



**Technical Service
BULLETIN**

June 4, 2002

Title:

**REFINISHING REPLACEMENT
BUMPER COVERS**

Models:

All '83 – '05 Models

REVISED

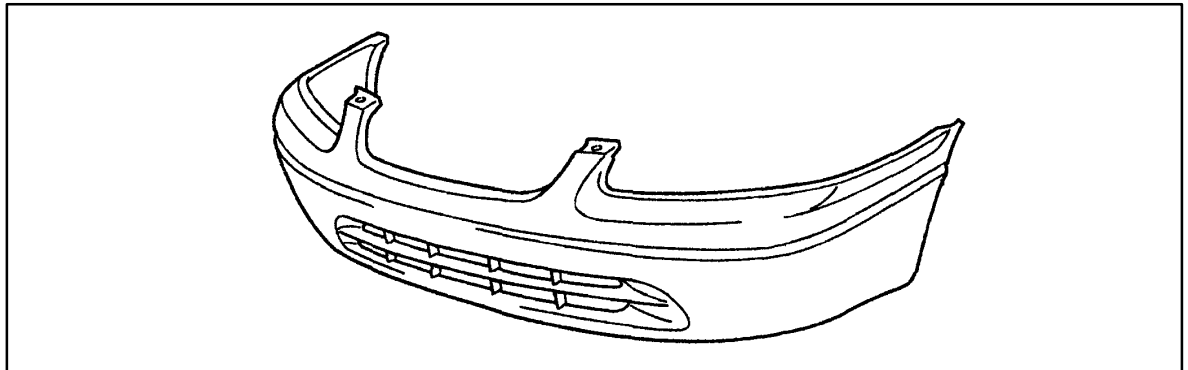
PAINT
PA003-02

TSB REVISION NOTICE:

- February 14, 2005: Applicable Vehicles now includes 2004 – 2005 model years. Previous versions of this TSB should be discarded.

Introduction

In cases where a bumper cover is being replaced, a special preparation process is necessary to assure the refinish is customer acceptable. This bulletin provides the recommended refinishing procedure for new bumper covers.



Applicable Vehicles

- All 1983 – 2005 model year Toyota vehicles.

Required Tools & Material

TOOLS & MATERIALS	RECOMMENDED PRODUCT	QUANTITY
Mild Soap — Ph neutral (no wax type)	3M™ Car Shampoo (or equivalent)	As Needed
Sanding Pad	3M™ ScotchBrite (Gray) 37448	
Sanding Paste	See Paint Manufacturer's Recommendations	
Wax, Grease, & Silicone Remover		
Plastic Part Adhesion Promoter		
Primer and Paint		

NOTE:

Please visit www.3m.com/automotive to find the nearest store that sells 3M automotive products.

Warranty Information

OP CODE	DESCRIPTION	TIME	OPN	T1	T2
N/A	Not Applicable to Warranty	–	–	–	–



Refinishing Procedure

1. Mix a solution of mild soap (car wash soap with no wax additives) and clean water.

NOTE:

Carefully follow mixing instructions on the soap container. Too much soap or too much water may cause surface contamination or rinsing difficulty.

2. **Scrub** the bumper covers with the soap and water solution, making sure all difficult-to-reach areas are thoroughly cleaned.
3. Rinse the entire bumper cover with clean deionized water, making sure all difficult-to-reach areas are thoroughly rinsed.
4. Dry the surface with a clean towel before water dries on the surface. Clean, dry compressed air from an oil-less compressor may be substituted for drying with a towel.
5. Degrease the surface with a wax, grease, and silicone remover.

NOTE:

Lacquer thinner or brake cleaner will NOT remove silicone. You MUST use a wax, grease, and silicone remover. Carefully follow application instructions on the container label. Fish eyes or other paint irregularities may result from not following instructions.

6. Apply a generous amount of sanding paste with a gray 3M™ ScotchBrite pad. Only a gray pad should be used during the sanding process. Sand the entire bumper cover surface. Be sure all difficult-to-reach areas are thoroughly sanded.
7. Clean the entire bumper cover with car wash soap and water. Be sure all difficult-to-reach areas are thoroughly cleaned.
8. Rinse the entire bumper with clean deionized water. Be sure all difficult-to-reach areas are thoroughly rinsed.
9. Degrease the surface with an anti-static plastic parts cleaner and a white body shop towel or paper towel.

NOTE:

Never use a red shop towel to wipe the surface (contains silicone).

10. Assure the bumper is firmly held in place to a steady fixture.
11. Apply a plastic parts adhesion promoter to the surface, according to the manufacturer's recommendations.
12. Apply plastic parts primer to the surface, according to the paint manufacturer's recommendations.
13. Since bumpers are made of flexible plastic urethane material, use a two-part urethane finish paint system with plasticizer (flex agent) for all bumper and cladding repairs. Apply the appropriate top coat to the surface, according to the paint manufacturer's recommendations.

Refinishing Procedure
(Continued)

14. If heat is applied to cure the paint, assure the surface temperature does not exceed 80°C (176°F.)

For additional information concerning the refinish process for plastic bumpers/cladding, please contact your respective refinish paint manufacturer’s local representative.

