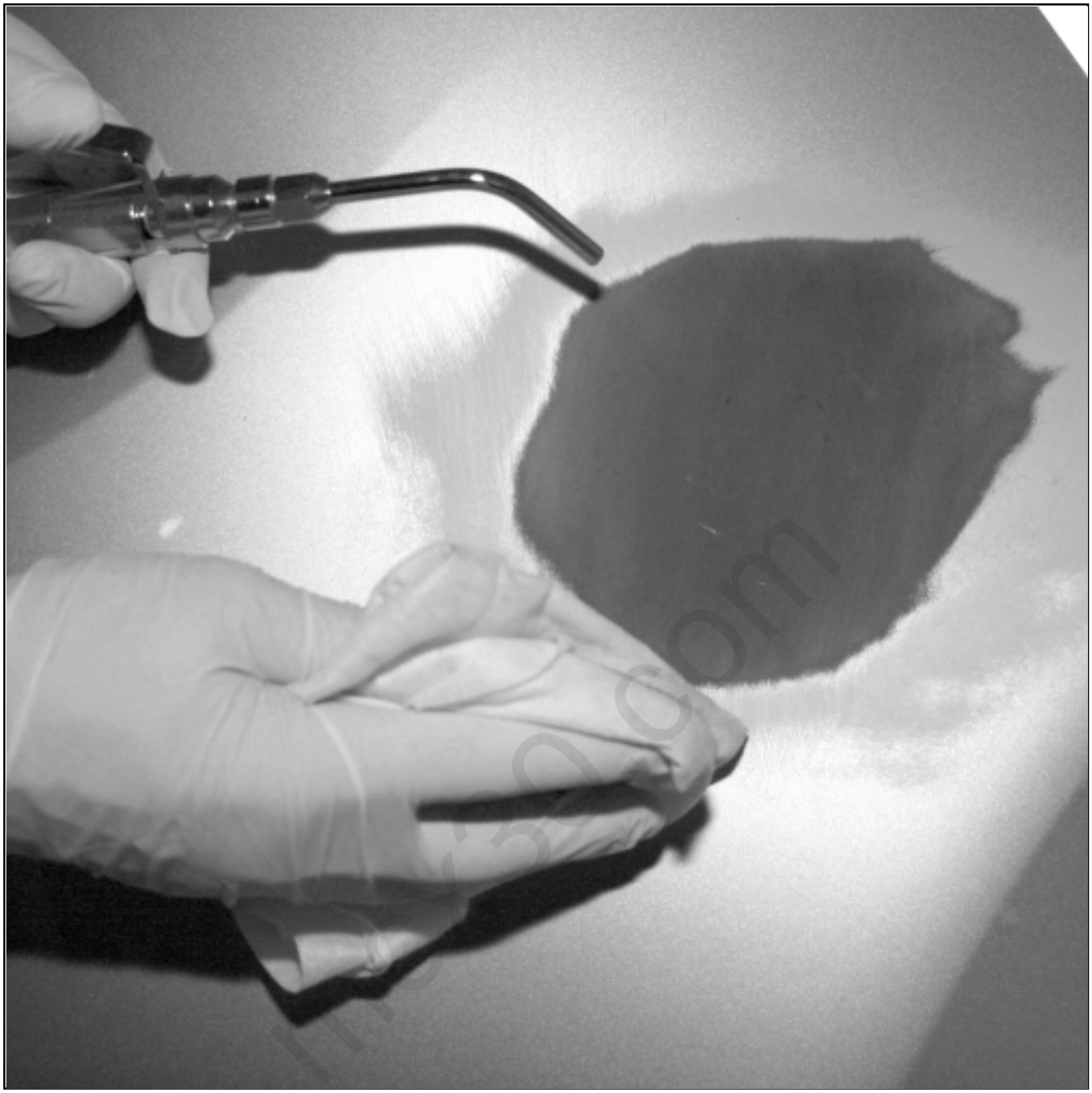
- Add material by preheating the welding rod with the tip of the soldering iron.
- Cool the whole of the repaired area for two seconds, vigorously with the cooler**Vehicle: Parts and consumables for the repair** (04B, Consumables - Products).



- Add material to the exterior by preheating the welding rod with the tip of the soldering iron.

- Cool the whole of the repaired area for two seconds, vigorously with the cooler**Vehicle: Parts and consumables for the repair** (04B, Consumables - Products).

Surface with a P 80to P 150then finish with a P 240.

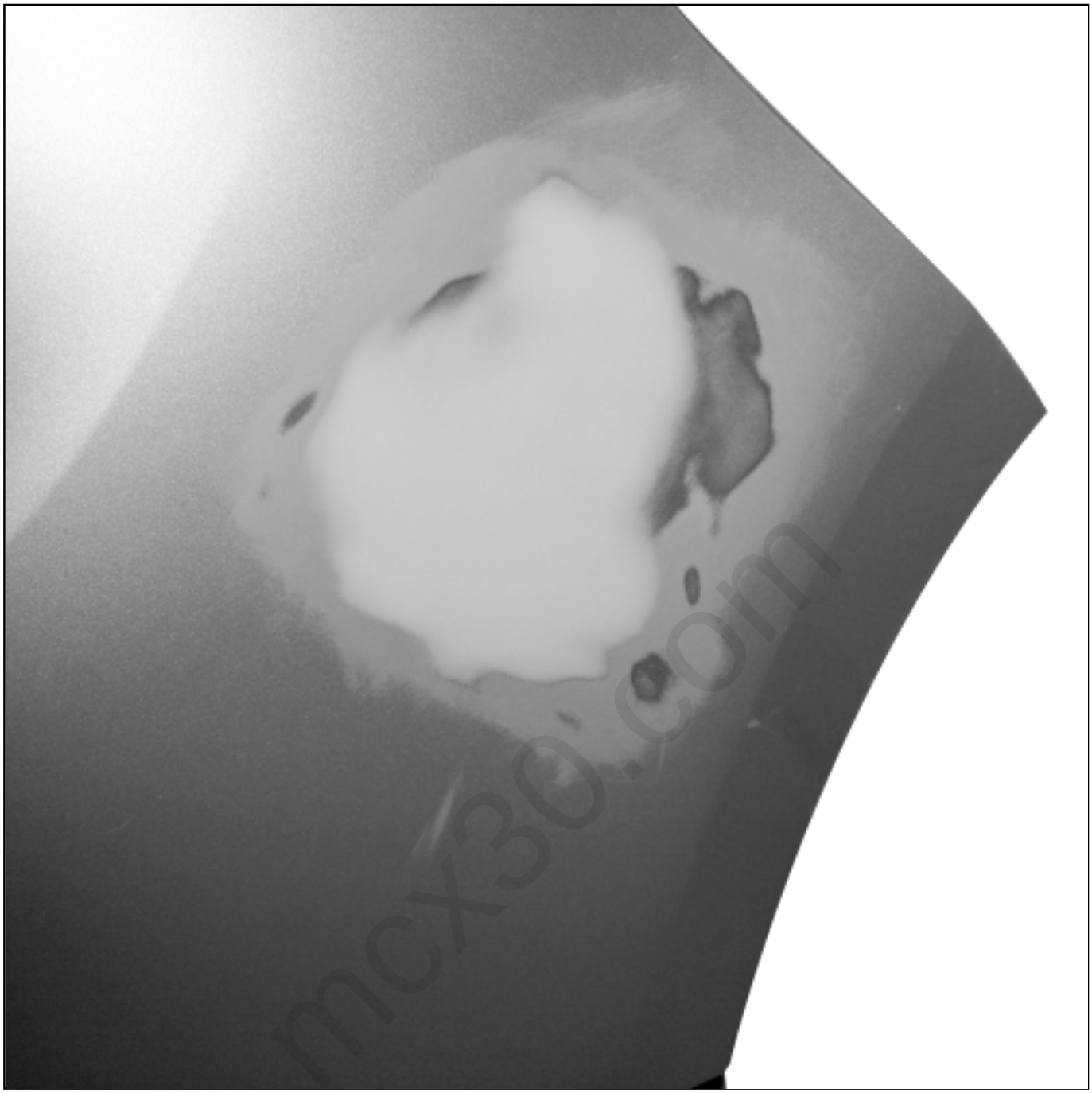


Blow the component and clean the area to be repaired with a LINT-FREE CLOTHsoaked in ANTISTATIC THINNER Vehicle: Parts and consumables for the repair (04B, Consumables - Products).

Wipe the area with a clean, dry LINT-FREE CLOTHVehicle: Parts and consumables for the repair (04B, Consumables - Products).

If necessary, apply a finishing mastic(see product technical sheet) **Vehicle: Parts and consumables for the repair** (04B, Consumables - Products).

Sand the finishing masticwith a P 150then finish with a P 240.



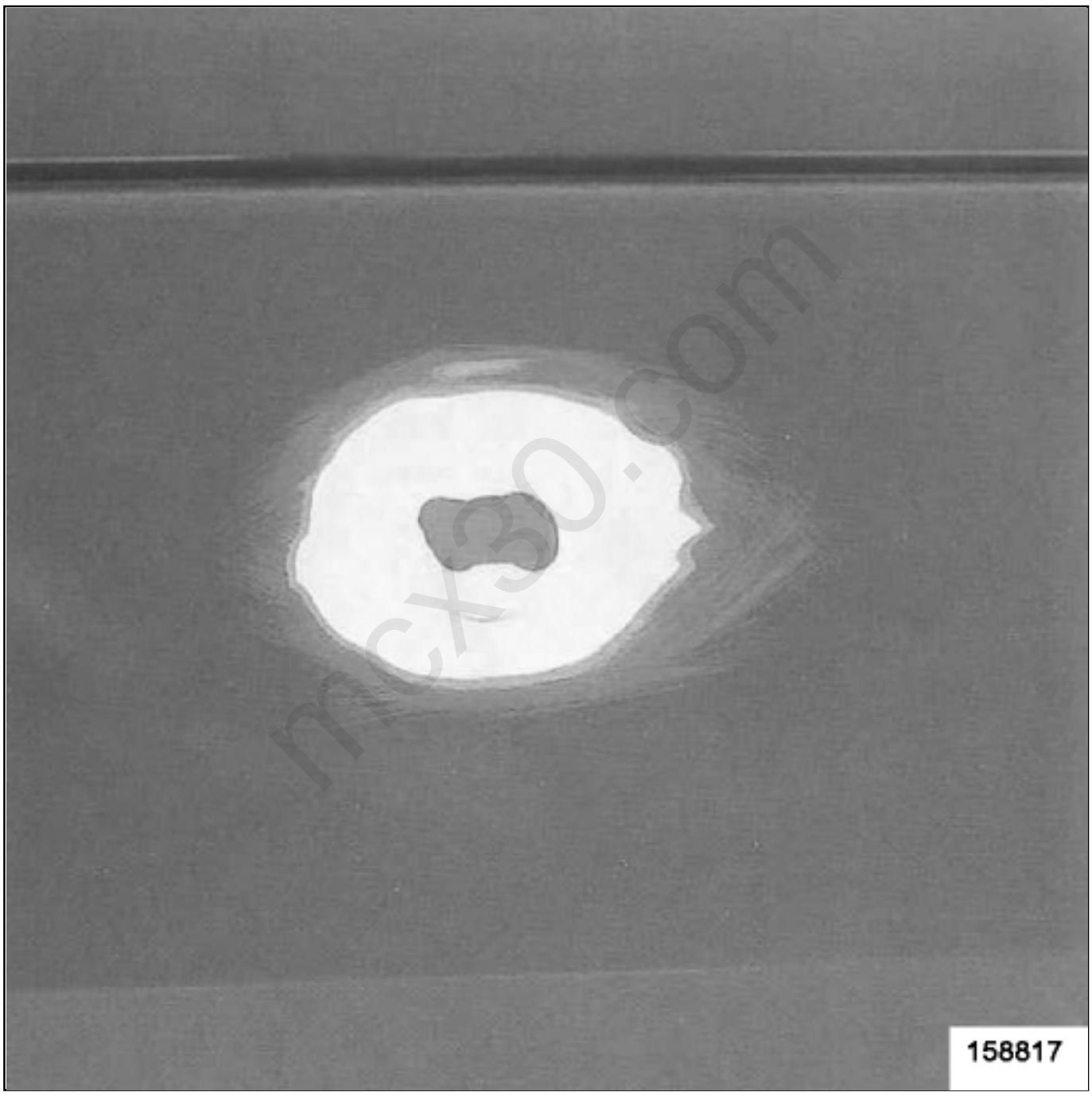
Follow the paint application procedure according to the material concerned:

- **Polypropylene / polyethylene bodywork component: Preparation and paint range** (Technical Note 592A, 95A, Paint application procedure on plastic),

- **Noryl bodywork component: Preparation and paint range** (Technical Note 592A, 95A, Paint application procedure on plastic).

