



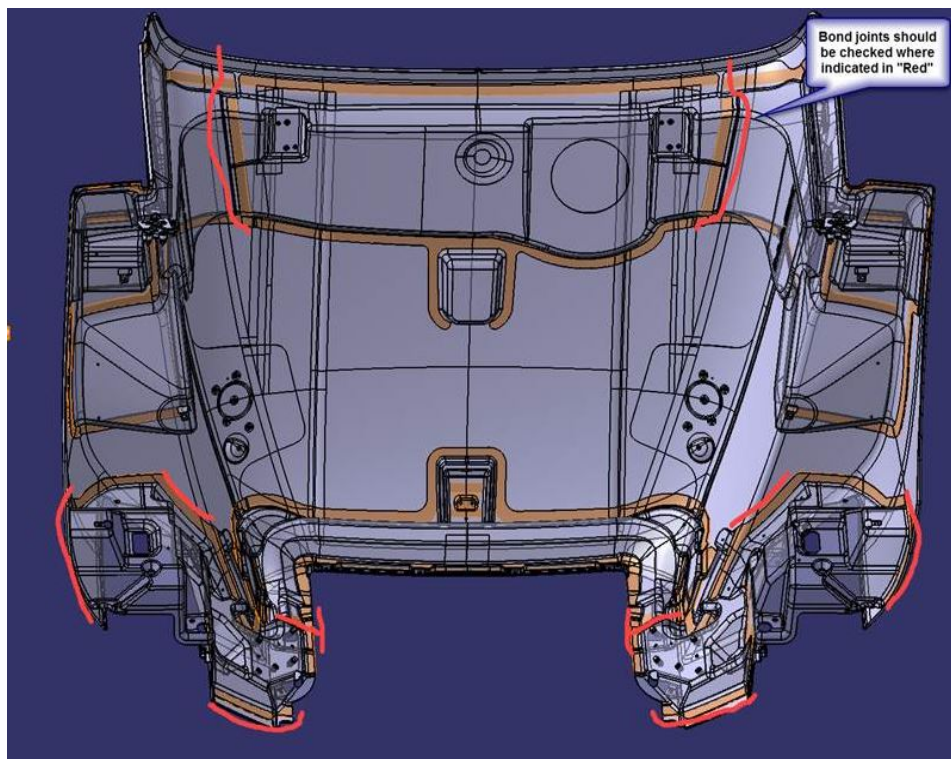
## Mack Chassis - Anthem ( AN ) - Hood Assembly; Crack Repair - US17+OBD16 and Newer Emissions



> Internal Content

This CBR solution will provide an overview of the procedures and processes for repairing and priming of Mack Anthem hoods.

**Note: Prior to any repair being made please inspect the integrity of the bonding joints in the key areas indicated with the orange lines.**



### Required Tools:


- Palm Sander
- Sand Paper ( 320, 180, 80 grit )
- Drill
- 1/8" Drill Bit
- Burr Bit
- Angle Grinder
- Scotch Brite
- Pressure Gauge
- **U-POL** Fibral Repair Paste ( from Finish Masters )
- Metal Glaze

Live UI fiberglass Mesh



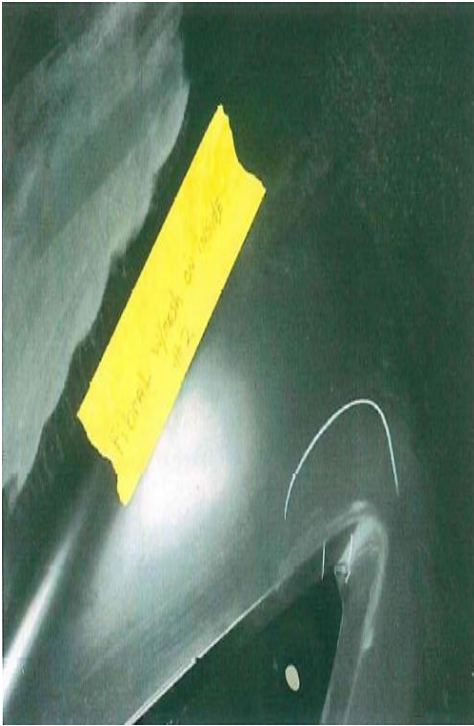
### Instructions:

