

# BU11P—Reinforcement



## 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.