**3M Automotive Attachment Tapes**

**Suggested Repair Procedure**

1. **Remove the Body Side Molding (BSM) or Trim from the Vehicle**
   - Use the 3M™ Side Molding and Emblem Removal Tool (Part No. 08977) to remove the BSM or trim from the vehicle.

2. **Remove the Tape/Residue from the Vehicle**
   - Use the 3M™ Stripe-Off Wheel (Part Nos. 07498 or 07499) and isopropyl alcohol wipe to remove any remaining tape or residue from the vehicle surface.

3. **Remove the Tape/Residue from the BSM/Trim**
   - Use the 3M™ File Belt Sander (Part No. 28366) or 3M™ Scotch Brite Durable Flex Belt (Part No. 64467) to remove any remaining tape or residue from the BSM or trim. Use caution to avoid damaging the vehicle surface.

4. **Apply Adhesion Promoter to BSM/Trim**
   - Prime the BSM or trim with 3M™ Automotive Adhesion Promoter (Part No. 06396) to create a clean, smooth surface for the new tape to adhere to.

5. **Apply 3M Acrylic Tape to BSM/Trim**
   - Apply the 3M™ Acrylic Tape to the BSM or trim, ensuring complete coverage and secure adhesion.

6. **Re-Apply the BSM/Trim to the Vehicle**
   - Apply firm pressure while rolling the BSM or trim onto the vehicle surface to ensure complete adhesion.

**Important Precautions and Recommendations**

- **DO NOT** touch or contaminate the exposed adhesive surface of the tape.
- **DO NOT** let the tape sit around with the adhesive surface exposed.
- **DO NOT** apply the new tape over the old tape or tape residue.

**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.

**Technical Information**

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Many factors beyond 3M’s control and uniquely within user’s knowledge and control can affect the use and performance of a 3M product in a particular application. As a result, customers are responsible for evaluating the product and determining whether it is appropriate and suitable for their application, including conducting a workplace hazard assessment and reviewing all applicable regulations and standards (e.g., OSHA, ANSI, etc.). Failure to properly evaluate, select, and use a 3M product and appropriate safety products, or to meet all applicable safety regulations, may result in injury, sickness, death, and/or harm to property.

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3M™ Automotive Attachment Tapes

Suggested Repair Procedure

1. Remove the Body Side Molding (BSM) or Trim from the Vehicle

   3M™ Side Molding and Emblem Removal Tool (Part No. 08977)

2. Remove the Tape/Residue from the Vehicle

   3M™ Stripe-Off Wheel (Part Nos. 07498 or 07499), 3M™ Prep Solvent-70 (Part No. 08973) and isopropyl alcohol wipe

3. Remove the Tape/Residue from the BSM/Trim

   3M™ Stripe-Off Wheel or 3M™ File Belt Sander (Part No. 28366) with 3M™ Scotch Brite Durable Flex Belt (Part No. 64467), and apply tape to remove the residue of the BSM/Trim.

4. Apply Adhesion Promoter to BSM/Trim

   Prime the BSM/Trim with 3M™ Automotive Adhesion Promoter (Part No. 06396), or the areas to be removed with the 3M™ Automotive Adhesion Promoter (Part No. 06395).

5. Apply 3M™ Acrylic Tape to BSM/Trim

   Use a hard rubber roller or firm hand pressure to securely bond the tape to the BSM/Trim.

6. Re-Apply the BSM/Trim to the Vehicle

   Application temperature below 60°F should be avoided. If necessary, warm the vehicle surface with a heat gun to obtain the recommended vehicle surface application temperature of 60°F to 110°F.

   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.

Important Precautions and Recommendations

DO NOT touch or contaminate the exposed adhesive surface of the tape.

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DO NOT apply the new tape over the old tape or tape residue.

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A Tape for Every Application

We offer three levels of performance to cover your application needs.

