

## ***Sheet-Molded Composite (SMC) Panel Repair***

1. Cover the break in the Sheet-Molded Composite (SMC) (front and back) with masking tape. This protects the damaged area from absorbing the prep cleaner and eliminates wicking of the cleaner through the fibers into the Sheet-Molded Composite (SMC).
2. Remove all waxes, silicones, dirt and road oils from the area surrounding both sides of the damaged area with a plastics wax and grease remover.
3. Remove the tape and sand the back of the repair area with an angle grinder, Dual Action (D/A) sander or by hand using 80-grit sandpaper. Remove all dust with a vacuum and tack cloth.  
**Use** Special Service Tool: ALCV-200.
4. Create a reinforcing patch using a piece of scrap Sheet-Molded Composite (SMC) that conforms well to the back of the damaged area or form a patch from fiberglass cloth.
5. Cut a section of cloth large enough to cover the repair, plus around the repair area. Cut a section of plastic film backing approximately larger than the cloth. Lay the plastic on a smooth, flat surface where it will be used to create a pyramid patch.
6. Follow manufacturer's directions and apply adhesive to the plastic film backing and smooth with plastic spreader to recommended thickness. Place the pre-cut fiberglass cloth on the adhesive-coated plastic film. Cover the cloth with a coat of repair adhesive and spread to the recommended thickness.  
**Material:** Plastic Bonding Adhesive / TA-9
7. Apply the prepared patch to the backside of the panel and compress. Follow manufacturer's instructions for adhesive cure. Remove plastic film after adhesive cures and sand as necessary to remove roughness.
8. Remove masking tape from the front side of damaged area and grind down to the backing patch. Use an angle grinder with a 30 to 40-grit wheel. Make a gradual taper in the area, this will prevent bull's-eyes or read-through in the finished repair. Sand prepared area with a Dual Action (D/A) sander or hand-sand with 80-grit sandpaper.  
**Use** Special Service Tool: ALCV-200.
9. Build a pyramid patch using fiberglass cloth or equivalent and adhesive. Following manufacturer's directions, apply patch to damaged area.  
**Material:** Plastic Bonding Adhesive / TA-9
10. Rough-grind area to remove excess adhesive. Sand repair area with 80-grit sandpaper, making sure to cut slightly below the Sheet-Molded Composite (SMC) finished surface. This will allow for a finish coat of plastic repair filler material.
11. Apply a finish coat of plastic repair filler material per manufacturer's directions.
12. Finish-sand, prime and topcoat using Ford-approved paint systems.