Removal of 3M™ VHB™ Tape Bonded Panels From Trailers and Truck Bodies

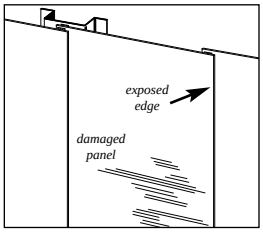
Technical Bulletin **March, 2002**

Equipment Required:

3/8" Electric Drill (500-2500 RPM)
3/4 h.p. Air Chisel
3M™ Side Molding and Emblem Removal Tool Kit - SMART (#09977)
4" 3M Stripe Off Wheel (#07499)
Air Regulator

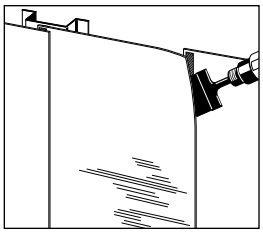
Steps for Disassembly of Overlapped Exterior Panel:

1. Remove rivets along the top and/or bottom of the panel that is to be removed.
2. Locate the exposed edge of the panel that is to be removed.

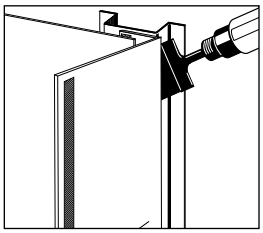


3. Using the SMART tool and a 3/4 h.p. air chisel cut through the 3M™ VHB™ tape bond.

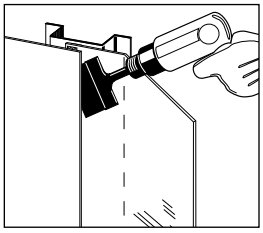
Note: Follow manufacturer's safety instructions and precautions for tool operation and use.



4. Bend panel out 90° from side of vehicle to expose next VHB bond line.



5. Using the SMART tool and a 3/4 h.p. air chisel cut through the VHB tape bond.
6. Continue step 4 and 5 sequence until the entire panel has been debonded from the supports.
7. Using the SMART tool and 3/4 h.p. air chisel remove the panel by cutting through the bond line to the adjacent overlapped panel.



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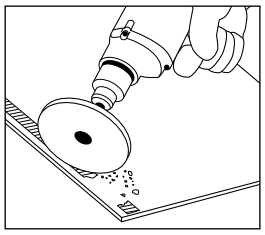
Removal of Adhesive Residue:

1. Using the 4" 3M™ Stripe Off Wheel and a 3/8" electric drill remove the adhesive residue from the adjacent panels and supports.



Note: Follow manufacturer's safety instructions and precautions for tool operation and use.

2. 3M™ Citrus Based Cleaner or other commercial adhesive removers can be utilized to remove the last residue.

Note: Follow solvent manufacturer's precautions and directions for using cleaners.

For Additional Information

To request additional product information or to arrange for sales assistance, call toll free 1-800-362-3550 or visit www.3M.com/adhesives. Address correspondence to: 3M Engineered Adhesives Division, 3M Center, Building 220-7E-01, St. Paul, MN 55144-1000. Our fax number is 651-733-9175. In Canada, phone: 1-800-364-3577. In Puerto Rico, phone: 1-787-750-3000. In Mexico, phone: 52-70-04-00.

Important Notice

User is responsible for determining whether the 3M product is fit for a particular purpose and suitable for user's method of application. Please remember that many factors can affect the use and performance of a 3M product in a particular application. The materials to be bonded with the product, the surface preparation of those materials, the product selected for use, the conditions in which the product is used, and the time and environmental conditions in which the product is expected to perform are among the many factors that can affect the use and performance of a 3M product. Given the variety of factors that can affect the use and performance of a 3M product, some of which are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for the user's method of application.

Warranty

3M warrants for 24 months from the date of manufacture, that 3M™ VHB™ Tape will be free of defects in material and manufacture. 3M MAKES NO OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. This Limited Warranty does not cover damage resulting from the use or inability to use 3M™ VHB™ Tape due to misuse, workmanship in application, or application or storage not in accordance with 3M recommended procedures.

Limitation of Remedies and Liability

If the 3M™ VHB™ Tape is proved to be defective within the warranty period stated above. THE EXCLUSIVE REMEDY, AT 3M'S OPTION, SHALL BE TO REFUND THE PURCHASE PRICE OF OR TO REPAIR OR REPLACE THE DEFECTIVE 3M™ VHB™ TAPE. 3M shall not otherwise be liable for loss or damages, whether direct, indirect, special, incidental, or consequential, regardless of the legal theory asserted, including negligence, warranty, or strict liability.

ISO 9002

This Engineered Adhesives Division product was manufactured under a 3M quality system registered to ISO 9002 standards.

3M

Engineered Adhesives Division

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