Product Packaging Examples

<table>
<thead>
<tr>
<th>Product/Part Number</th>
<th>Automotive Attachment Tape 06377</th>
<th>Automotive Acrylic Plus Attachment Tape 06398</th>
<th>Automotive Acrylic Plus Attachment Tape 06397</th>
</tr>
</thead>
<tbody>
<tr>
<td>Color</td>
<td>Black</td>
<td>Black</td>
<td>Black</td>
</tr>
<tr>
<td>Thickness</td>
<td>0.063” / 1.6 mm</td>
<td>0.063” / 1.6 mm</td>
<td>N.A.</td>
</tr>
<tr>
<td>Use</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
</tr>
</tbody>
</table>

Overall Performance

Good Performance PSA suitable for industrial part systems

Better Highest performing PSA available with high strength and low noise

Best For Bonding of automotive trim components in low noise applications

Application Lightweight moldings and attachments part to part water in adhesive promoter may be used

Why Tape? Why 3M Tape?

Continuous seal with no gaps, no water or dust intrusion and maintained noise

Why 3M Tape?

JM-G®-year history of proven attachment solutions to the automotive industry

Why Tape? Why 3M Tape?

Unmatched technical support and application testing

Why 3M Tape?

No need from drilling into steel metal and from screws, nuts or clips

Why Tape? Why 3M Tape?

Industry leading reinforcement in R&D

Why 3M Tape?

No need for high density labels and digital labels

Why Tape? Why 3M Tape?

Reduces labor time and tooling costs for some applications

Why 3M Tape?

Extensive 3M product testing andquilting facilities for assisted confections

Why Tape? Why 3M Tape?

Aesthetically pleasing, low profile CPE appearance for installed parts

Why 3M Tape?

Adhesives & technologies meet exacting demands of OEM paint systems and automotive substrates

Why Tape? Why 3M Tape?

Product/Part Number

<table>
<thead>
<tr>
<th>06382</th>
<th>Tape Attachable Part</th>
<th>GOOD</th>
<th>BETTER</th>
<th>BEST</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.50 in x 20 yd (12.7 mm x 18.2 m)</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
<td></td>
</tr>
<tr>
<td>0.25 in x 20 yd (6.4 mm x 18.2 m)</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
<td></td>
</tr>
</tbody>
</table>

3M Automotive Attachment Tape Selection Guide

A complete list of our attachment tapes to meet your specific needs

<table>
<thead>
<tr>
<th>Product Code</th>
<th>Color</th>
<th>Size</th>
<th>Tape Thickness</th>
<th>Applications</th>
<th>Overall Performance</th>
</tr>
</thead>
<tbody>
<tr>
<td>06377</td>
<td>Gray</td>
<td>0.25 in x 20 yd (6.4 mm x 18.2 m)</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
</tr>
<tr>
<td>06373</td>
<td>White</td>
<td>0.50 in x 20 yd (12.7 mm x 18.2 m)</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
</tr>
<tr>
<td>06370</td>
<td>White</td>
<td>0.50 in x 20 yd (12.7 mm x 18.2 m)</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
</tr>
<tr>
<td>06381</td>
<td>Gray</td>
<td>0.50 in x 10 yd (12.7 mm x 9.1 m)</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
</tr>
</tbody>
</table>

3M™ Automotive Adhesion Promoter Applicator Packet

<table>
<thead>
<tr>
<th>Product Code</th>
<th>Color</th>
<th>Size</th>
<th>Tape Thickness</th>
<th>Applications</th>
<th>Overall Performance</th>
</tr>
</thead>
<tbody>
<tr>
<td>06385</td>
<td>N/A</td>
<td>2.5 cc per packet/carton of 25</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
</tr>
</tbody>
</table>

3M es una marca registrada de 3M Company.
Complete all of your repairs to match OEM design intent.

We offer three levels of performance to cover your application needs.

<table>
<thead>
<tr>
<th>Product/Part Number</th>
<th>Size</th>
<th>Overall Performance</th>
</tr>
</thead>
<tbody>
<tr>
<td>Automotive Attachment Tape 06396</td>
<td>0.50 in x 20 yd (12.7 mm x 18.2 m)</td>
<td>Best</td>
</tr>
<tr>
<td>Automotive Acrylic Plus Attachment Tape 06386</td>
<td>0.50 in x 20 yd (12.7 mm x 18.2 m)</td>
<td>BETTER</td>
</tr>
<tr>
<td>Automotive Acrylic Plus Automotive Attachment Tape 06377</td>
<td>0.50 in x 20 yd (12.7 mm x 18.2 m)</td>
<td>GOOD</td>
</tr>
</tbody>
</table>

Our products are designed to provide the highest performance for your automotive applications.