Note:

Method apply only on RTM component.



Chamfering around a radius between 30to 40 mmusing the orbital sander with a P80.

Sand the paint around the zone to be repaired using the orbital sander with a P 150

Blow the component and clean the area to be repaired with the Acetone(see product techincal sheet).

Cut a piece of materielrecovering the chamfering.

Prepare the Epoxy resin(see 50A, General information, Products for plastic material bodywork components: Description) .

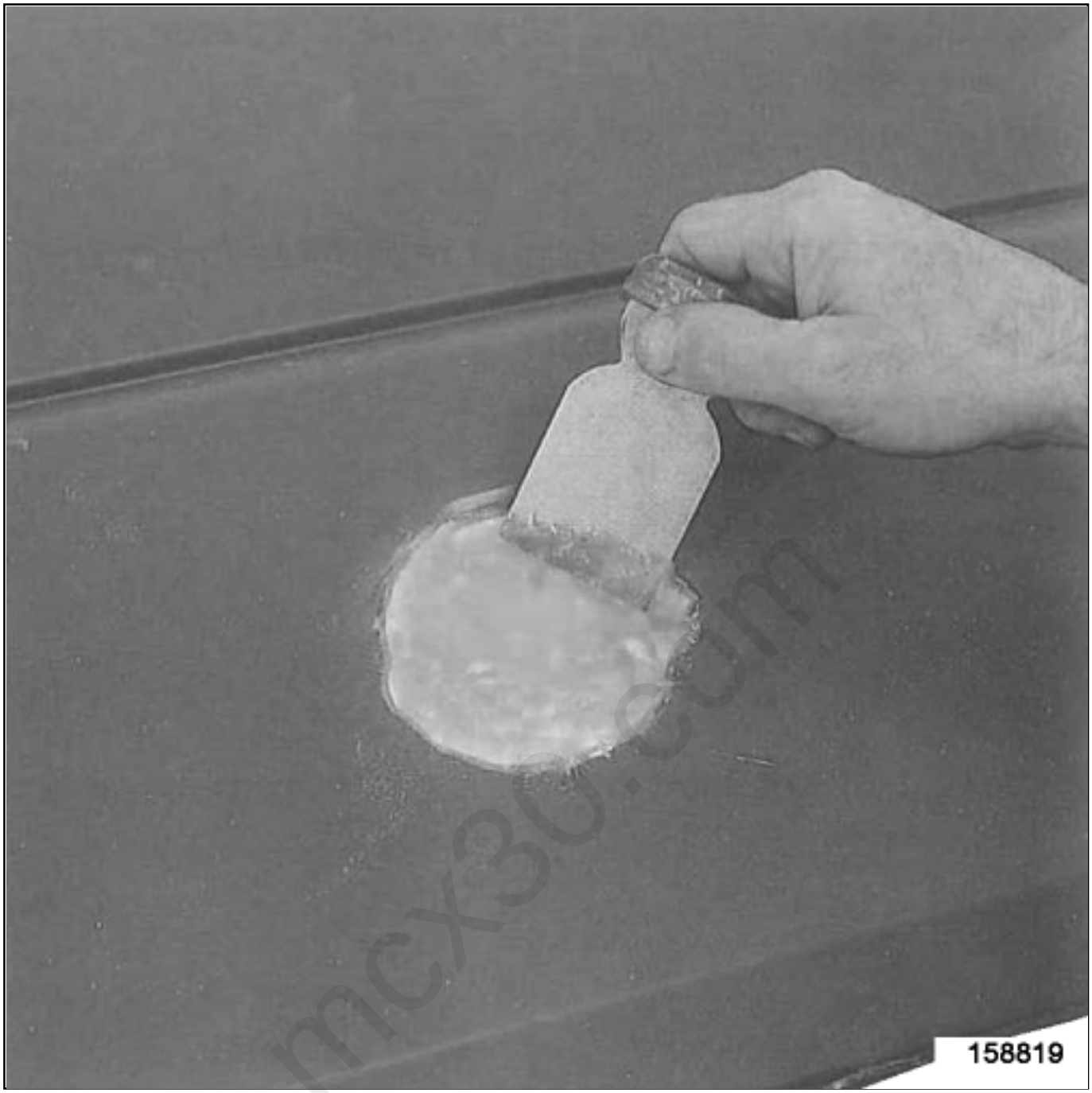
- Wet the chamfer with Epoxy resin.

- Position the reinforcement a poket.

- Soak the reinforcement with Epoxy resin.

Note:

After 15 minutes,accelerate the hardening in drying oven or in infrared drying device(60° C maxi at a distance of 70 cm).



- Prepare the Epoxy resin (see 50A, General information, Products for plastic material bodywork components: Description) .

- Add short fibres with resin and well mix.

- Fill the pocket with mixture.

Note:

After 15 minutes,accelerate the hardening in drying oven or in infrared drying device(60° C maxi at a distance of 70 cm).

Sand using the orbital sander with a P 80then with a P180and P240.

Apply if necessary a finishing mastic(see product technical sheet). (see **Vehicle: Parts and consumables for the repair**)

Sand the finishing masticusing a P 150then finish using a P240.

5. PROCEDURE 4

Repairing a mounting bracket on a plastic chassis element

1- BONDING METHOD

Note:

Before any repairs, check the reparability of components made from plastic materials.

(see 50A, General information, Products for plastic material bodywork components: Description) .

(see 50A, General information, Plastic material bodywork component: Precautions for the repair) .

Chamfer the two sections of the mounting bracket on both sides using a grinder with an angular member .

Blast and clean the inside and outside of the component with the cleanerincluded in the Plastic repair kit box.

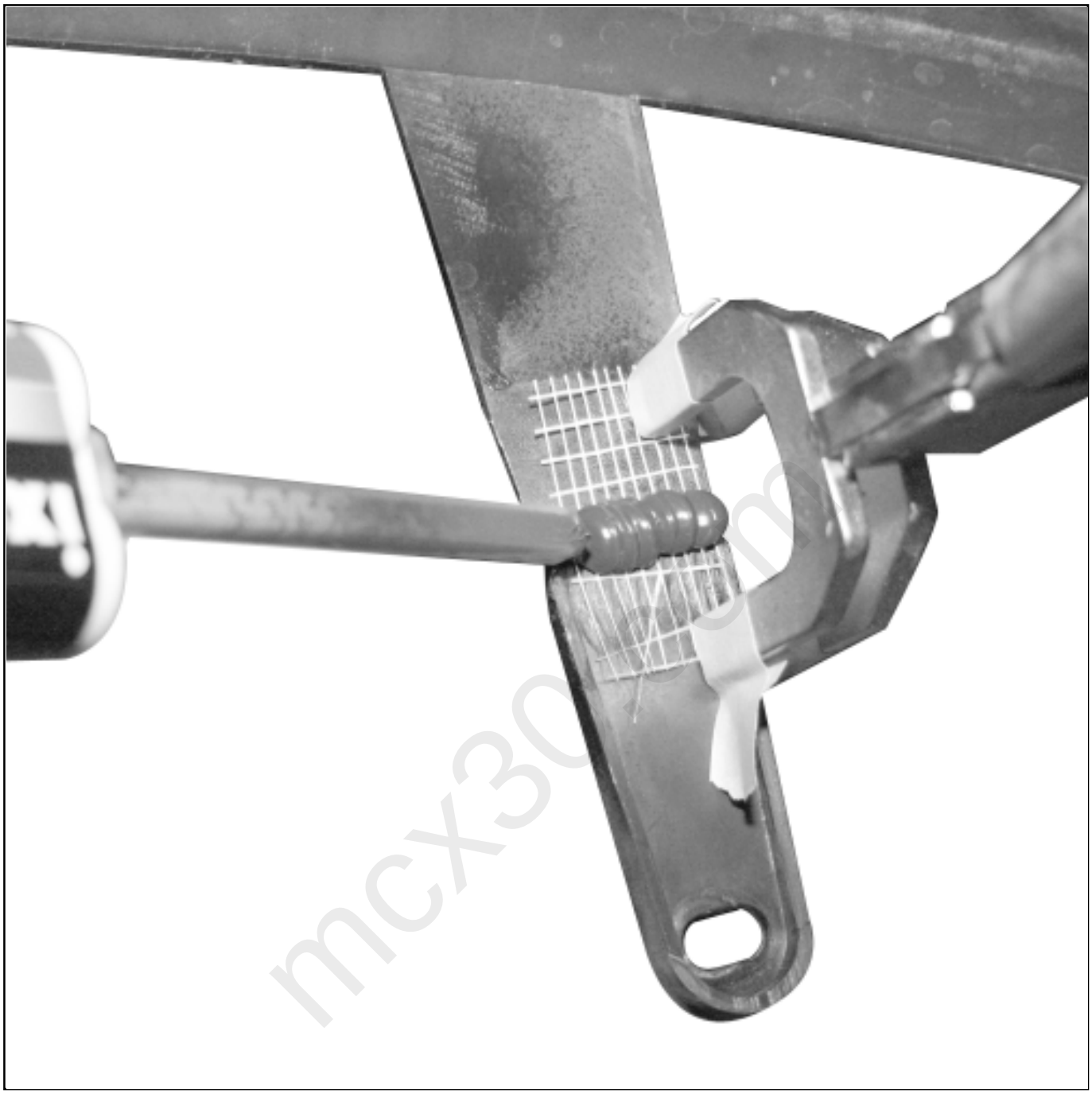
Apply the adhesive primerincluded in the Plastic repair kitbox to the inside and outside of the component.

Leave the adhesive primer to dry (see product technical sheet).

Adjust a piece of reinforcing film (cloth) adapted to repairing the internal and external faces.

Prepare the bi-component repair mastic (see 50A, General information, Products for plastic material bodywork components: Description) .

Maintain pressure on the two parts with pliers.



- Extrude bi-component repair masticbetween the two parts.
- Smooth the bi-component repair masticon the internal and external faces.
- Leave the bi-component repair masticto dry (see product technical sheet).

- Surface the exterior side with a P 150then finish with a P 240.
- Retouch the paintwork if necessary.

