

SP13-19A

SP13-19A DPF GRILLE GLUING
REFER TO SAP FOR CODES AND NOTIFIED VEHICLES
POUR LA VERSION FRANCAISE SE RÉFÉRER AU RETROFIT R13030

GRILLE FRAME GLUING VERIFICATION ON THE DPF DOOR. (LEFT SIDE, OVER THE RADIATOR DOOR)

PERFORM AN ADHESION TEST BY PUSHING IN THREE SELECTED ZONES BEHIND THE PANEL. (TOP, MID AND BOTTOM). PUSH FROM THE INSIDE OUT ON THE INSIDE OF POLYCARBONATE AIR GRILLE. APPLY PRESSURE WITH THE PALM OF YOUR HAND, ABOUT 30 LB. (DO NOT TEAR THE WHOLE THING APART!)

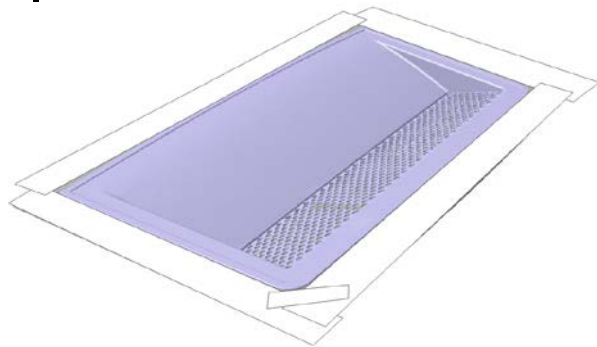
IF PART SHOWS NO SIGN OF SEPARATION OR UNGLUING, IT IS OK.

IF TESTING REVEALS POOR BONDING, REMOVE GRILLE, GLUE AND DOUBLE FACE TAPE.

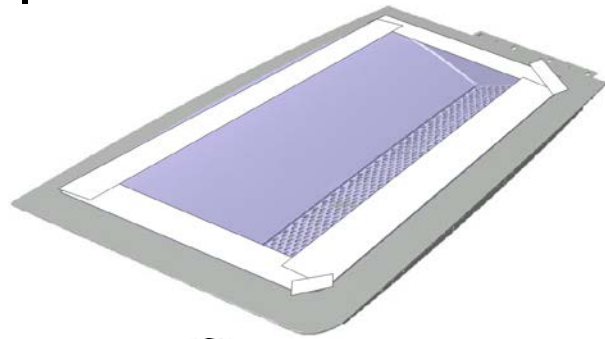
ALUMINIUM PART MUST BE SLIGHTLY SANDED TO REMOVE ANY REMAINING GLUE RESIDUE.

REMOVE DPF DOOR AND FOLLOW PROCEDURE BELOW TO GLUE GRILL FRAME BACK ON.

1. Before removal of the air grille, protect the surrounding painted area using masking tape. Place masking tape so it will help you, as a guide, to properly reposition the air grille at time of installation.



2. Using making tape, protect the painted surface of the air grille.

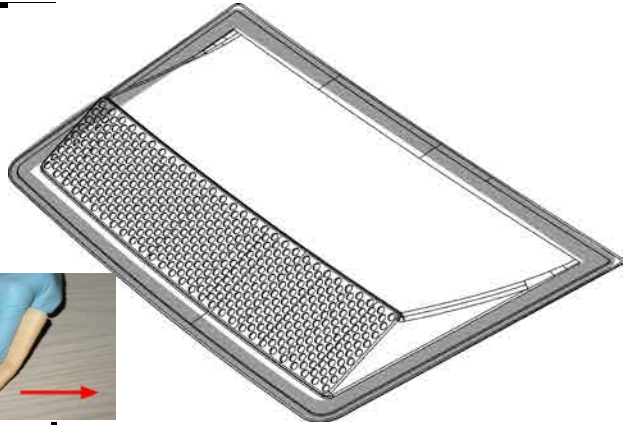


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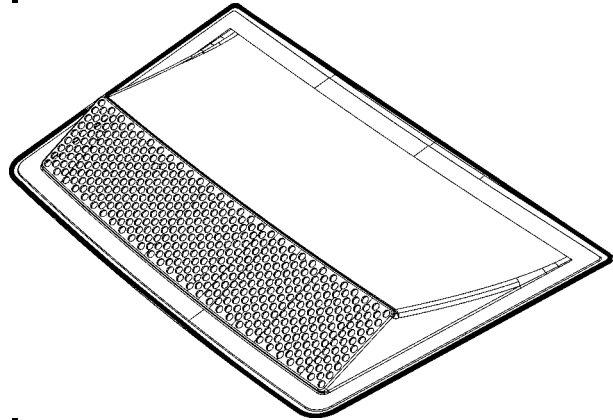
3. Carefully remove the air grille. Take care not to damage it as it will be reuse (suggested tools: air hammer chisel (zip), knife, wire saw).

4. Scrape old adhesive and remove all tape residue. For best results, prepare surface so the fiber glass will be exposed.

5. Clean off dirt, dust of grease from surface where adhesive will be applied using silicone remover (p/n 682989) or isopropyl alcohol. Do not clean with a back and forth movement. Allow enough time to dry.



6. Apply 1/8X1/4 double-face adhesive tape around the air grille at about 1/8 inch from the edge.



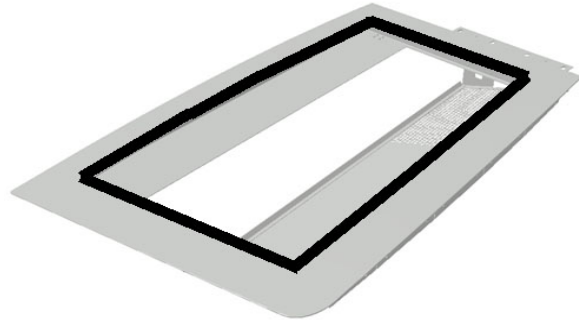
7. Remove all residue of old adhesive and tape on the door. Use sand paper if required.

8. Clean with silicone remover or isopropyl alcohol.

9. To assure best adhesion, rub door surface where adhesive will be applied using a gray Scotch-Brite pad (p/n 680226).

10. Clean with silicone remover or isopropyl alcohol once again

11. If the primer coat has peeled or chipped, apply Plexus PC120 (p/n 687955) primer locally.



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12. Use only methacrylate Plexus MA530 adhesive (p/n 687956). Plexus MA530 is a 1:1 ratio, i.e. one part of adhesive for one part of activator.

13. In order to assure proper adhesive curing, it is mandatory to use mixer nozzle #683919. **Do not use any other type of mixer.**

14. Apply adhesive bead at $\frac{1}{2}$ inch from the adhesive double face tape. The bead size must be about $\frac{1}{4}'' - \frac{5}{16}''$ (cut mixer nozzle at 2nd mark). Remove backing paper on double face tape.

15. Remove the double-face adhesive tape protective paper.

16. Place air grille on the door and press firmly. Allow at least one hour (1 hr) for curing time.

17. Reinstall DPF access door.