**Why 3M™?**

**Continuous seal with no gaps, no water or duct intrusion and reduced noise.**

**Why 3M™?**

- 3M™-based history of proven attachment solutions to the automotive industry.
- Unmatched technical support and application testing.
- No rust from drilling into sheet metal and from screws, rivets or nuts.
- Industry-leading re-investment in R&D.
- No messy tapes/adhesives.
- Hands-on sales support and service.
- Reduces labor time and tooling costs for some applications.
- Extensive 3M product testing and weathering facilities for added confidence.
- Aesthetically pleasing, low profile OE appearance for installed parts.

**Adhesive information is available to meet most OEM part specifications and automotive standards.**
### 3M™ Automotive Attachment Tape Performance Guide

We offer three levels of performance to cover your application needs.

<table>
<thead>
<tr>
<th>Color</th>
<th>Thickness</th>
<th>Overall Performance</th>
<th>Best</th>
<th>Good</th>
<th>Better</th>
</tr>
</thead>
<tbody>
<tr>
<td>Gray</td>
<td>0.020 in (0.51 mm)</td>
<td>High</td>
<td>High</td>
<td>High</td>
<td>High</td>
</tr>
<tr>
<td>Black</td>
<td>0.020 in (0.51 mm)</td>
<td>High</td>
<td>High</td>
<td>High</td>
<td>High</td>
</tr>
<tr>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
</tr>
</tbody>
</table>

#### Why Tape?
Continuous seal with no gaps, no water or dust infiltration and reduced noise.

#### Why 3M Tape?
3M™ PCL is known for its strength and durability, providing a long-lasting solution.

### Product Packaging Examples

<table>
<thead>
<tr>
<th>Product/Part Number</th>
<th>Automotive Attachment Tape 06377</th>
<th>Automotive Acrylic Plus Attachment Tape 06380</th>
<th>Automotive Acrylic Plus Attachment Tape 06385</th>
<th>Adhesive Promoter Application Packet 06386</th>
</tr>
</thead>
<tbody>
<tr>
<td>Color</td>
<td>Grey</td>
<td>Black</td>
<td>Black</td>
<td>N/A</td>
</tr>
<tr>
<td>Thickness</td>
<td>0.020” / 0.51 mm</td>
<td>0.020” / 1.27 mm</td>
<td>0.020” / 1.27 mm</td>
<td>N/A</td>
</tr>
<tr>
<td>Note</td>
<td>0.50 x 40 yd (1.27 mm x 18.2 m)</td>
<td>0.50 x 40 yd (1.27 mm x 18.2 m)</td>
<td>0.50 x 40 yd (1.27 mm x 18.2 m)</td>
<td>N/A</td>
</tr>
</tbody>
</table>

| Instructions          | 25 pc packed carton of 15 | 25 pc packed carton of 15 | 25 pc packed carton of 15 | N/A |

<table>
<thead>
<tr>
<th>Selection</th>
<th>Tape Attached Part</th>
<th>GOOD</th>
<th>BETTER</th>
<th>BEST</th>
</tr>
</thead>
<tbody>
<tr>
<td>1 A, B, C pillar trim</td>
<td>•</td>
<td>•</td>
<td>•</td>
<td></td>
</tr>
<tr>
<td>2 Antenna</td>
<td>•</td>
<td>•</td>
<td>•</td>
<td></td>
</tr>
<tr>
<td>3 Chrome trim</td>
<td>•</td>
<td>•</td>
<td>•</td>
<td></td>
</tr>
<tr>
<td>4 License plate</td>
<td>•</td>
<td>•</td>
<td>•</td>
<td></td>
</tr>
<tr>
<td>5 Fender and chrome trim</td>
<td>•</td>
<td>•</td>
<td>•</td>
<td></td>
</tr>
<tr>
<td>6 Rocker panel</td>
<td>•</td>
<td>•</td>
<td>•</td>
<td></td>
</tr>
<tr>
<td>7 aerosol trim</td>
<td>•</td>
<td>•</td>
<td>•</td>
<td></td>
</tr>
<tr>
<td>8 Body side molding and fascia</td>
<td>•</td>
<td>•</td>
<td>•</td>
<td></td>
</tr>
<tr>
<td>9 Spoiler</td>
<td>•</td>
<td>•</td>
<td>•</td>
<td></td>
</tr>
<tr>
<td>10 Wheel flares and wheel arch trim</td>
<td>•</td>
<td>•</td>
<td>•</td>
<td></td>
</tr>
<tr>
<td>11 bumpers and spoilers</td>
<td>•</td>
<td>•</td>
<td>•</td>
<td></td>
</tr>
<tr>
<td>12 Door sill plate</td>
<td>•</td>
<td>•</td>
<td>•</td>
<td></td>
</tr>
</tbody>
</table>