2- WELDING METHOD

Note:

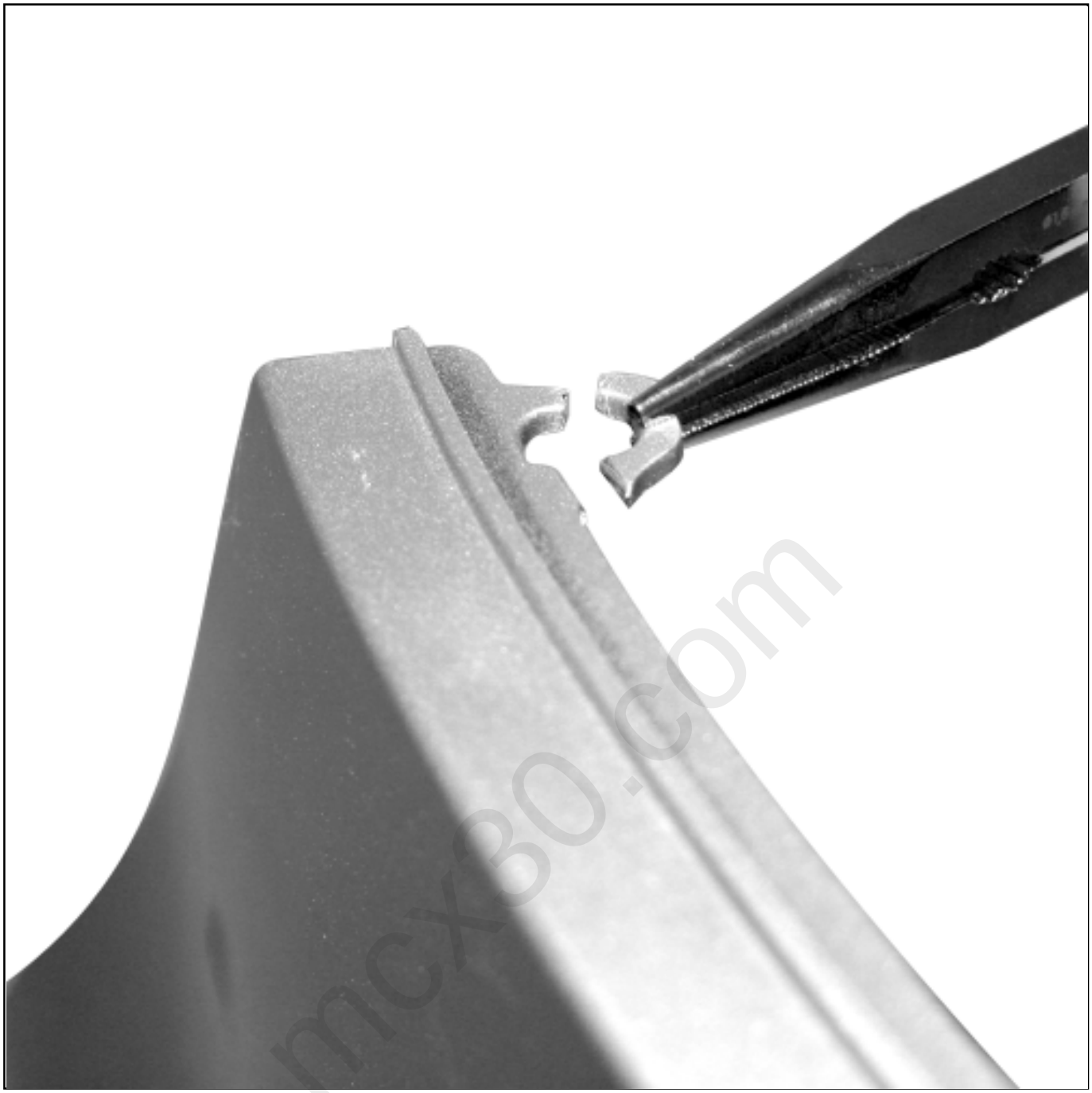
Before any repairs, check the reparability of components made from plastic materials.

(see 50A, General information, Products for plastic material bodywork components: Description) .

(see 50A, General information, Plastic material bodywork component: Precautions for the repair) .

Note:

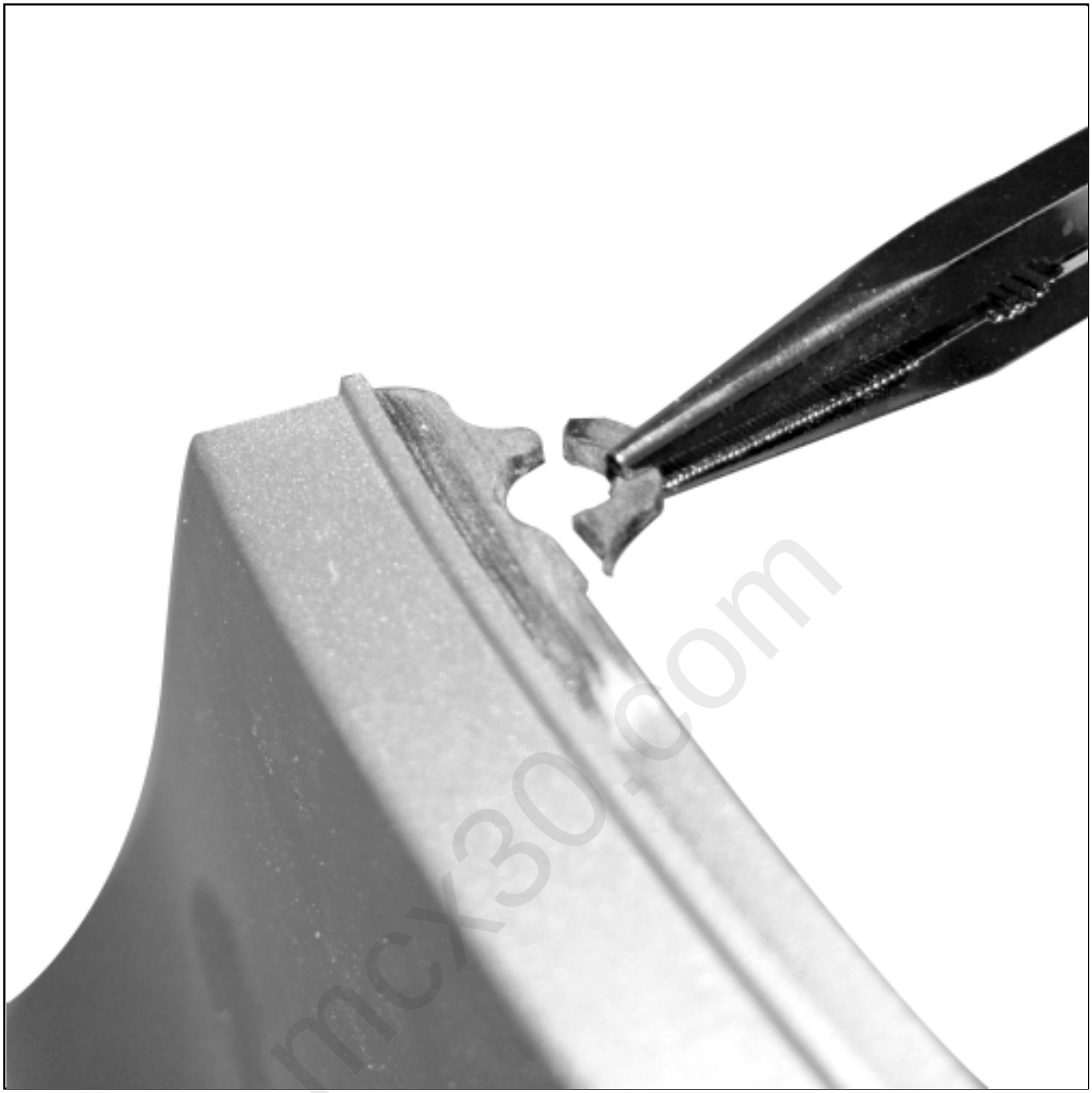
This repair cannot be carried out on ABS, ASAand Polycarbonateplastics.



- Wash the component in soapy water and rinse in clean water.

- Clean the area to be repaired with a LINT-FREE CLOTHsoaked in ANTISTATIC THINNERVehicle: Parts and consumables for the repair (04B, Consumables - Products).

- Wipe the area with a clean, dry LINT-FREE CLOTHVehicle: Parts and consumables for the repair (04B, Consumables - Products).



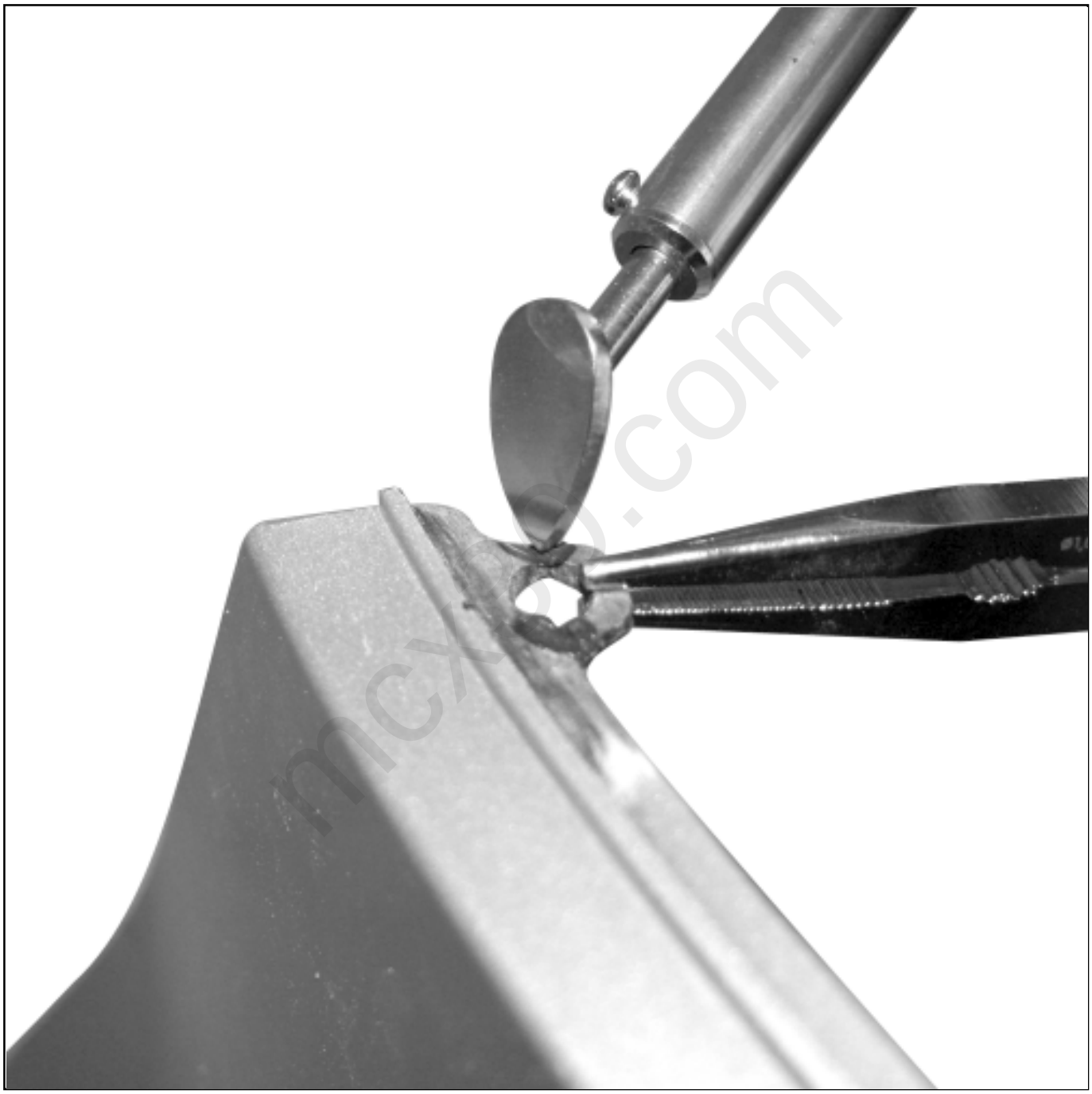
Strip the paint with P 150on the repair area.

Blow the component and clean the area to be repaired with a LINT-FREE CLOTHsoaked in ANTISTATIC THINNER Vehicle: Parts and consumables for the repair (04B, Consumables - Products).

Wipe the area with a clean, dry LINT-FREE CLOTHVehicle: Parts and consumables for the repair (04B, Consumables - Products).