1. Place the hood into a well lit work area.
2. Blow off dust from both side A and B of the hood and clean with IPA cleaner using clean rags or lint free paper towels to remove any dirt or foreign objects.
3. Using approved calibrated force gauge, check around headlight area with 45 pounds of force to insure no cracks appear. Reference pictures below for exact locations to apply force.
4. If cracks appear, mark area to be repaired.
5. Inspect hood for any defects such as cracks, pinholes, gouges and peeling, mark all areas.
6. All pinholes and gouges should be sanded using palm sander with 320 grit paper and repaired with Metal Glaze filler if needed.
7. When repairing a cracked area using an angle grinder, grind out around crack 1-1/4 inch on outside (A side) and inside (B side) of repaired area
8. Using Burr- Bit, burr out the crack front and back and blow off any dust left behind. Drill a 1/8" hole at the end of the crack ensuring that the end of the crack is within the hole.

 Live UI : off dust from both A and B side of hood and clean with IP A cleaner and clean rags or lint free paper towels to remove any dirt or

foreign object.

- 10.** For inside areas, mix appropriate amount of Fibril, fiberglass mesh and place on tape to be applied to area and let cure.
- 11.** For outside areas of panel, mix appropriate amount of Fibril and apply using approved spreader to an even amount and let cure.
- 12.** Using a Palm Sander with 80 grit paper, sand areas even and blow off remaining dust.
- 13.** For hard to get areas (inside headlight) use 80 grit and hand sand to an even finish and blow away any remaining dust.
- 14.** Blow off dust from surface and clean with IP A cleaner and clean rags or lint free paper towels to remove any dirt or foreign object.
- 15.** Mix appropriate amount of Metal Glaze on mixing board and apply to areas that have been repaired and let cure.
- 16.** Using palm sander with 180 grit paper, sand area to contour for final finish and blow off any remaining dust.
- 17.** Scuff areas by hand using 320 grit paper that have been repaired and blow off any remaining dust.
- 18.** Clean hood with IPA with a clean rag or towel then use approved tack cloth for area to be primed.
- 19.** Mix approved primer and apply to areas that have been repaired and let cure for 12 hours.
- 20.** Using approved calibrated force gauge, check around headlight area with 45 pounds of force to insure no cracks re-appear. Reference pictures below for exact locations to apply force. If cracks reappear, scrap the hood assembly.
- 21.** Write an "R" to the left side of sequence label with black sharpie marker. This signifies the hood has been repaired.