### Product/Part Number

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>06377</td>
<td>Automotive Attachment Tape 06377</td>
</tr>
<tr>
<td>06380</td>
<td>Automotive Acrylic Plus Attachment Tape 06380</td>
</tr>
<tr>
<td>06385</td>
<td>Automotive Acrylic Plus Attachment Tape 06385</td>
</tr>
<tr>
<td>06386</td>
<td>Adhesive Promoter Application Packet 06386</td>
</tr>
</tbody>
</table>

### WhySelect?

1. **Continuous seal with no gaps**: Ensures a tight, unbroken seal that prevents water and dust infiltration, reducing noise and maintaining the aesthetic of the vehicle.
2. **High performance**: 3M™ products are known for their durability and reliability, ensuring long-lasting performance in various weather conditions.
3. **Wide range of applications**: Suitable for a variety of applications, from car trim to body panels, providing versatility in use.

### Why 3M Select?

- **3M™ PCL technology**: PCL technology offers superior adhesion and durability, ensuring a strong bond over time.
- **Easy application**: Designed for ease of application, allowing for rapid installation and minimal mess.
- **Guaranteed performance**: All 3M™ automotive attachment tapes are backed by a performance guarantee, ensuring customer satisfaction.

### Specifications

- **Material**: Thermoplastic resin
- **Color**: Standard and custom options available
- **Adhesion**: High, medium, and low strength
- **Weatherability**: Resistant to UV exposure and extreme temperatures

### Application

- **Body side moldings, wheel flares, wheel arch trim, and body elements**
- **Bumpers, spoilers, and other body components**
- **Door sill plates and other trim areas**

### Performance

- **Suitability for traditional and high-performance applications**
- **Available in a variety of colors and sizes**
- **Easy to use, requiring no special tools or training**

### Limitations

- **Not recommended for applications requiring high adhesion, such as intricate trim work**
- **May not be suitable for use on non-painted surfaces**

### Additional Resources

- **3M™ Automotive Attachment Tape Selection Guide**
- **3M™ Automotive Attachment Tape Performance Guide**
- **3M™ Automotive Attachment Tape Technical Manual**

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3M™ Automotive Attachment Tapes
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1. Remove the Body Side Molding (BSM) or Trim from the Vehicle
   3M™ Side Molding and Emblem Removal Tool (Part No. 08977)

2. Remove the Tape/Residue from the Vehicle
   3M™ Sticker-Off Wheel (Part Nos. 07498 or 07499), 3M™ Prep Solvent-70 (Part No. 08977) and isopropyl alcohol wipe

3. Remove the Tape/Residue from the BSM/Trim
   3M™ Sticker-Off Wheel or 3M™ File Belt Sander (Part No. 25209) with 3M™ Scotch Brite Durable Flex Belt (No. 64467), and also check not to gouge or deform the backside of BSM/trim.

4. Apply Adhesion Promoter to BSM/Trim
   Prime the BSM/trim with 3M™ Automotive Adhesion Promoter (Part No. C06396) in the areas the tape will be applied. The use of the 3M™ Automotive Adhesion Promoter (C06396) helps form a bond due to the use of low surface energy plastic by the automotive industry.

5. Apply 3M™ Acrylic Tape to BSM/Trim
   Use a hand rubber roller or thin hand pressure to securely bond the tape to the BSM/trim.

6. Re-Apply the BSM/Trim to the Vehicle
   Application temperature below 60°F should be avoided. If necessary, warm the vehicle surface with a heat gun to obtain the recommended vehicle surface application temperature of 60°F to 110°F.
   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.

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