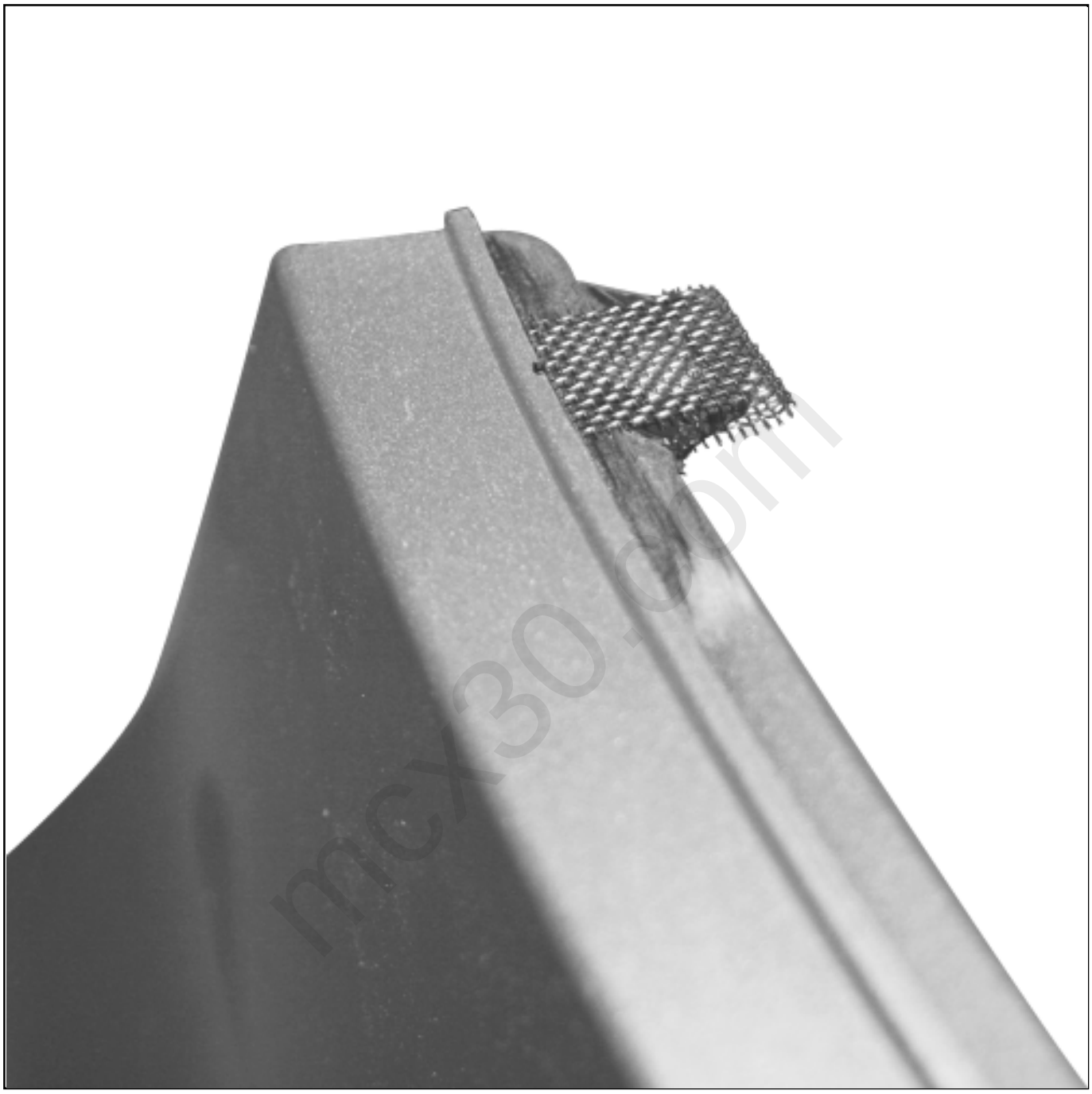
Preheat the soldering iron.

Cut the stainless steel mesh according to the shape of the support.



Spot-weld with the tip of the soldering iron on the ends in order to hold the mounting bracket.

Cool each spot weld, for two seconds, vigorously with the cooler[Vehicle: Parts and consumables for the repair](#) (04B, Consumables - Products).



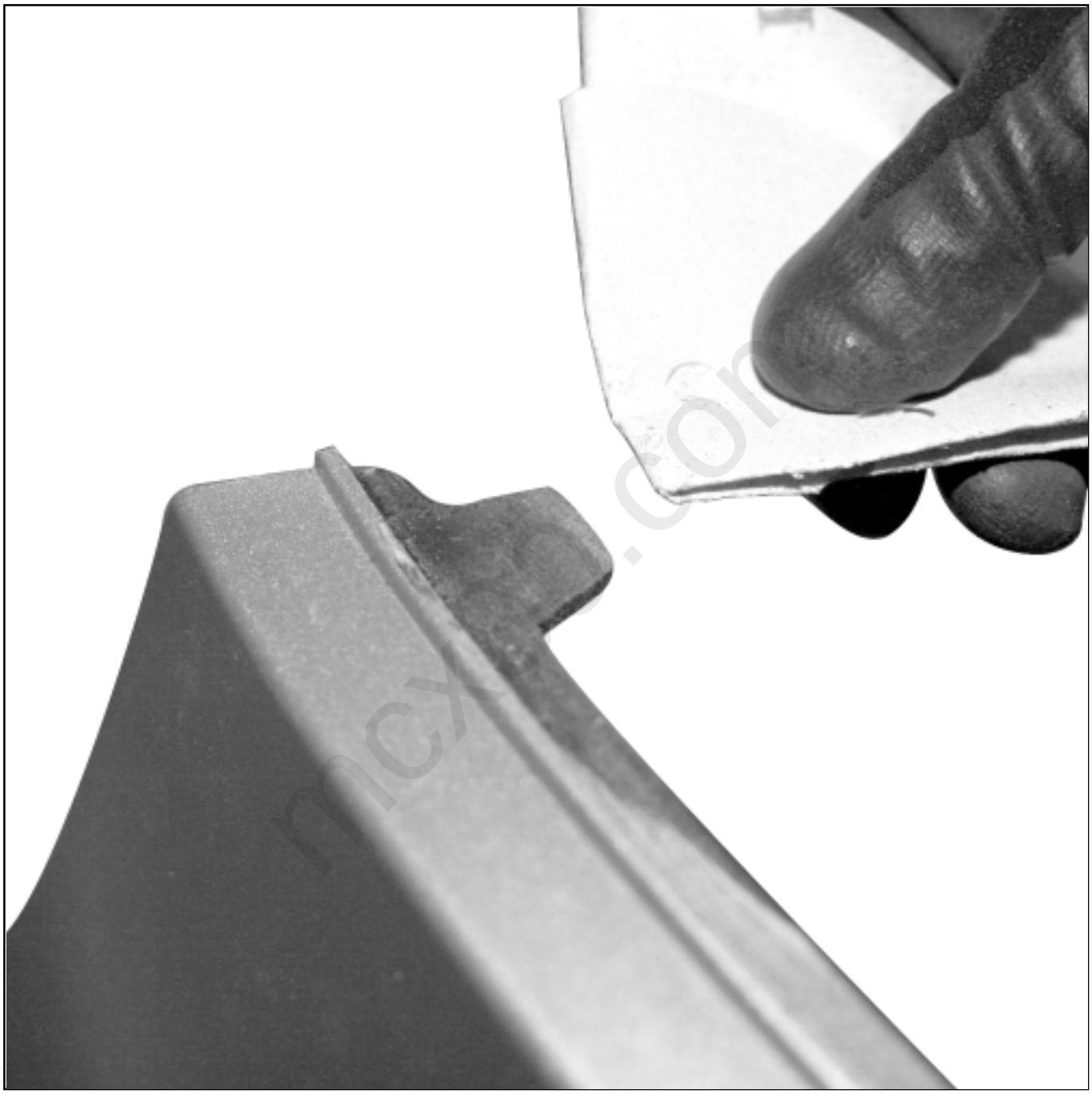
Position the stainless steel mesh and hold it using a dedicated tool.

Enclose the stainless steel frame in the plastic material.

Cool the whole of the repaired area for two seconds, vigorously with the cooler[Vehicle: Parts and consumables for the repair](#) (04B, Consumables - Products).

Add material by preheating the welding rod with the tip of the soldering iron.

Cool the whole of the repaired area for two seconds, vigorously with the cooler**Vehicle: Parts and consumables for the repair** (04B, Consumables - Products).



Surface with a P 80to P 150then finish with a P 240.

Blow the component and clean the area to be repaired with a LINT-FREE CLOTHsoaked in

ANTISTATIC THINNER Vehicle: Parts and consumables for the repair (04B, Consumables - Products).

Adjust the shape of the part to return it to its original appearance.

Retouch the paintwork if necessary.

6. PROCEDURE 5

Partial replacement of an element by cuting.

Note:

Method apply only on RTM component.

Note:

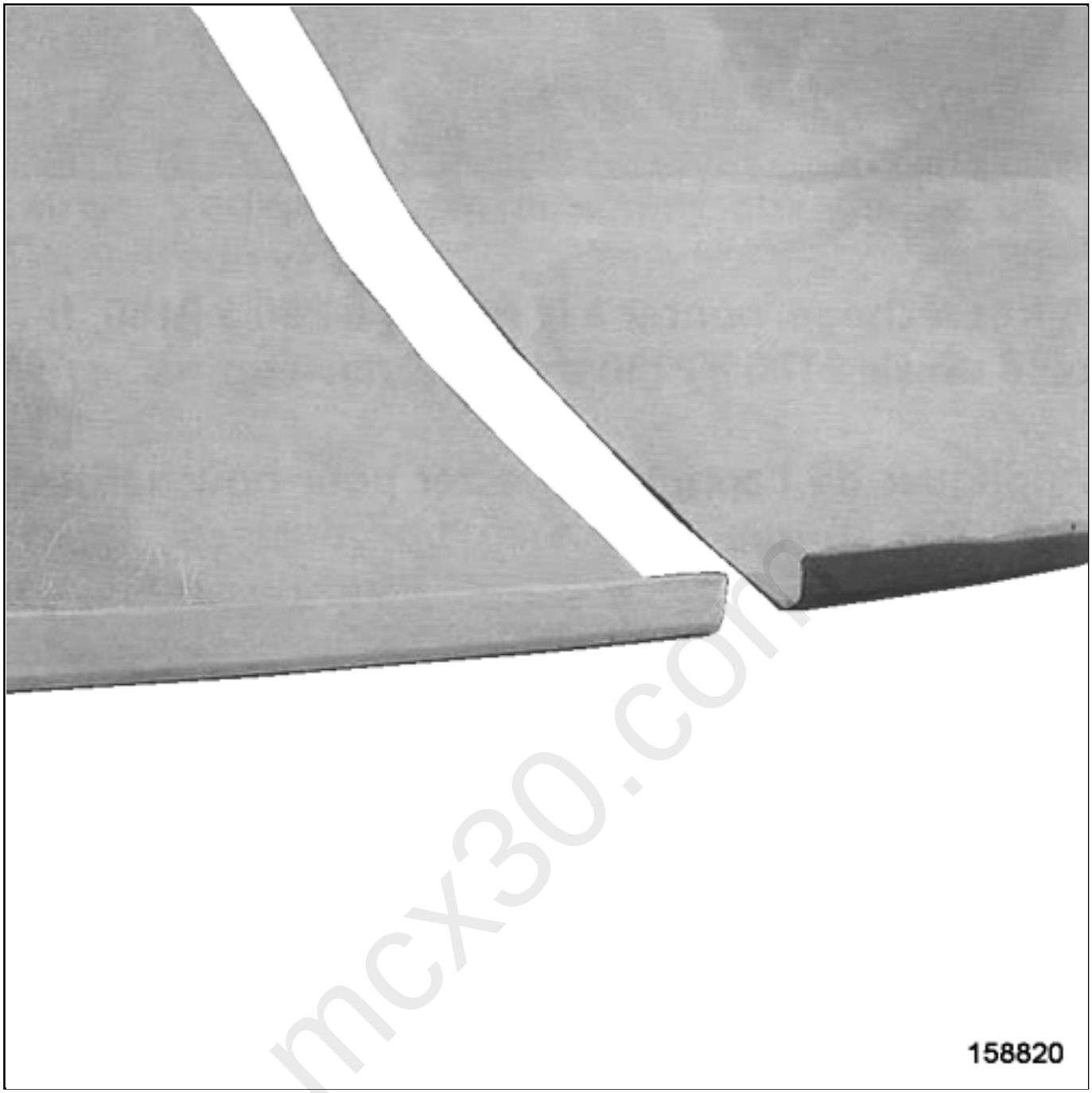
The components are manufactured by the method referred to as "contact" .

The reparation is performed by the interne face of the component.

