

Instructions for Use of Overlap Seam Repair Kit:

3M has assembled a field repair kit to adhesively re-attach delaminated overlap seams on trailers or truck body sidewalls. If the overlap seams were previously attached with 3M™ VHB™ Tapes, there is no need to remove the tape residue. For repair, the temperature of the trailer and all components must be at least 60°F (15°C).



1. Approximate the center of the delamination. Place a mark at the same height as the center of the delamination, on the post directly behind and the post directly forward from the overlap seam
2. Clean both sides of the delaminated overlap seam and clean a 1" x 3" area around the marked spots. Use 50/50 isopropyl alcohol/water, wipe and let it dry. There is no need to remove the 3M™ VHB™ Tape residue.
3. Clean base of acrylic "L" bracket with 50/50 isopropyl alcohol/water; wipe lightly and let it dry.
4. Take 3M™ Command™ Adhesive Strips out of the package. Remove the red printed Command™ adhesive liner, apply to the back of "L" shaped bracket, and press firmly.



5. Remove the black printed liner, position bracket on the forward post, 1" x 3" area and press firmly for 30 seconds. Base of bracket should be facing repair seam. Repeat bracket attachment for rear post.



6. Place masking tape on left and right side of delamination to protect panels from adhesive overflow.

7. Place Duo-pak adhesive cartridge 3M™ Scotch-Weld™ Adhesive DP-810NS into 3M™ Scotch-Weld™ EPX Plus II applicator (see instructions in box for the EPX applicator operation).
8. Remove cap from adhesive. Dispense and discard a small amount of adhesive to ensure even mixing of the two part adhesive, and free flow.
9. Attach mixing nozzle.
10. Attach curved Centex tip to the end of the mixing nozzle. Dispense and discard a small amount of adhesive to ensure even mixing of the two part adhesive and free flow.



11. Apply a 1/8" to 1/4" bead of adhesive to one surface of the delaminated overlap seam.
12. Within 5 minutes, close seam.
 - a. Slide the cross tube into openings in the "L" bracket.
 - b. Pass screw through center hole of the cross tube (screw may already be in place) and into the threaded nut bar.



- c. Bring 1" x 1" x 12" PVC bar in contact with the overlap seam by turning the screw through the center of the cross tube, with the end of the screw contacting the matching hole on the bar. Turn the screw to close the seam.
 - i. If the delamination is toward the vertical middle of the trailer, use the center hole on the PVC bar.
 - ii. If the delamination is within 3 inches of the top or bottom of the trailer, then use one of the end holes on the bar.



13. Turn the screw to increase pressure until the overlap seam is totally flat.
14. After 5 minutes, wipe off adhesive that squeezed out of repair seam, using a paper towel or rag.



15. Remove masking tape on right panel of repair seam.
16. Allow 3M™ Scotch-Weld™ Adhesive DP-810NS to cure for one hour.
17. Release pressure on the seam by turning the screw in the counter clockwise direction.
18. Slide the ends of the cross tube from the “L” brackets.



19. To remove the “L” brackets, place one hand on the bracket and with the other hand, slowly pull and stretch the tab on the 3M™ Command™ Adhesive Strip, flat down the surface of the trailer, until the “L” bracket is released.
20. Remove the masking tape from the trailer.

Parts List

The following parts can be ordered separately:

3M™ Scotch-Weld™ Low Odor Acrylic Adhesive DP-810NS (12 duo pack per case) (sku: 62-2799-1435-2/ UPC: 00-021200-49082-8)

Scotch® Performance Masking Tape 233+ (24 per case/ 36mm x 55m) (sku: 60-9801-0930-4/ UPC: 0-00-51131-46338-7)

3M™ Command™ Mounting Strips (36 packs/case) (sku: 70-0713-0444-1/ UPC: 00-051131-85126-9)

3M™ Scotch-Weld™ Mixing Nozzle – Square Gold 5.3mm (12/bag; 6 bags/case) (sku: 62-9171-9153-8-1/ UPC: 00-021200-50008-4)

3M™ Scotch-Weld™ EPX™ Plus II applicator W 2:1 and 1:1 Plunger model 9170 (10 applicators/case) (sku: 62-9170-9930-1/ UPC: 00-021200-50004-6)

The following are only available with the complete kit:

- Repair Kit L-Brackets (2)
- Repair Kit Center Piece
- Repair Kit Screw
- Repair Kit Screw Cross Piece
- Repair Kit PVC Pressure Bar
- Centex Nozzle Tip

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