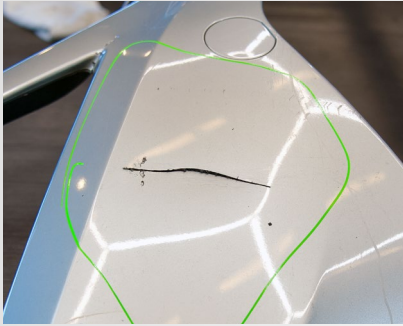
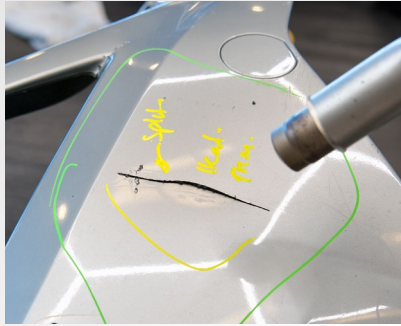




STEP 1 – Identify impact point

A split usually happens because the bumper was hit and pushed in. Check for a low beside the split.



STEP 2 – Heat and reshape first

Use the heat gun and push tool to remove the low before trying to weld the crack.



STEP 3 – Align the split perfectly

This is one of the most important steps. If the split is welded while misaligned, the repair becomes harder and may need extra correction.



STEP 4 – Trim stretched plastic

If the crack will not close cleanly, trim only the small stretched or interfering plastic. Small pieces can make the difference between a clean line and a poor fit.



STEP 5 – Tape the front

Tape holds the crack in alignment, but the plastic should sit naturally. Do not tape the crack while the bumper is twisted, hanging or under stress.



STEP 6 – Turn bumper, clean inside

Clean the back side surface before welding.



STEP 7 – Mark the inside

The crack can become harder to see once heat and sanding start. Mark it clearly with a marker.



STEP 8 – Strip the weld area

Remove paint, dust and contamination from the internal weld area before channeling and welding.



STEP 9 – Channel the inside

Create a channel along the crack before welding. Go slightly past the visible end of the crack because the split may continue internally.



STEP 10 – Clean the channel

Remove sanding dust, burr residue, paint particles and contamination before welding.



STEP 11 – Weld the inside first

Start before the crack and finish after it. Weld bottom-up or from inside-out where possible. The rod must fuse into the bumper plastic, not sit on top.



STEP 12 – Cool the weld

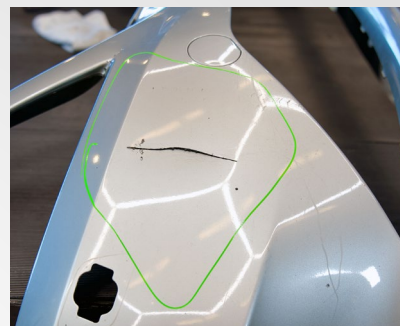
Use water to cool the weld back to room temperature

Extra, non-mandatory step: Decide whether to sand the inside weld

Clean the weld if thickness, clearance, or sensor/radar considerations require it.

If no clearance issue exists, the weld may remain for support.

Do not claim ADAS approval unless the repair process has been validated and certified.



STEP 13 – Turn bumper back over

Return to the front side and carefully remove the support tape.



STEP 14 – Inspect front alignment

Check that the split is closed, the surface is aligned, and there is no excessive lift or low area before front welding.



STEP 15 – Strip the paint

Remove paint from the front weld repair area before channeling. This is mandatory for welding. The front weld must fuse into clean plastic, not into paint.



STEP 16 – Mark the front crack

Mark the repair path before channeling.



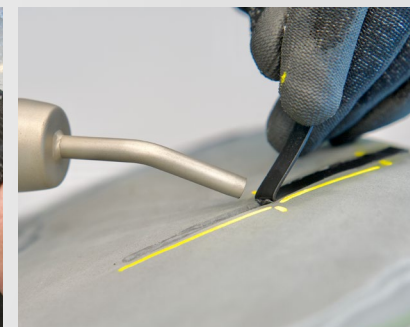
STEP 17 – Channel the front side

Create a controlled channel along the crack. Go slightly past the visible end of the split. If the crack changes direction sharply, prepare separate weld sections instead of bending the rod around the corner.



STEP 18 – Clean the front channel

Remove dust, paint residue, burr residue, and contamination before welding.



STEP 19 – Weld the front side

Start before the crack and finish after it. If the crack changes direction, use separate welds instead of forcing one rod around a tight angle.



STEP 20 – Cool the front weld

Use water to cool the weld before sanding. Do not sand while the weld is still too hot.



STEP 21 – Sand the weld

Use OSP 1 abrasive with 120 grit to Reduce and shape the weld carefully. Keep the sanding controlled and avoid overheating the plastic.



STEP 22 – Plastic Shaving File

Use the file lightly, as a guide, to reveal small highs and lows. The Plastic Shaving File is a quality-control tool, not a heavy material-removal tool.



STEP 23 – Refine after filing

Use 180 grit/OSP 2 to remove file marks and refine the repair.



STEP 24 – Finish plastic repair

The plastic repair process finishes at 240 grit if using Abranet. Any further sanding, such as 320, 400, or 500, belongs to the paint/prep-to-primer process. The process stops in OSP 2 in case of using OSP process.



STEP 25 – Final check

Confirm alignment, surface continuity, weld integration, thickness, and readiness for the next paint-preparation process.



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