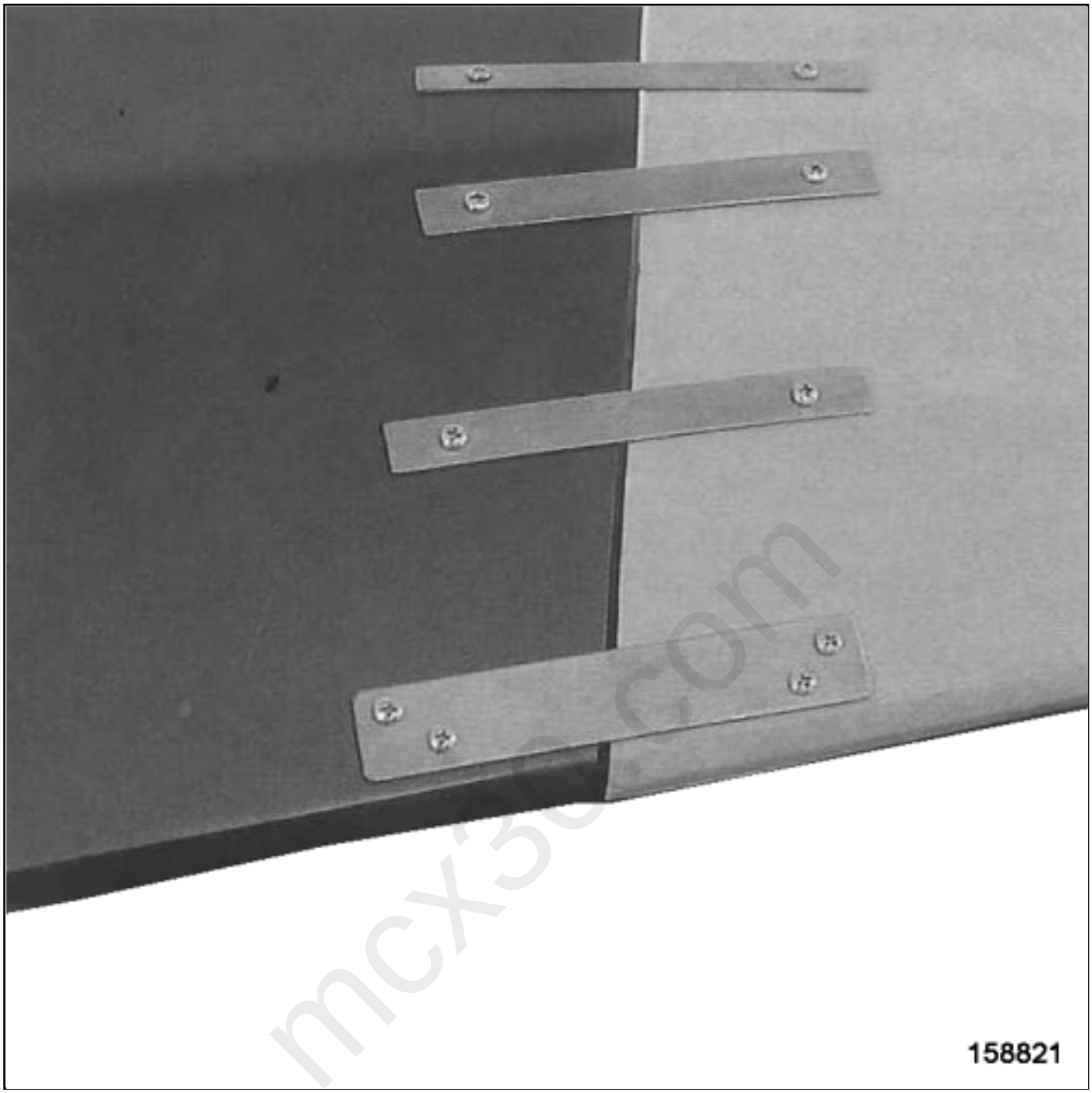
Cut the damaged component beyond the cracks.

Cut and adjust the new component.

Prepare a space from 5to 10mm between the two components.



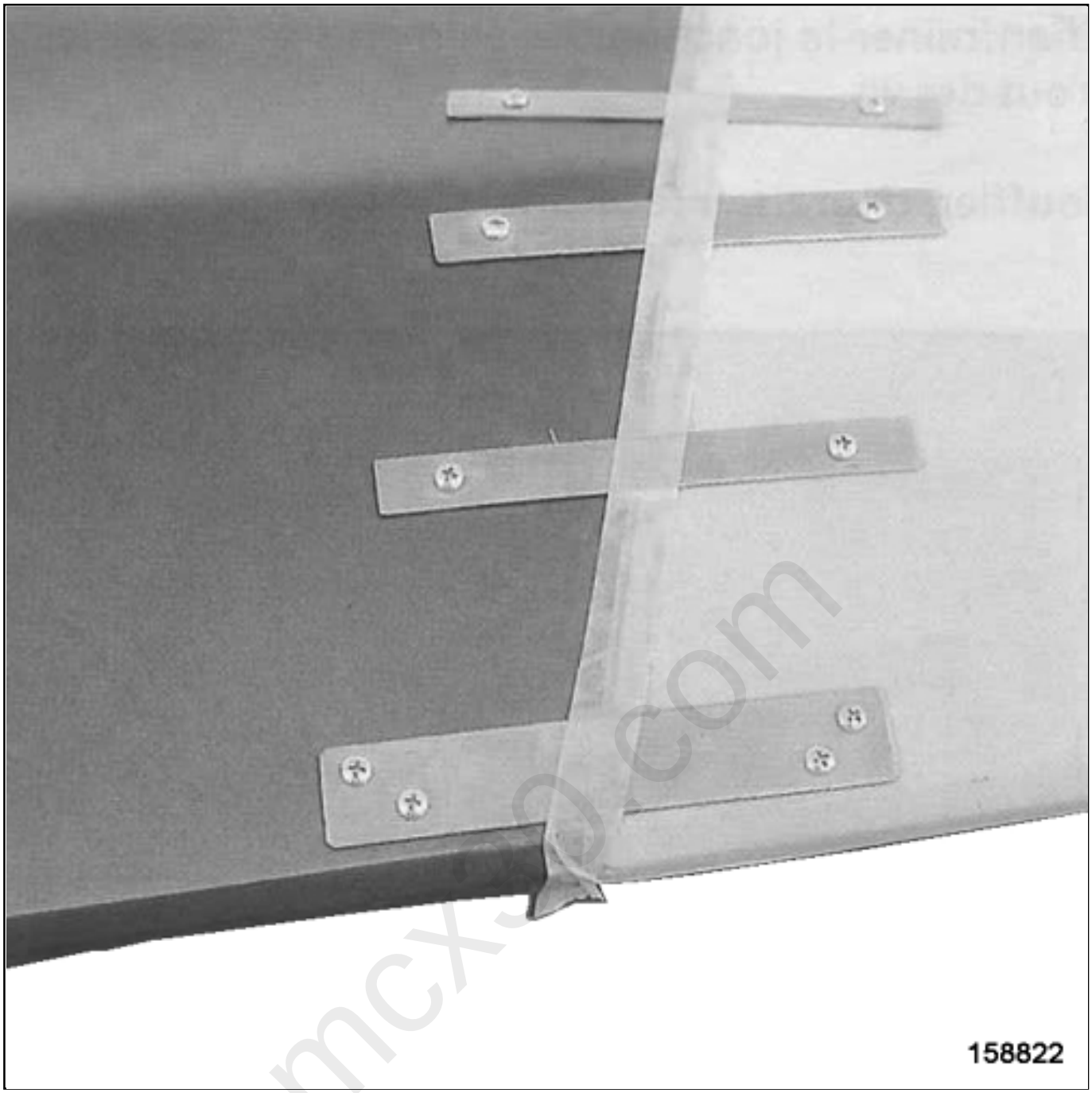
Chamfering the interne face of components on 100 mmwide.



- Position the new component.

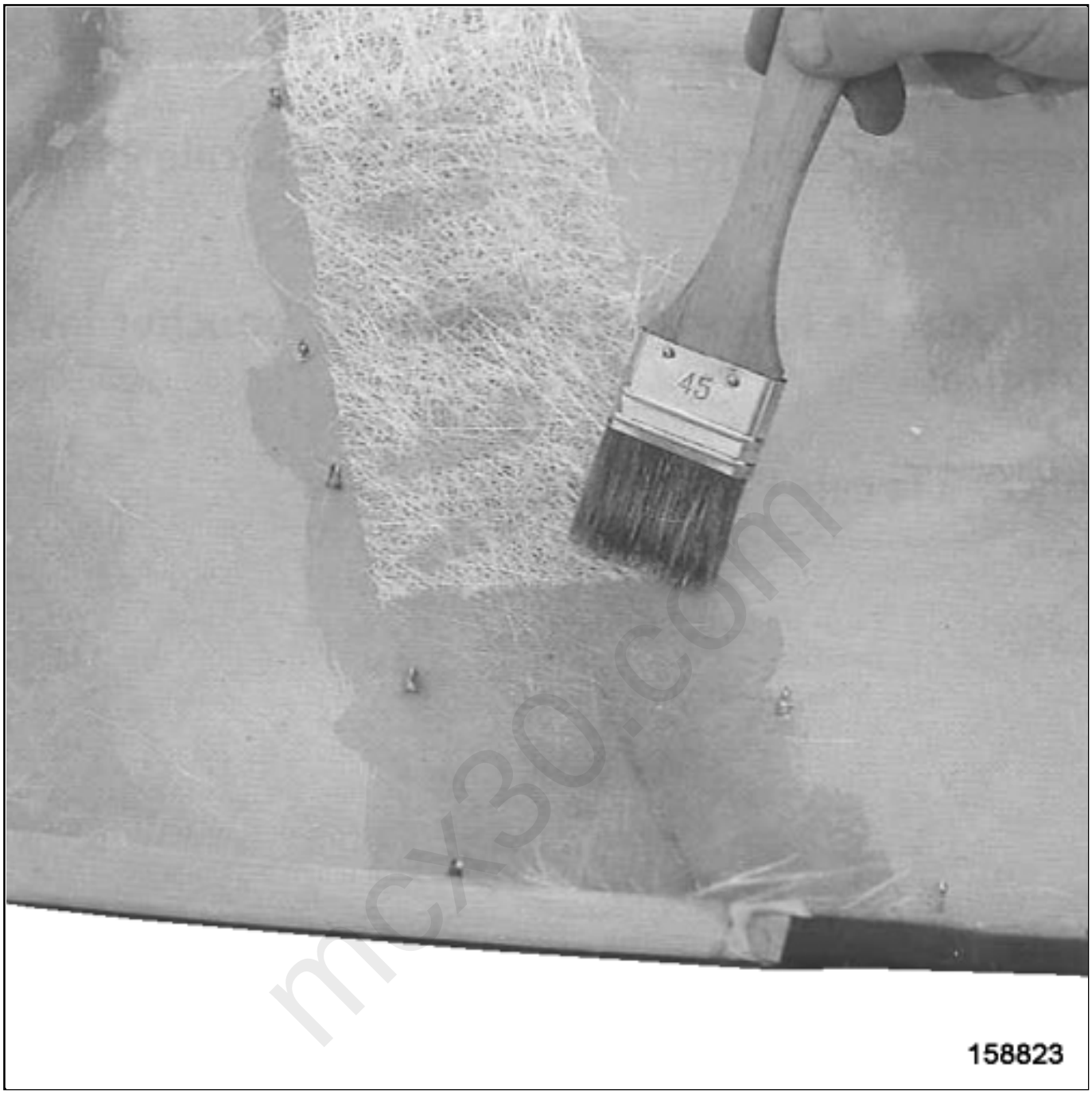
- Hold the new component by the externe face using a plate pad(local manufactured)and fix them with plate screws.

- Check the clearance and the flush fitting.



- Bond a masking tape on externe face on all reparation length.
- Blow the component and clean the area to be repaired with the Acetone(see product techincal sheet).
- Cut a piece of materielrecovering the reparation assembly.
- Prepare the Epoxy resin(see 50A, General information, Products for plastic material bodywork components:

Description) .



Put the material strip by soaking with resin.

