



Repair Procedure for Clips Applied with 3M™ Structural Bonding Tape 9259

Technical Update

March 2008

General Description Roof molding attachment clips bonded to a vehicle with 3M™ Structural Bonding Tape may be removed and replaced with new clips when repairing roof moldings or broken clips. This Application Guideline describes the recommended method for making this repair.

Materials

- Industrial drier
- Fine tweezers
- Soft spatula
- Isopropyl alcohol (IPA)*
- 3M™ Scotch-Brite™ High Performance Cloth
- Clip with *cured* 3M™ Structural Bonding Tape 9259 (cure condition: minimum 135°C [275°F] for 15 minutes)
- 3M™ Duramix™ Super-Fast Adhesive 4747 System **
- Masking tape for temporary holding
- Gloves to protect hands



****Note:** 3M™ Duramix™ Super-Fast Adhesive 4747 may cause asthma-like symptoms in persons previously sensitized to isocyanates. To obtain an MSDS, please go to: www.3M.com/MSDS.

Application Guidelines

3M™ Structural Bonding Tape 9259 Applied Clips

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Repair Procedure

1. Remove taped clip from liner.
2. Cure 3M™ Structural Bonding Tape 9259 for 15 minutes at 135°C [275°F] with adhesive exposed. (Note: SBT must be fully cured to achieve structural strength.)
3. To remove the damaged clip, heat under hot air (minimum 100°C [212°F]), until the tape is soft and pliable. Then remove the clip with fine tweezers, being careful not to damage the body panel.
(Tip: use a fine nozzle attached to the dryer to avoid damage to the body painted surface.)
4. To remove any remaining cured tape from the ditch that was previously applied, heat under hot air (minimum 100°C [212°F]), until the tape is soft and pliable; then remove with a soft spatula.
5. Clean roof ditch area with a clean wipe dipped in IPA*.
6. Apply 3M™ Duramix Super-Fast Adhesive 4747 to cured 3M Structural Bonding Tape 9259 on the new clip.
7. Set the new clip on the body panel, ensuring correct location and orientation, and hold it with masking tape for:
 - Minimum 15 minutes at 23°C (73°F)
 - Minimum 30 minutes at 10-23°C (50-73°F)
 - Minimum 60 minutes at 5-10°C (41-50°F)
8. Install roof molding.

*Note: When using solvents, extinguish all ignition sources, including pilot lights, and follow the manufacturer's precautions and directions for use.

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