



Plastic Repair with Teroson



Rough Cleaning

1

With a high pressure cleaner or similar, the part should be cleaned to have all dirt and loose particles removed.



Cleaning

2

Cleaning with Cleaner FL is required to remove all surface residues present at the repair area. Only a residue free surface will provide optimum adhesion.



Pre-Treatment

3

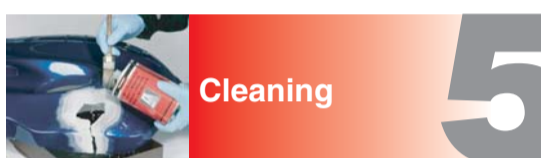
Grind the edges around the repair area to a V-Shape (2cm wide each side). This is to enlarge the contact area for the adhesive.



Pre-Treatment

4

The surface around the repair area is sanded on both sides. This provides for an optimum-bonding surface.



Cleaning

5

Clean again using Cleaner FL to remove grinding dust.



Priming

6

Apply a thin coat of Terokal 150 Primer to both sides and leave to dry for 5 - 10 minutes.



Adhesive Application

7

Apply a sufficient amount of adhesive to the backside of the repair part. In case of fissures, attach metal reinforcement strips (for alignment and reinforcement) using suitable clamps.



Adhesive Application

8

Place the fibre fleece over the adhesive and push the adhesive through the mesh using a spatula or similar to fully saturate the mesh. A change in colour is a good indication that saturation is complete. Smooth the surface.



Adhesive Application

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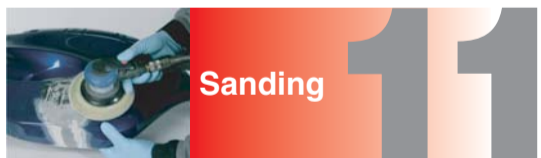
Apply a sufficient amount of adhesive to the front side of the repair part and smooth the surface. Please note: if too little adhesive has been applied, not enough material will be available for the sanding process and the procedure has to be repeated.



Curing

10

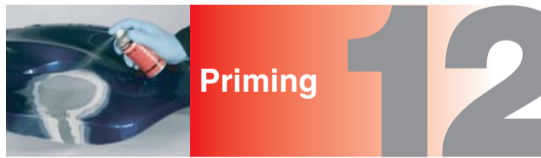
Place the repair area under an infra-red lamp at 60° - 70°C and let the adhesive cure for a minimum of 15 minutes.



Sanding

11

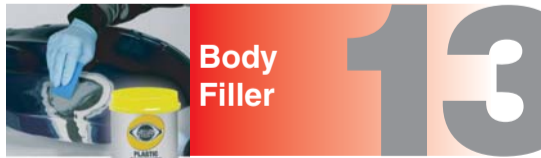
After the part is cooled down and dry, recreate the shape of the surface on the front side by sanding using progressively finer paper until the desired surface finish has been achieved.



Priming

12

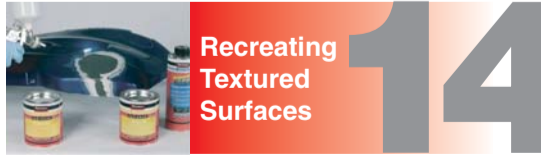
Remove sanding dust and apply a thin coat of Terokal 150 Plastic Primer to the entire repair area. Observe a flash-off time of 5 - 10 minutes.



Body Filler

13

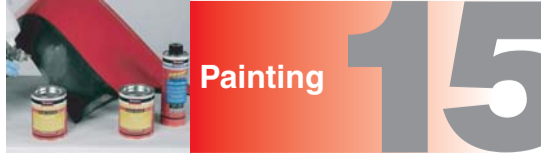
To smooth roughness and scratches on the surface apply Plastic Padding Plastic Filler using a plastic spatula. Afterwards sand the repair area again. Recommended sandpaper: 240 - 400 grit.



Recreating Textured Surfaces

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Unpainted textured surfaces can be recreated either with Terotex Super 3000 Black mixed with up to 50% clear paint and hardener or a mixture of Terotex Super 3000 Black & Light mixed with up to 50% clear paint and hardener.



Painting

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Painted bumpers are now ready for the paint process and should be processed in accordance with the paint suppliers recommendations & instructions.