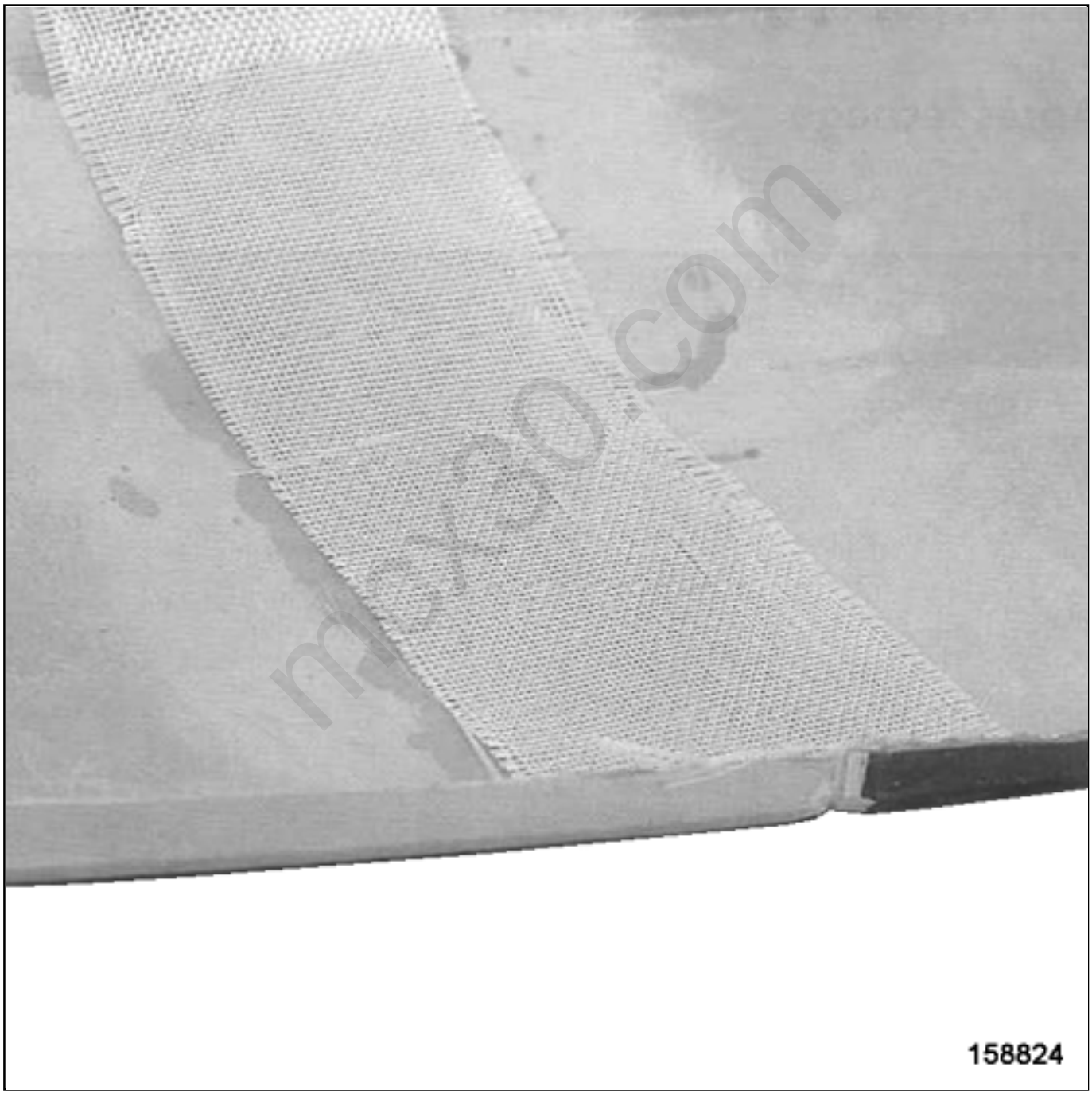
Note:

Pay particular attention at output screw area and at strips junction reinforcement to prevent the air bubbles form.

Note:

After 15 minutes,accelerate the hardening in drying oven or in infrared drying device(60° C maxi at a distance of 70 cm).

Remove the pads.



Prepare the reinforcement strips(material, cloth)by cuting then in a growing order 10 to 15 mm

Note:

According with the component width, the reinforcement strips number is variable, the purpose is to conserve the characteristic similar to the original.

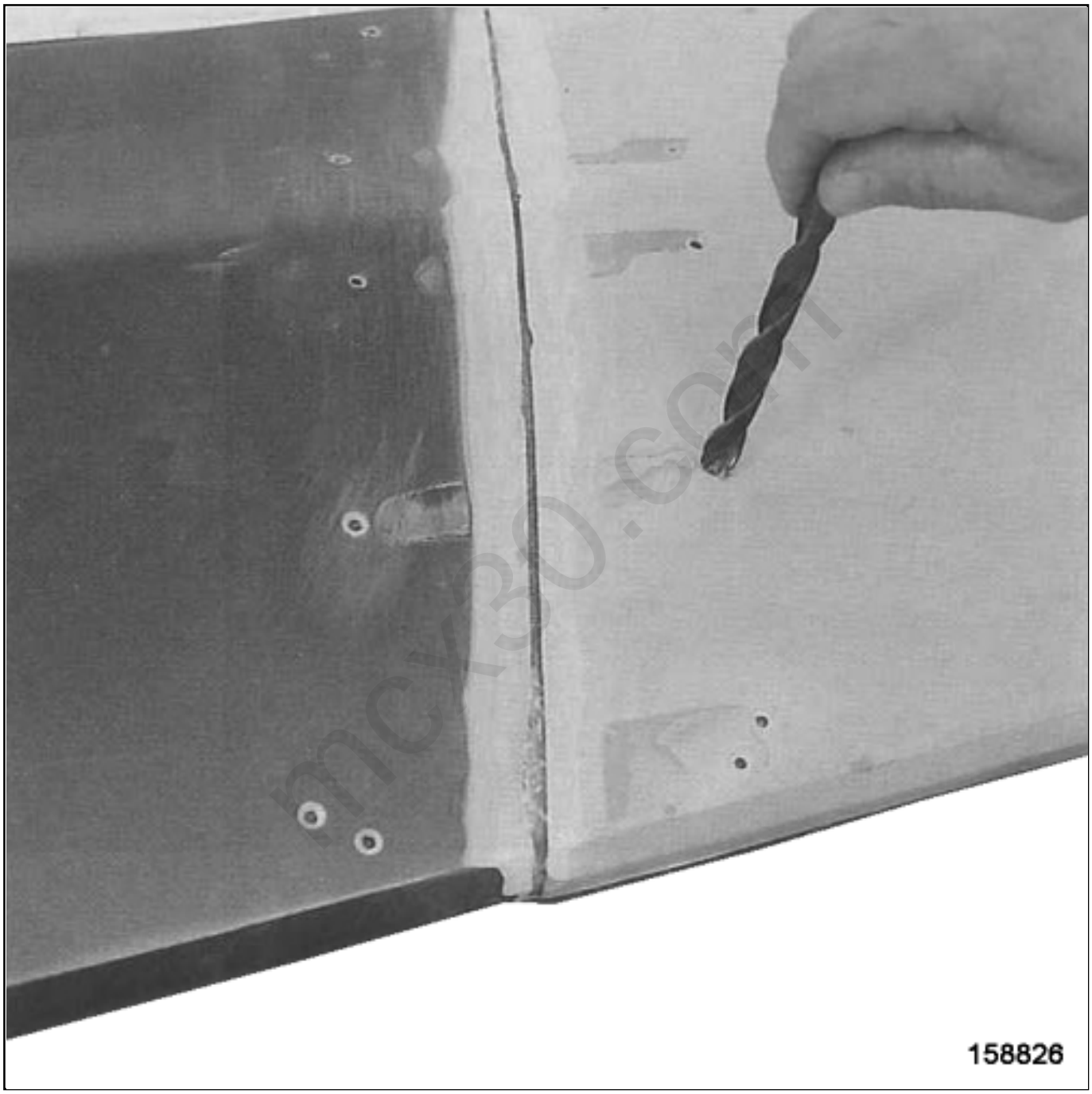
- Sand the zone to be repaired using the orbital sander with a P 40
- Blow the component and clean the area to be repaired with the Acetone(see product techincal sheet).
- Prepare the Epoxy resin(see 50A, General information, Products for plastic material bodywork components: Description) .

Put the material strip by soaking with resin.

Pass the spiked roller.

Note:

After 15 minutes,accelerate the hardening in drying oven or in infrared drying device(60° C maxi at a distance of 70 cm).



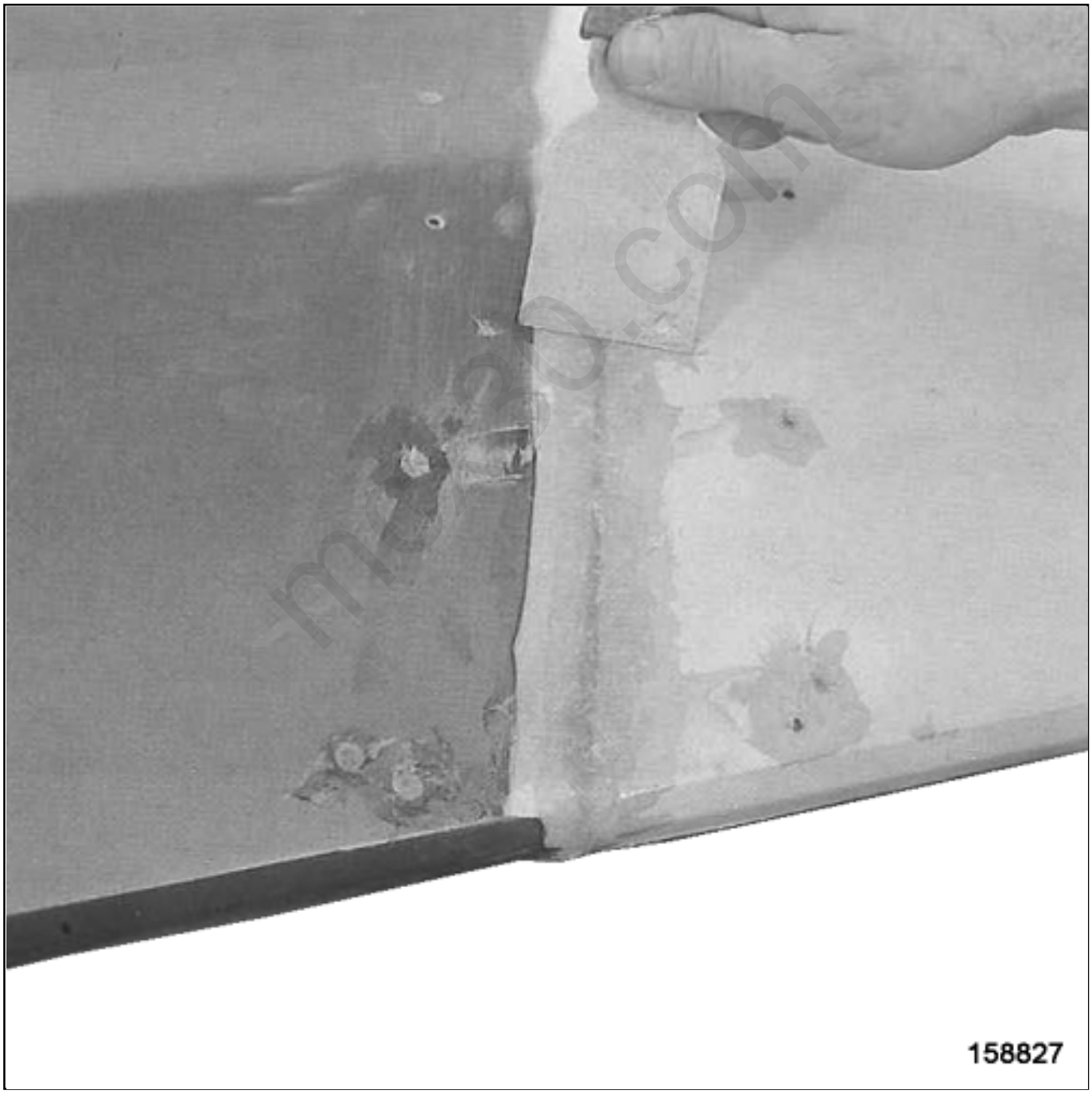
Chamfering the components junction.

Countersink the screws holes.

Blow the component and clean the area to be repaired with the Acetone(see product techincal sheet).

Prepare the Epoxy resin(see 50A, General information, Products for plastic material bodywork components: Description) .

Add short fibres with resin and well mix.



Fill the chamfer and the holes using a spatula.

Note:

After 15 minutes,accelerate the hardening in drying oven or in infrared drying device(60° C maxi at a distance of 70 cm).

Apply if necessary a finishing mastic(see product technical sheet). (see **Vehicle: Parts and consumables for the repair**)

Sand the finishing masticusing a P 150then finish using a P240.

7. PROCEDURE 6

Partial replacement of an element by cuting with patcht drilling.