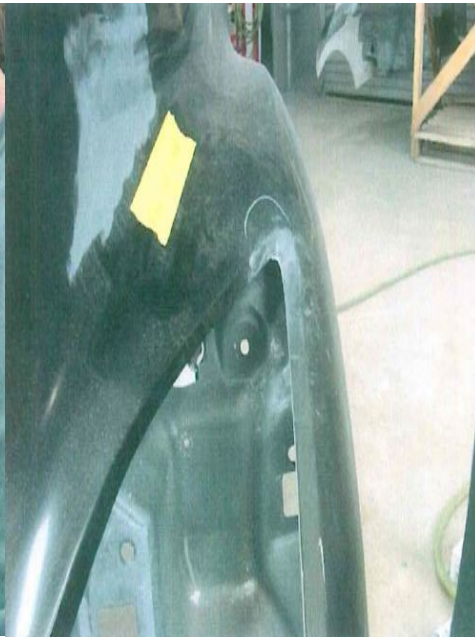
Identify crack



Identify crack



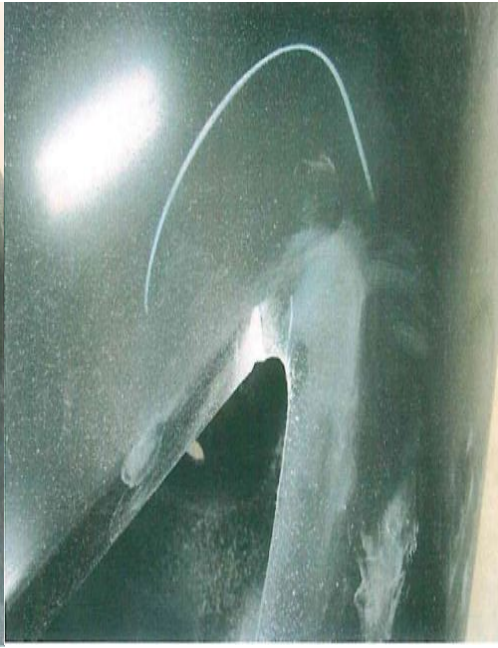
Sand crack area with 80 grit



Sanded crack area with 80 grit



Grind crack with deburring tool



Deburring crack



Drill hole at end of crack



Grind area around crack with 24 grit disc



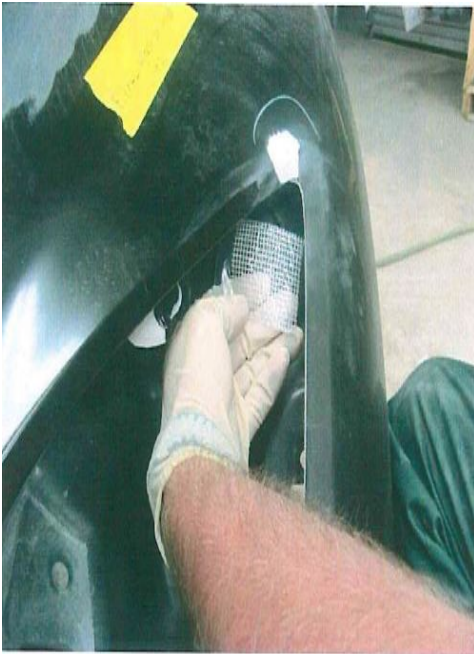
Grind the topside at least 1 inch by 2 inches  
( depending on the crack size )

Grind the underside of the crack



Measure the crack

Measure the crack



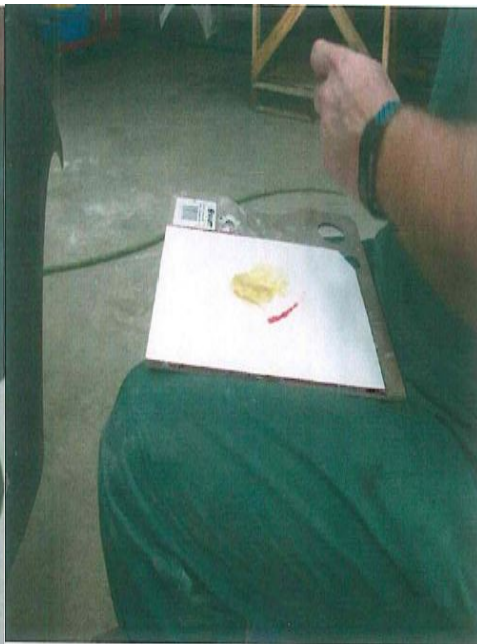
Cut the mesh to cover the inside surface around the crack



