



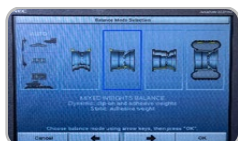
3M™ Wheel Weight System

Standard Operating Procedures for Balancing Wheels

General Description

This document provides standard procedures for balancing wheels using 3M™ Wheel Weights PN55409, PN55428, PN61403, PN61405 and PN99473 and 3M™ Mechanical Replacement Weight PN99427, as a part of the 3M™ Wheel Weight System. These cut-to-weight, wheel balancing weights allow the user to adjust the increment of material used to 1 gram, allowing for more precise balancing and a reduction of static and residual ride imbalance. The same process is used for both 3M Wheel Weights and 3M Mechanical Replacement Weights, with the exception of the placement of the weight on the wheel. 3M Wheel Weights are applied on the inside of the rim offering less noticeable wheel balancing, 3M Mechanical Replacement Weights are applied on the flange.

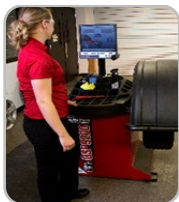
Balancing Wheels Using 3M™ Wheel Weights



1. Select Balancer Setting
 - Select clip/clip or clip/tape setting



2. Measure Width of Wheel
 - Place wheel on balancer
 - Use measuring arm on balancer to measure the wheel width.
 - Input measurement into balancer



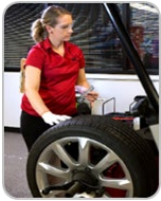
3. Balance the Wheel
 - Lower the hood of the balancer
 - After spinning, the balancer displays the out-of-balance weight and location on the inner and outer portions of the wheel



4. Clean the Wheel Rim
 - Clean the area of the wheel where the 3M™ Wheel Weight will be applied using 3M™ Wheel Weight Surface Prep 2000 or another comparable cleaner
 - Spray the surface of the wheel and wait for a moment while the cleaner penetrates and loosens the grease or dirt
 - Wipe away the residue with a clean cloth



5. Cut the 3M Wheel Weight Material to the Needed Weight
 - Pull the 3M Wheel Weight material through the 3M™ Universal Cutting Tool
 - Using the measuring scale (either gram or ounce), cut to the desired weight



6. Center the 3M Wheel Weight Material to the Correct Position
 - Pre-bend the 3M Wheel Weight
 - Remove the liner from the cut 3M Wheel Weight material, being careful not to touch or contaminate the adhesive



7. Apply the 3M Wheel Weight
 - Bend the part slightly to fit curvature of rim. Apply middle of part to centerline, right against the flange, while keeping ends from making contact
 - Pressurize from the center of the part towards both ends

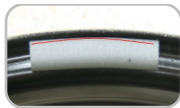


8. Apply Pressure to the Wheel Weight Material
 - Using your fingers or a roller, apply pressure firmly and smoothly along the length of the weight

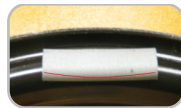


9. Recheck the Balance of the Tire
 - Spin the tire to check for balance
 - A zero on the balancer means the wheel balancing process is complete

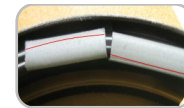
Determining Good versus Bad Part to Flange Matched for 3M™ Mechanical Replacement Weights



GOOD – The curved part matches the flange and is applied tightly against it.



BAD – The part is bridged across the flange.



BAD – The part is applied with the notch away from flange (upside down).

Contact Information

The information provided in this technical document is intended as a guide for these products. For more information or help in selecting a 3M product for an application, please contact your 3M technical service representative or call 1-800-328-1684.

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Automotive and Aerospace Solutions Division

3M Center
St. Paul, MN 55144-1000
Phone 1-800-328-1684
Web www.3M.com/autosolutions

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