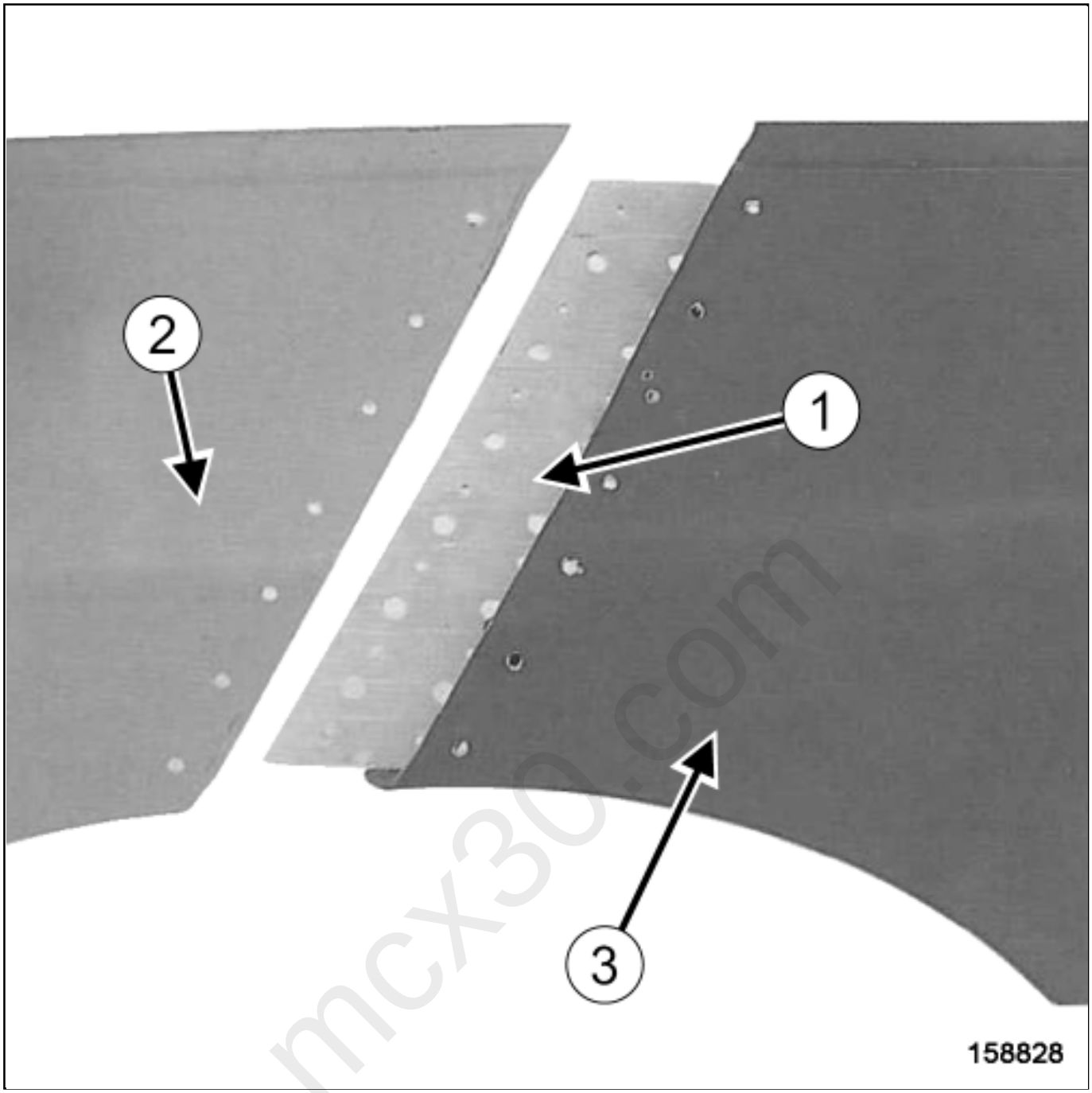
Note:

Method apply only on RTM component.

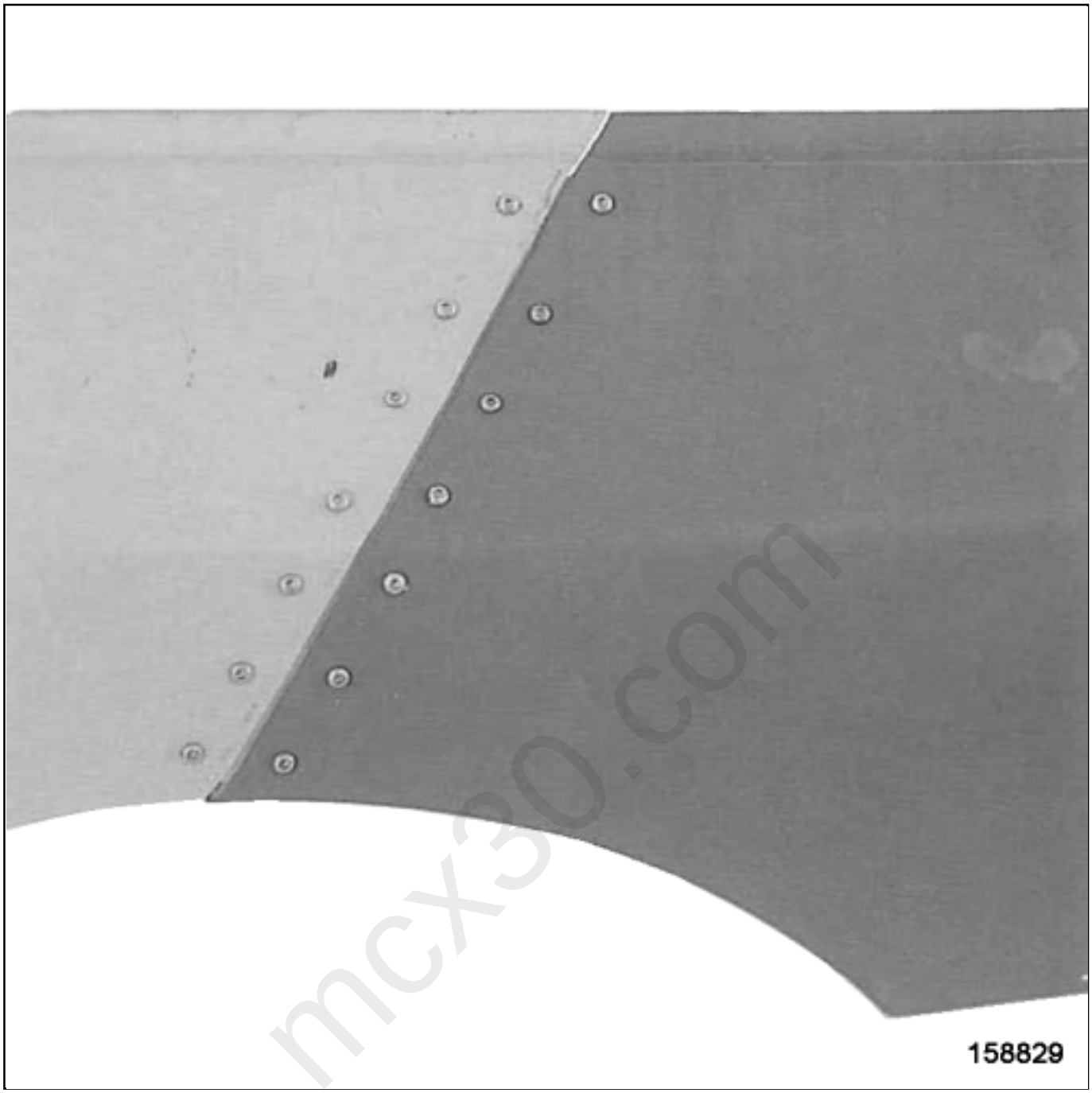
Note:

The components are manufactured by the method referred to as "contact" .

The reparation is performed by the interne face of the component.



- Cut the damaged component for facilitate the patcht drilling.
- Cut and adjust the new component.



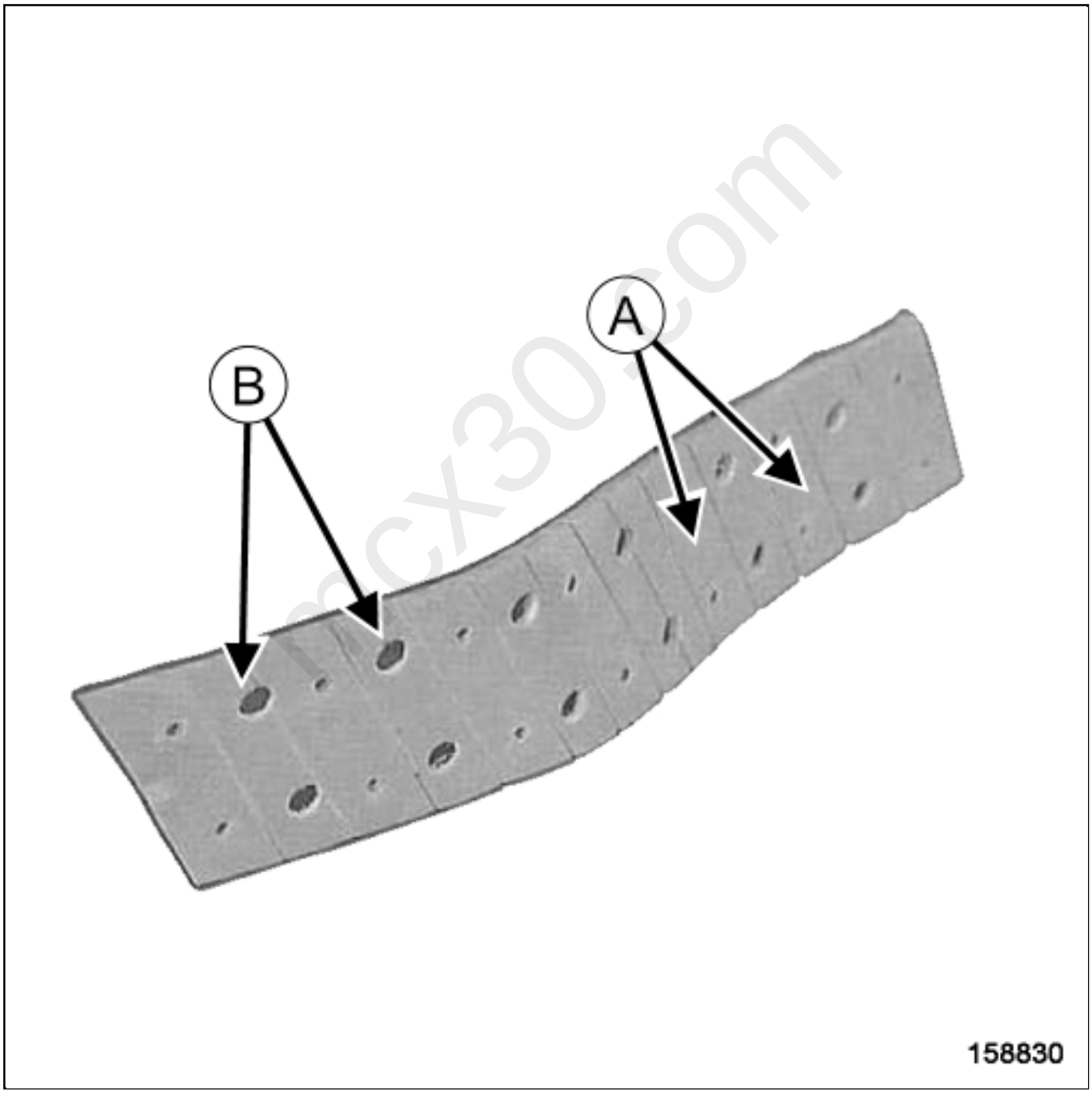
- Drill the component on the vehicle.
- Temporary fit on the vehicle the patch drilling with plate screws.
- Position the new comonent on the vehicle.

Fit on the vehicle the patch drilling with plate screws.

If necessary hold the new components with locking pliers.