Measured tape



Measured tape



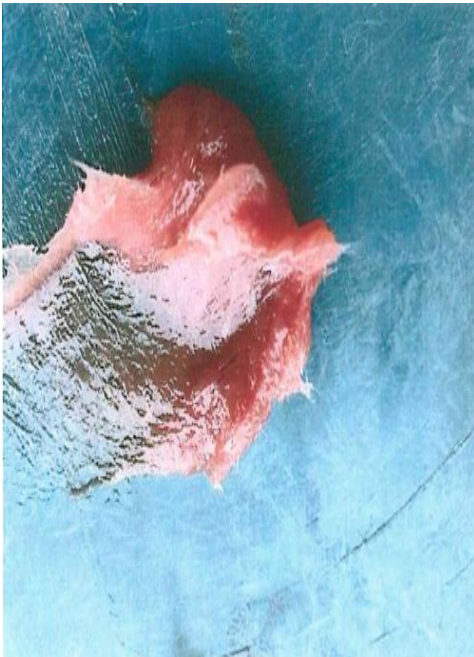
Dispense Fibral components



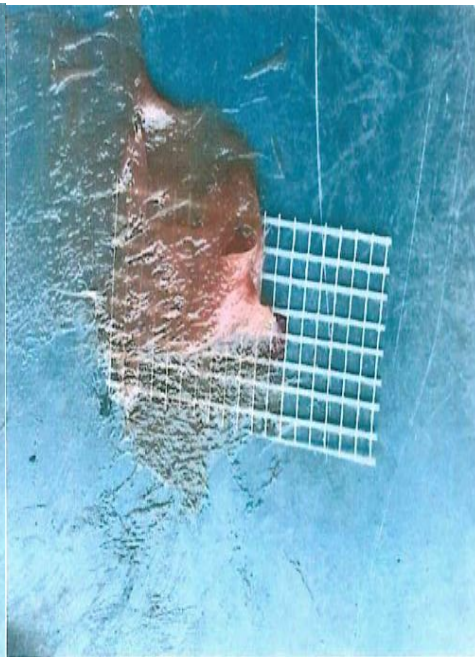
Mix Fibral components



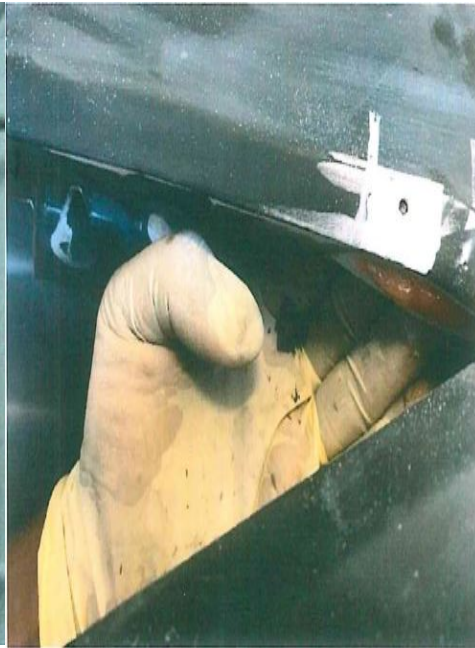
Appearance of incorrect Fibral mix



Appearance of correct Fibral mix

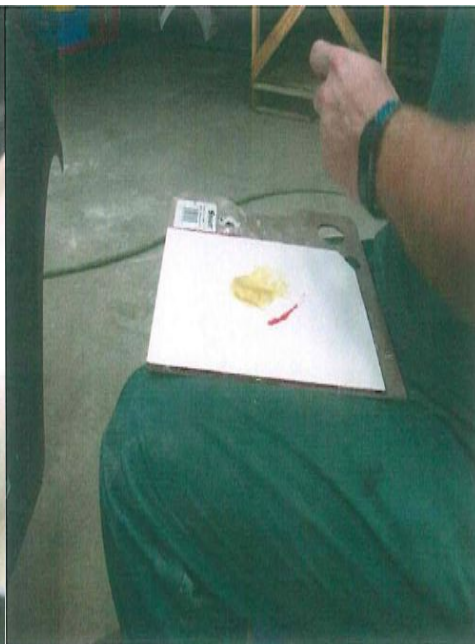


Apply Fibral mix to mesh tape



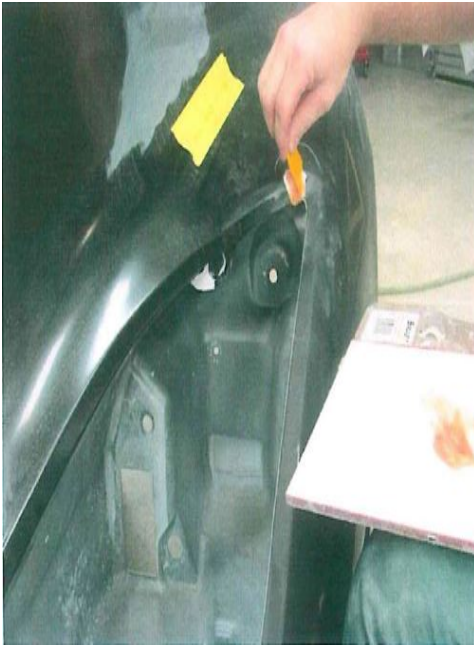
Put tape upside down and layer Fibral and mesh on sticky side of tape so it will stick to under side of hood

