



Automotive Specialty Chemicals

**CREST INDUSTRIES, INC.**  
1337 King Road, Trenton, Michigan 48183  
Phone 1-800-822-4100

## GENERAL INSTRUCTIONS

**Stock No. CE-CB, CODE BLUE**

**Work Time: 7 – 10 minutes**  
**Sand / Paint Time: 30 minutes**

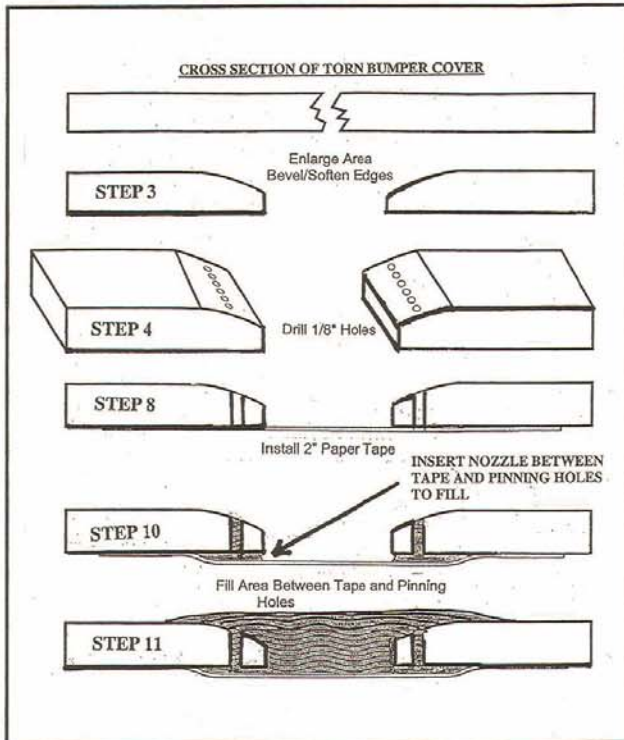
**Two-component, flexible, multi-task repair epoxy  
specially formulated for enhanced adhesion to problem plastics.  
For plastic bumper repair, general purpose repair and sealing.**

### Preparation of GF-21 Applicator Gun and Cartridge

1. GF-21 plunger rods should be fully retracted. To release rods, hold gun by back handle, press thumb lever and pull back on knob.
2. Prepare cartridge for loading by removing cover from nozzle side of cartridge and snapping off end cap.
3. Load cartridge into gun. Make sure tab at front of cartridge is properly inserted in slot at front of gun. Prior to attaching static mixer nozzle, dispense a small amount of product to be sure both sides flow evenly. To stop dispensing, release pressure by pressing thumb lever.
4. Install static mixer. Dispense a short bead until color is uniform. Dispose of this bead. Product is now ready for application.
5. When application is complete, leave mixer nozzle installed on cartridge and hang (nozzle-down) on Stock No. WAWR – Adhesive Wall Rack. Use a new nozzle for next application.
6. Never attempt to force material through a blocked cartridge opening or a used nozzle.

**STORE CARTRIDGES AT 65°F TO 95°F (18°C TO 35°C).  
SUBSTRATE TO BE REPAIRED SHOULD BE 70°F (21°C) OR ABOVE.**

**\* SEE REVERSE SIDE FOR DETAILED PLASTIC REPAIR PROCEDURE \***



### **CODE BLUE BUMPER REPAIR PROCEDURE**

1. Clean thoroughly with BCS – Car Wash Soap. After drying, clean with AS-X / BS-X Super Solv.
2. Restore shape and dry repair area with heat gun.
3. Using a 36 grit grinding disc or carbide cutting bit, enlarge area and bevel / soften edges to increase bonding surface area. Take care to avoid melting / smearing of plastic.
4. Drill 1/8" pinning holes 3/8" apart.
5. Scuff repair area and surrounding surface with 80 grit sandpaper.
6. Wipe or blow-off area.
7. Flame treat repair area with a propane or butane torch. Simply touch the area with flame tip – do not heat. AF-S Flex Stik may be used as a substitute or after flame treating.
8. Install 2" paper tape (RPT) on rear of repair.

9. Prepare Code Blue for dispensing per instructions.
10. Fill area between tape and pinning holes with Code Blue.
11. Continue to fill area until slightly overfilled to provide material for sanding.
12. After 30 minutes, sand to contour with 80 grit on DA sander. Finish sand with 150 or finer grit.
13. Prime with Prima Flex (APF, APFB) or Hi-Build (AHBG, AHBR) flexible primers.
14. Apply top coat per paint manufacturer's instructions or use Crest Flexible Bumper Coat (AF 1 – 18).

VISIT OUR WEB SITE: [WWW.CRESTAUTO.COM](http://WWW.CRESTAUTO.COM)

The Crest Pinning Process and Flaming Process were developed for  
automotive repair applications by Crest.  
COPYRIGHT © 10/95 CREST INDUSTRIES, INC.

### **TYPICAL PHYSICAL PROPERTIES**

Adheres to plastic, metal, aluminum,  
SMC and fiberglass.

Work Time: 7 – 10 minutes  
Sand / Paint Time: 30 minutes