1. Description

This procedure describes methods for the repair and replacement of a plastic bumper reinforcement. Inspection and evaluation requirements are also included.

2. Purpose

The purpose of this procedure is to provide industry-accepted requirements for performing high-quality repair of plastic bumper reinforcements. This procedure is intended for use by professionals who are qualified through training and experience.
3. Referenced Documents

The following documents are considered part of this procedure by reference.

3.1 Procedures
BU01S Bumper
BU02P Bumper Cover
BU21 Energy Absorber, Mechanical
BU22 Energy Absorber, Crushable
PR01 Plastic Repair, Welding
PR11 Plastic Repair, Adhesive
PS01 Personnel Safety
RF01P Surface Preparation
RF41 Finish Application

3.2 Other Information
Product-specific information
Recycled parts information
Vehicle-specific repair information

4. Equipment And Material Requirements

Does not apply.
5. Damage Analysis

5.1 General Damage

Inspect a plastic bumper reinforcement for these conditions:

- dents
- bows or buckles
- chips, gouges, or other surface damage that affect the function of the reinforcement
- damaged mounting tabs or brackets
- cracks
- damage to mounting fasteners
- stress cracks or marks
- separation of any bonded areas
- damaged finish

Repair or replace damaged bumper reinforcements, following the vehicle maker’s recommendations. Verify the availability of replacement parts.

6. Personnel Safety

6.1 General Safety

General safety information is in PS01.

7. Environmental Safety

Does not apply.

8. Vehicle Protection

8.1 Adjacent Areas

Protect adjacent areas when replacing a plastic bumper reinforcement.
9. Repair Procedure

9.1 Bumper Reinforcement Removal
To remove a plastic bumper reinforcement:

- 1. Loosen and remove the mounting fasteners. Discard any damaged fasteners.
- 2. Remove the bumper reinforcement.

9.2 Bumper Reinforcement Repair
To repair a plastic bumper reinforcement:

- 1. Make necessary repairs, following the vehicle maker’s recommendations. See 5.1.
- 2. Apply corrosion-resistant primer to all adjacent surfaces that have been damaged by the collision or repairs.
- 3. Refinish as required to restore appearance.

9.3 Bumper Reinforcement Installation
To install a plastic bumper reinforcement:

- 1. Align and hold the replacement reinforcement in position.
- 2. Install the fasteners holding the bumper reinforcement to the frame, energy absorbers, or brackets. If the fasteners are being replaced, use fasteners that are the same size, type, and strength as the original fasteners.
- 3. Adjust the reinforcement to obtain proper alignment with attached and adjacent parts. Follow the vehicle maker’s recommendations.
- 4. Torque all fasteners to the vehicle maker’s recommendations.
- 5. Continue vehicle reassembly.
10. Use Of Recycled [Salvage] Parts

10.1 Condition Of Salvage Parts
Do not install a salvage plastic bumper reinforcement having any of these defects:

- unrepairable damage
- improper previous repairs

10.2 Preparation Of Salvage Parts
To prepare a salvage plastic bumper reinforcement for installation:

- Make any necessary repairs.
- Clean the part to remove dirt, grease, etc.

11. Inspection And Testing

11.1 Inspection Of A Replaced Plastic Bumper Reinforcement
Inspect a plastic bumper reinforcement for these conditions:

- proper alignment with attached and adjacent parts
- proper installation of all trim and fasteners
- proper finish appearance and film thickness

Correct any defects.