Apply Fibral to crack area and remove tape when it sets up



Fibral applied

Dispense Fibral components and mix



Apply Fibril to the grinded area on the top side



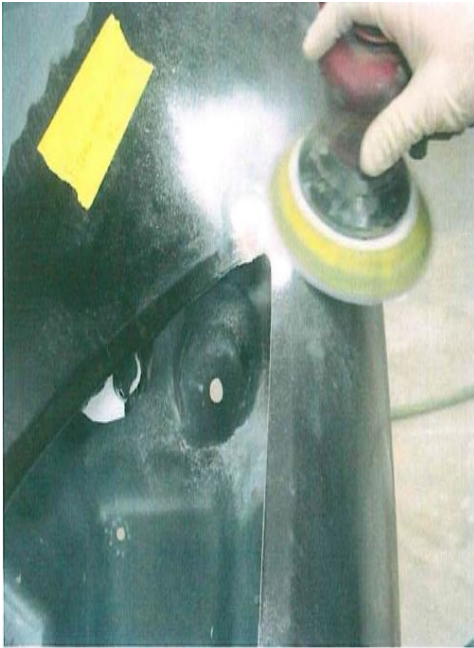
Fibril Applied



Fibril Applied



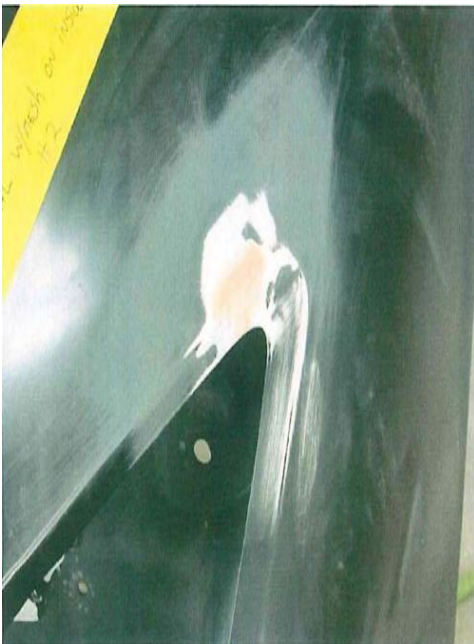
Fibril Applied



