



Repair Procedures for Pressure-Sensitive Trim Using 3M™ Automotive Attachment Tapes

Technical Update

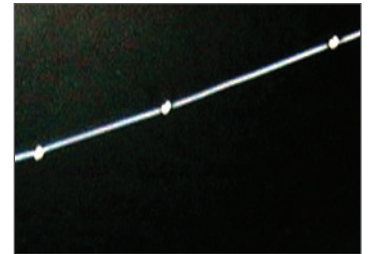
January 2006

Supersedes Technical Update dated December 2003

This technical update outlines the recommended procedures for repairing pressure-sensitive body side moldings (BSMs) and trim attached with both black 3M™ Automotive Acrylic Plus Tapes and gray 3M™ Automotive Acrylic Attachment Tapes. The following procedures offer specifics on removal and re-application of BSMs and trim.

Remove the Body Side Molding (BSM) or Trim from the Vehicle

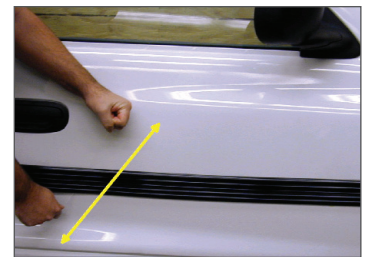
1. Use a piece of monofilament line and make several knots spaced about 1 inch apart.
2. Use the knotted monofilament to saw through the tape and remove the trim without damaging it or the vehicle surface. (Use of gloves recommended.)



Step 1

Remove the Tape/Residue from the Vehicle

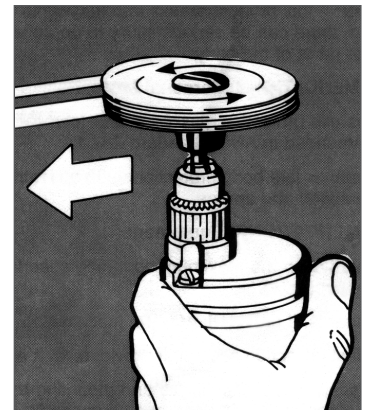
3. All tape/residue must be completely removed from the vehicle surface. Use a 3M™ Stripe-Off Wheel (Part Nos. 07498 or 07499, which are solid wheels) to remove the tape/residue without damaging the vehicle surface.
4. The following technique is necessary for the removal wheel to work with the black 3M™ Acrylic Plus Tapes: The wheel must rotate clockwise and be applied to the tape from right to left. Or, the wheel must be rotating into the tape to remove it without smearing.
5. After removal of the tape/residue with the wheel, use 3M™ Prep Solvent-70 (Part No. 08973) as a cleaning wipe. Then wipe with isopropyl (rubbing) alcohol and dry with a clean, lint-free cloth.



Step 2

Remove the Tape/Residue from the BSM/Trim

6. All tape/residue must also be removed from the BSM/trim.
7. This can be accomplished with the 3M Stripe-Off Wheel, using caution not to gouge the backside of BSM/trim.
9. Or, the BSM/trim can be placed in a suitable container and 3M™ Citrus Base Cleaner (3M ID No. 62-4615-4930-5) sprayed to saturate the tape on the part. Allow the BSM/trim to soak in the 3M Citrus Base Cleaner for 12-24 hours with the tape side down in the cleaner. Then use a plastic squeegee to remove the softened tape/residue.
9. Clean off any remaining residue with the 3M Citrus Base Cleaner by scrubbing with a cloth and wipe with isopropyl (rubbing) alcohol. Dry with a clean, lint-free cloth.
10. Other solvents, such as 3M™ General Purpose Adhesive Cleaner (Part No. 08984) or 3M Prep Solvent-70 (Part No. 08973) can be used to clean the tape/residue from the BSM/trim, but caution must be used to assure they do not attack or mar the parts.



Step 4

Apply Adhesion Promoter to BSM/Trim

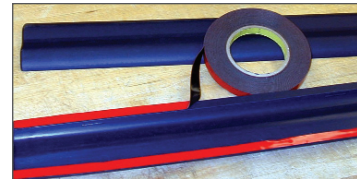
11. Prime the BSM/trim with 3M™ Automotive Adhesion Promoter (Part No. 06396) in the areas the tape will be applied.
12. Be careful not to drip or spill the primer on the BSM/trim face as it may craze or damage the finish.
13. The use of the 3M™ Automotive Adhesion Promoter (Part No. 06396) will assure an optimum bond due to the widespread use of low surface energy plastics by the automotive industry.



Step 11

Apply 3M™ Automotive Acrylic Plus Tape to BSM/Trim

14. Apply the 3M™ Automotive Attachment Tape to the BSM/trim, being careful not to entrap air between the part and tape.
15. Use a hard rubber roller or firm hand pressure to securely bond the tape to the BSM/trim.
16. Keep all contaminants (fingers, gloves, cloths, etc.) off the adhesive surface of the tape while applying it. Store the BSM/trim with the new tape applied in a clean area until it is re-applied to the vehicle.



Step 14

Re-Apply the BSM/Trim to the Vehicle

17. Apply BSM/trim to a clean, dry vehicle (as previously described).
18. Application temperatures below 60°F should be avoided. It is important that the vehicle not have any condensation on it (i.e., a cold vehicle moved into a warm shop). If necessary, warm the vehicle surface with a heat gun to obtain the recommended vehicle surface application temperature of 60°F to 110°F.
19. Apply BSM/trim with a rolling motion and with firm pressure to assure maximum tape contact with the vehicle, resulting in greater adhesion.
20. Use a hard rubber hand roller to roll the BSM/trim on the vehicle. Apply firm pressure while rolling to ensure complete adhesive wet-out and a good bond.
21. Check the edges of the BSM/trim to verify good tape adhesion. Re-roll the BSM/trim with more pressure if necessary.



Step 15

Important Precautions and Recommendations

- DO NOT...
- Touch or contaminate the exposed adhesive surface of the tape.
 - Let the tape sit around with the adhesive surface exposed.
 - Apply the new tape over the old tape or tape residue.
 - Use an adhesion promoter on the painted surface of the vehicle.
- DO...
- Use recommended 3M products for repair of all automotive BSMs and trim.
 - Read and follow safety precautions on the product label and MSDS for each product used in this procedure.

3M™ Automotive Adhesion Promoter 06396 is recommended for tape bonding to all plastic substrates. Please contact your 3M sales representative with application or performance questions.

Note: All statements, technical information and recommendations herein are based on tests 3M believes are reliable. 3M does not warrant or guarantee the accuracy or completeness of this information.

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