



STEP 1 – Evaluate the damage

Confirm that the bumper is not cracked, split, broken, or structurally damaged. If the defect is too deep for sanding or Plastic Bond alone, proceed with welding.



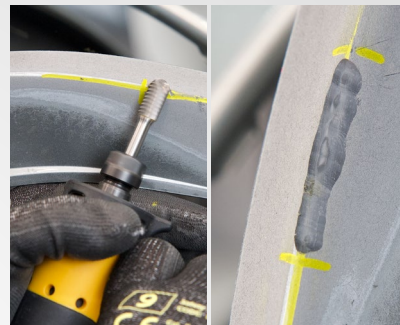
STEP 2 – Mark the repair area

Define the affected zone and protect nearby body lines, edges, contours, or textured areas.



STEP 3 – Sand damaged area

Use 120 grit / OSP 1 to remove paint, expose the plastic, and read the real depth of the defect. Stop sanding if continuing would flatten an edge, remove a style line, or distort the bumper contour.



STEP 4 – Channel the defect

Create a controlled channel along the deep scratch or gouge. Do not make the channel wider or deeper than necessary.



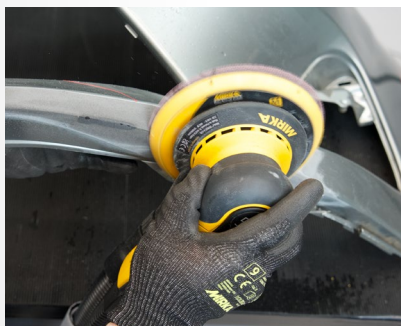
STEP 5 – Clean the channel

Remove dust, paint residue, loose plastic, and contamination before welding.



STEP 6 – Weld plastic into channel

Fill the channel with the correct welding rod. The goal is to rebuild the missing material with plastic, not with filler. Use water to cool the weld before sanding.



STEP 7 – Sand and shape

Use 120 grit / OSP 1 to reduce and shape the weld, then refine with 180 grit / OSP 2.



STEP 8 – Guide file if needed

Use the Plastic Shaving File lightly to check contours, edges, or body lines and reveal small highs or lows.



STEP 9 – Abranet: Finish to 240

Finish the plastic repair to 240 grit if using Abranet. Further sanding belongs to the paint/prep-to-primer process.

