



Repair Procedures for Pressure-Sensitive Trim Using 3M™ Acrylic *Plus* Tapes – PT Series

Technical Update

February 2003

This technical update outlines the recommended procedures for repairing pressure-sensitive body side moldings (BSMs) and trim attached with new black 3M™ Acrylic *Plus* 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

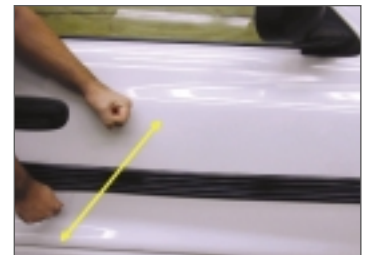
1. Use a piece of monofilament line and make several knots spaced about 1 inch apart.
2. Use the knotted monofilament to saw through the tape and remove the trim without damaging it or the vehicle surface.
3. Or, use the 3M™ Side Molding and Emblem Removal Tool (Part No. 08977), but vehicle surface might become scuffed.



Step 1

Remove the Tape/Residue from the Vehicle

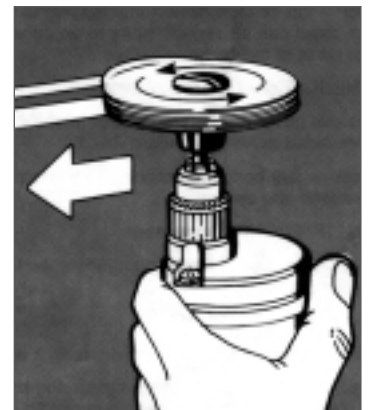
4. All tape/residue must be completely removed from the vehicle surface. Use a 3M™ Stripe-Off Wheel (Part Nos. 07498 or 07499, which are **solid** wheels) to remove the tape/residue without damaging the vehicle surface.
5. **The following technique is necessary for the removal wheel to work with the 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.***
6. 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

7. All tape/residue must also be removed from the BSM/trim.
8. 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 as needed for up to 24 hours with the tape side down in the cleaner. Then use a plastic squeegee to remove the softened tape/residue.
10. 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.
11. 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 5

Repair Procedures for Pressure-Sensitive Trim

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Apply Adhesion Promoter to BSM/Trim

12. Prime the BSM/trim with 3M™ Automotive Adhesion Promoter 4298 in the areas the tape will be applied.
13. Be careful not to drip or spill the primer on the BSM/trim face as it may craze or damage the finish.
14. The use of the 3M™ Automotive Adhesion Promoter 4298 will assure an optimum bond due to the widespread use of low surface energy plastics by the automotive industry.



Step 12

Apply 3M™ Acrylic Plus Tape to BSM/Trim

15. Apply the 3M™ Acrylic Plus Tape to the BSM/trim, being careful not to entrap air between the part and tape.
16. Use a hard rubber roller or firm hand pressure to securely bond the tape to the BSM/trim.
17. 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 15



Step 16

Re-Apply the BSM/Trim to the Vehicle

18. Apply BSM/trim to a clean, dry vehicle (as previously described).
19. 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.
20. Apply BSM/trim with a rolling motion and with firm pressure to assure maximum tape contact with the vehicle, resulting in greater adhesion.
21. 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.
22. Check the edges of the BSM/trim to verify good tape adhesion. Re-roll the BSM/trim with more pressure if necessary.

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.

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