Step-by-step working instructions

TEROSON® PU 9225 SF ME

Plastic Repair e.g.
Bumper repair, scratches, holes

1 CLEAN AND PRE-TREAT THE SURFACE

Remove all major dirt and rinse the plastic part with plenty of clear water. Clean and pre-treat the repair area using ***TEROSON® VR 10*** with lint-free cloth.

2 PRE-TREATMENT OF THE DAMAGED AREAS

For cracks drill out the hole at the ends. The hole diameter should be about 6mm to stop further cracking. Enlarge the crack to the minimum 2-3mm gap. In case of a hole go to step 3 directly.

3 CARVING

Grind a V-groove into the frontface edges of the repair area. The holes at each end should also be V-tapered with a grinder.

4 SANDING

Roughen surfaces on both faces with P150 grinding paper. Remove the grinding dirt. Don't forget to also sand the back of the damaged area. Clean and pre-treat both sides (front and back) with ***TEROSON® VR 10***.

5 PREPARE FIBRE MESH

Adjust the mesh to the desired size and cut a piece of fibre mesh larger than the damage. Make sure to cut-off the edges of the fibre mesh to prevent fraying.

6 PRIMER APPLICATION

Spray a thin coat of ***TEROSON® VR 155*** primer onto both sides (front and back). Flash off time is 5 min at room temperature.

7 PREPARATION OF THE CARTRIDGE

Open the cartridge and squeeze out a small amount of material until both adhesive components run equally. Apply the mixing nozzle and discard the first 5cm of the mixed adhesive.

8 APPLICATION BACK (1/2)

Apply ***TEROSON® PU 9225 SF ME*** to the back of the repair area. Position the fibre mesh over the damaged area and press it down into the adhesive with a spreader until the fibre mesh is saturated.

9 APPLICATION BACK (2/2)

Apply the adhesive on top of the fibre mesh and spread it to cover the repair area completely. Keep the nozzle inside the material to avoid air pockets.

10 TRACK-FREE TIME

No need to place the repair area under an infra-red lamp as the **TEROSON® PU 9225 SF ME** cures to tack free after 10min at room temperature.

11 APPLICATION FRONT

Apply **TEROSON® PU 9225 SF ME** to the front side, keeping the nozzle inside the material to avoid air pockets. Smooth down with a spreader, always from the centre of the damage outwards.

12 CURING

No need to place the repair area under an infra-red lamp as the **TEROSON® PU 9225 SF ME** cures to tack free in 10min at room temperature.

13 SANDING

Start grinding with P150 grit paper and progressively use finer sandpaper grits (to P360) to smooth the surface and clean with ***TEROSON® VR 10*** using a lint free cloth.

14 FINISH (1/2)

For optimal adhesion, apply a thin coat of ***TEROSON® VR 155*** primer. Allow 5 min flash-off time. During flash-off time, mix the plastic filler ***TEROSON® UP 250*** together with the hardener (ratio: ***UP 250*** gulf ball size, hardener pea-sized).

15 FINISH (2/2)

Apply the mixed body filler onto the prepared repair area and spread it evenly. The surface can be sanded with P240 to P400 after ~30mins to be ready for painting.

16 PAINTING

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

TEROSON® PU 9225 SF ME is a fast curing 2-component repair adhesive. Typical areas of application are repair work on paintable plastic parts in interior/exterior areas, especially repairs of minor damage such as scratches and holes in bumpers, spoilers, skirts, etc. low emission, therefore no R40 phrase labelling. The product can be cured at room temperature, with IR radiator at 60 °C, or flexitherm pads.

- **Recommended for repair areas smaller than 7 cm**
- **Excellent sandability**

Scan the QR code to see further product information, technical data sheets and safety data sheets.

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