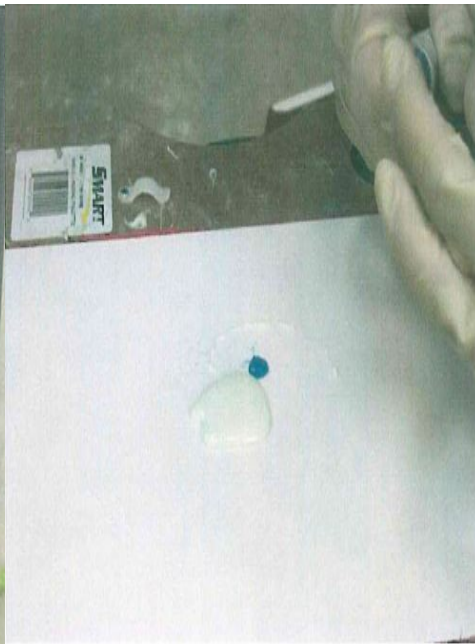
Sand the Fibril with 80 grit sand paper



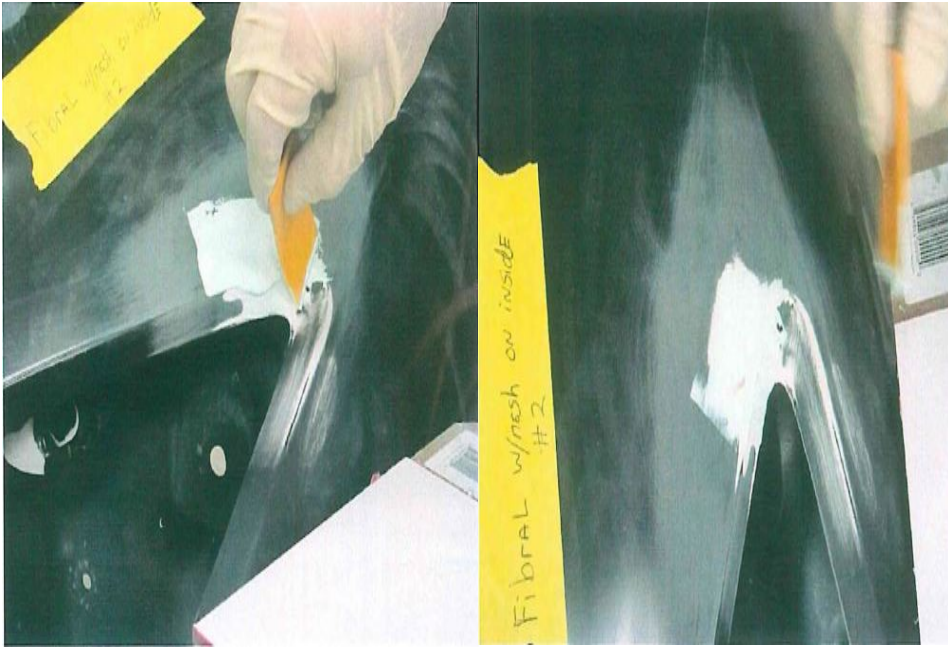
Sanded surface



Blow the surface off with air



Mix the metal glaze to finish the repair



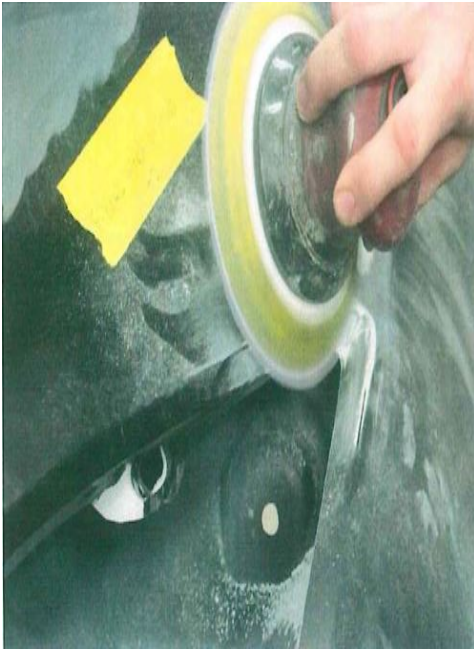
Apply metal glaze to grinded area on top side

