

Bumper Pliers Kit

6146

Product Information and Instructions



Polyvance's 6146 Bumper Pliers Kit makes it easier for technicians to repair rectangular "slot tabs" and recessed holes often found on bumper covers. These bumper features are designed to clip into brackets on the quarter panels and hold the bumper tightly in place. The tabs are weak and often break when removing the bumper. The Bumper Pliers Kit helps technicians repair these problem areas.

Slot tabs can be repaired using the nitrogen plastic welder, but without the aid of the Bumper Pliers Kit, the job requires much more skill and finesse. Additionally, technicians often have difficulty restoring the correct dimensions of the slot, which is critical for proper panel installation.

Benefits:

- Quickly and accurately repairs torn slots and recessed bolt holes in automotive bumpers.
- Increases shop profits by speeding difficult repairs.
- Includes 6 different slot tab dies, one recessed hole die, and four sets of die pliers to repair virtually any slot.

KIT CONTENTS

| Qty: | Item: |
|------|-----------------------------------|
| 3 | Numbered (1-6) forming die pliers |
| 1 | Pin die pliers |
| 6 | Numbered slot forming dies |
| 1 | 3/16" Recessed hole pin die |
| 1 | Storage case |

Note that the numbered dies match the widths in the forks of the corresponding numbered pliers. The dies have the following widths:

| Die #: | width (mm) | Die #: | width (mm) |
|--------|------------|--------|------------|
| 1 | 10.5 | 4 | 16.3 |
| 2 | 12.7 | 5 | 18.5 |
| 3 | 14.9 | 6 | 20.3 |



Customer Support:
Toll Free: 800-633-3047
Phone: 256-638-4103
www.polyvance.com

Instructions:

1. Find Matching Die

Find the forming die which most closely matches the width of the broken rectangular slot tab. Select the matching numbered die and pick the pliers that match the forming die. Prepare the plastic for welding by cleaning with Polyvance Super Prep or EcoPrep and tapering each side with a grinder or sander.)

2. Tape Forming Die Into Position

Insert the selected forming die into the broken hole and line up the outer edges of the tab and slot. Tape into position with a piece of 6485 aluminum tape.

3. Weld

Use your preferred plastic welding rod and weld from one side to the other in a continuous pass, locking the plastic welding rod into the bumper on both sides. A second, or even third pass of welding rod is often needed to fill out the missing plastic.

4. Reheat

Immediately after welding, reheat the welding rod using hot nitrogen gas until it is translucent.

5. Flatten With Pliers

Immediately squeeze the melted plastic with the matching forming pliers. Apply gentle pressure and hold for about 10 seconds to cool plastic.

6. Remove Die, Shape as Needed

Allow the die to cool completely, then remove aluminum tape and push the die out of the hole. Shape the repaired area as needed with the airless plastic welder, utility knife, grinder, and/or sander until desired dimensions are restored.

See video of this process at www.polyvance.com or on our YouTube channel



Customer Support:
Toll Free: 800-633-3047
Phone: 256-638-4103
www.polyvance.com