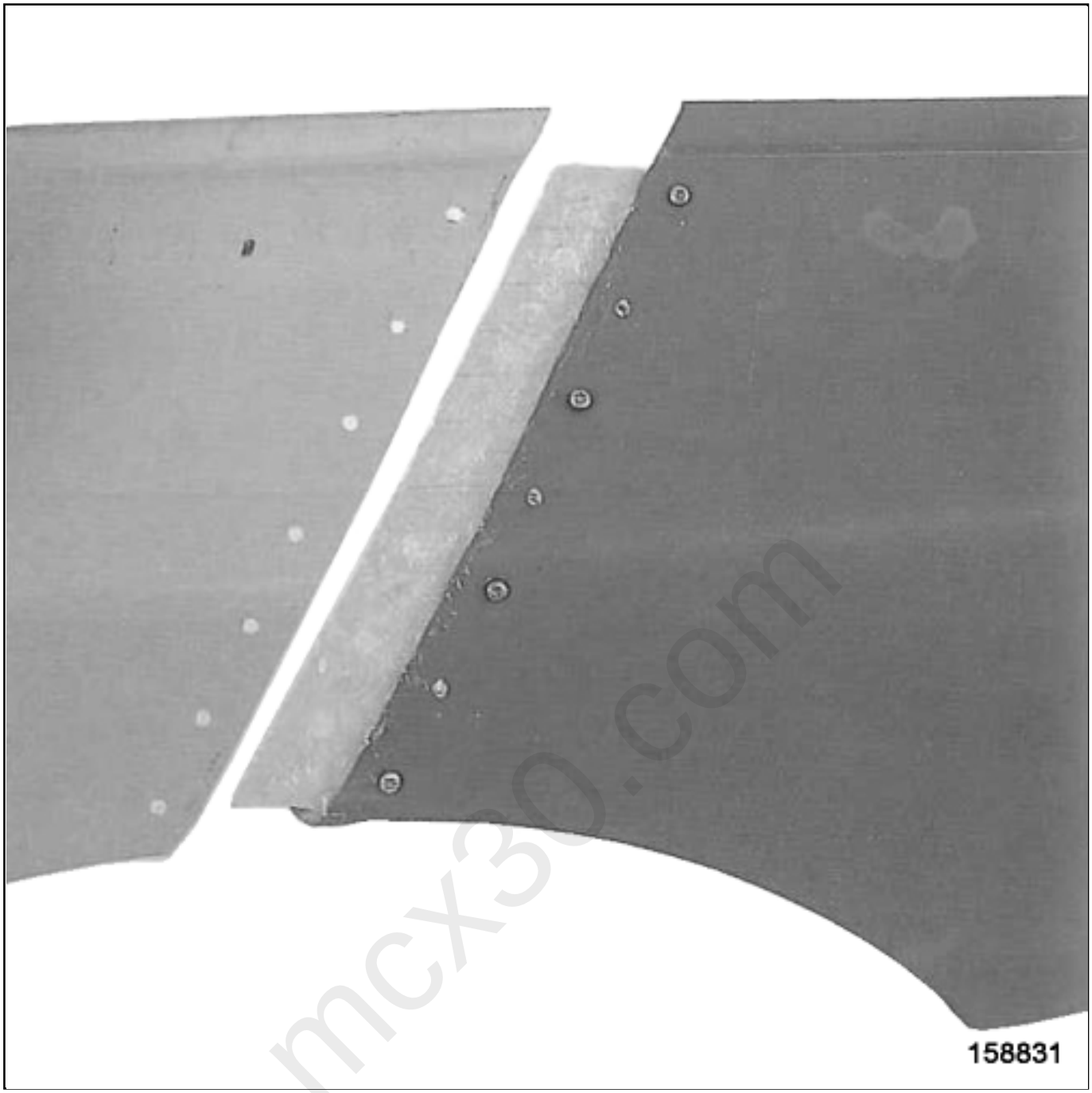
Check the new component position.

Remove all components.

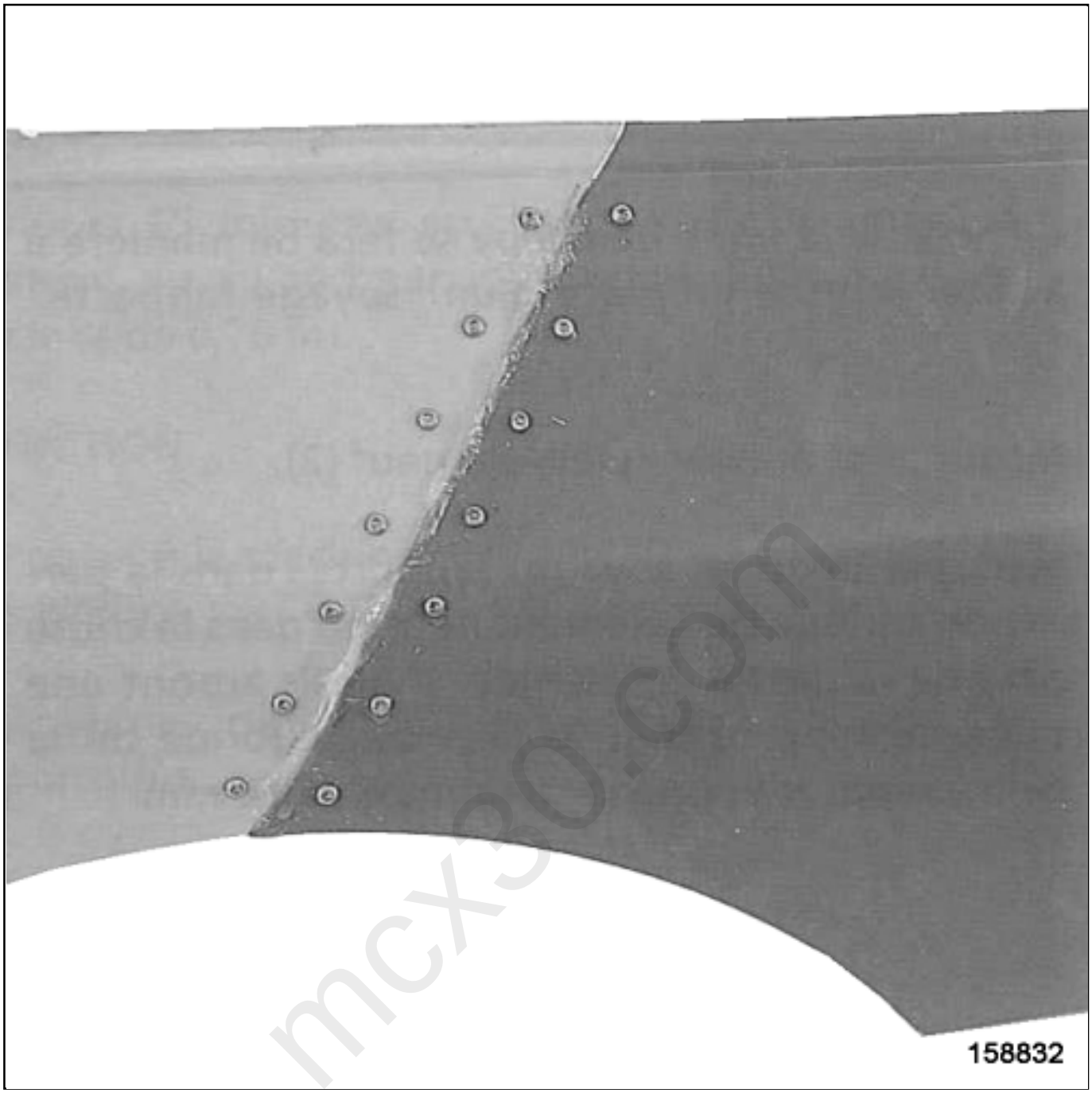


Do the grooves(A) , in the intern al side of patch drilling for adjust to the curve of component on the vehicle.

- Drill the holes(B) with a 8 mmdiameter.
- Countersink the holes fron external side.
- Sand the zone to be repaired using the orbital sander with a P 40
- Blow the component and clean the area to be repaired with the Acetone(see product techincal sheet).
- Prepare the Epoxy resin(see 50A, General information, Products for plastic material bodywork components: Description) .



Band the half way of patcht drillingand fit on the component on the vehicle using plate screws.



Band the second half way of patcht drilling.

Note:

After 15 minutes,accelerate the hardening in drying oven or in infrared drying device(60° C maxi at a distance of 70 cm).

Remove the plate screws.

Blow the component and clean the area to be repaired with the Acetone(see product techincal sheet).

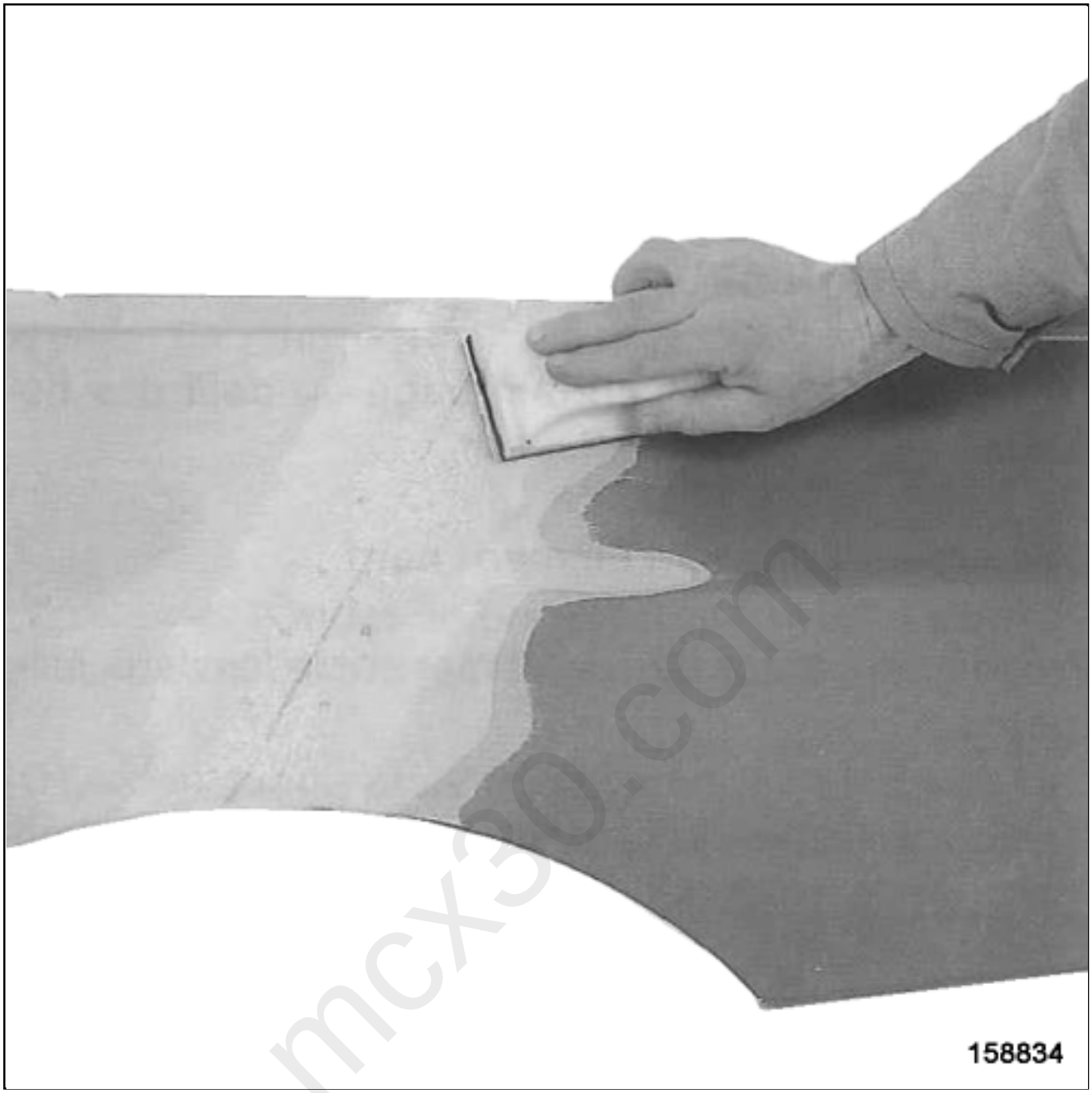
Prepare the Epoxy resin(see 50A, General information, Products for plastic material bodywork components: Description) .

Apply the reinforcement by soaking of resin.

Note:

After 15 minutes,accelerate the hardening in drying oven or in infrared drying device(60° C maxi at a distance of 70 cm).

- Sand the zone to be repaired using the orbital sander with a P 40
- Blow the component and clean the area to be repaired with the Acetone(see product techincal sheet).
- Prepare the Epoxy resin(see 50A, General information, Products for plastic material bodywork components: Description) .
- Add short fibres with resin and well mix.
- Apply the mixture on reparation zone.



- Sand using the orbital sander with a P 80then with a P180and P240.

- Apply if necessary a finishing mastic(see product technical sheet). (see **Vehicle: Parts and consumables for the repair**)

- Sand the finishing masticusing a P 150then finish using a P240.