Metal glaze applied



Sand metal glaze with 180 grit sand paper

Blow surface off with air



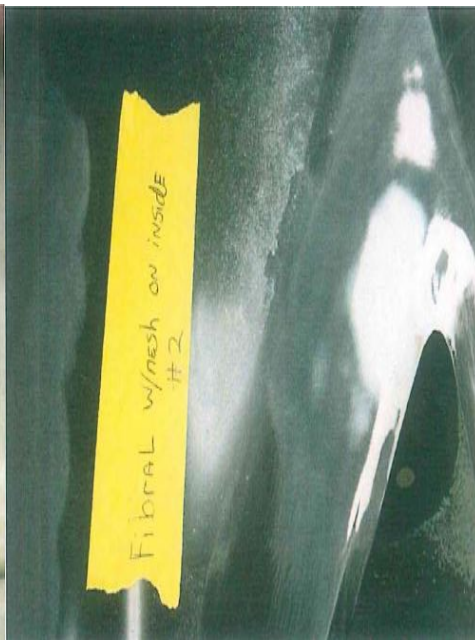
Sand metal glaze with 180 grit sand paper



Scuff with 320 grit sand paper



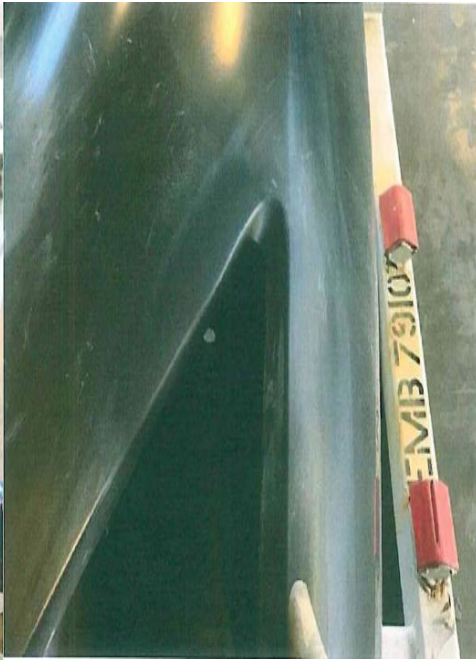
Scuff with 320 grit sand paper



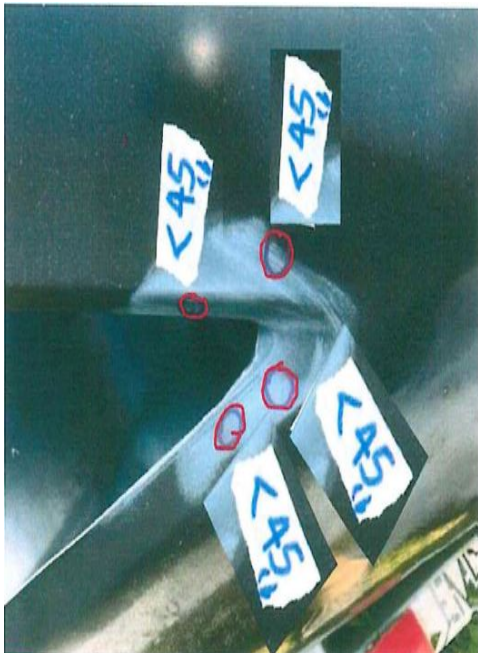
Blow surface off with air



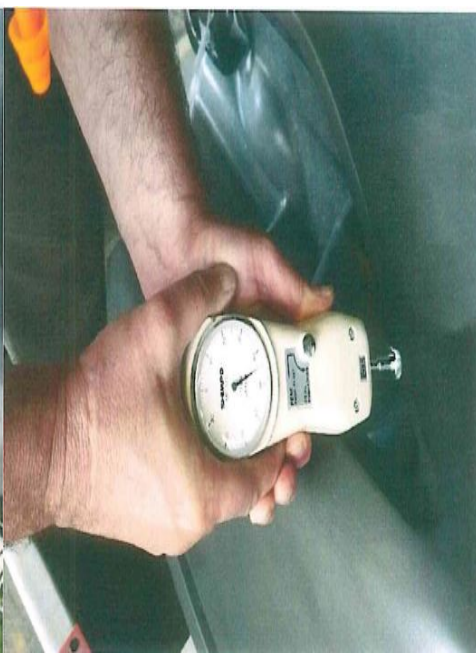
Spray primer on repaired area



Finished surface



Apply force to above locations



Using force gauge



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