

Application Procedures for Pressure-Sensitive Body Side Mouldings

Outlined below are the recommended procedures for applying pressure-sensitive body side mouldings (BSM). These procedures address three key points for a successful BSM application.

1. The body of the vehicle must be clean and dry to achieve the best adhesion.
2. The pressure-sensitive adhesive on the moulding must not be contaminated during the application.
3. The moulding must be applied to achieve complete contact (bond) of the adhesive to the vehicle. (i.e. maximum wet-out).

A. Installation Area:

1. The installation area should be kept reasonably clean. Any airborne dust, oils, etc. may contaminate the vehicle or BSM adhesive and reduce the bond of the tape.

B. Vehicle Surface Preparation:

1. The vehicle surface should be washed with an appropriate solvent, one commonly used system is a 70% mixture of Isopropyl Alcohol and water (Rubbing Alcohol). To assure removal of all contaminants it may be necessary to first wipe with TG Prep, then use the 70% Isopropyl Alcohol mixture.
 - * **Use clean lint free wiping cloths or disposable wipes.**
 - * **Reprocessed rags should not be used as they may contain wax or residue.**



2. After washing, the vehicle surface should be thoroughly dried. Again use a clean, dry, lint free cloth.
3. Vehicle surface application temperatures of 80°F (26°C) to 110°F (44°C) are recommended for best tape adhesion. The **warmer surface** will help wet-out the adhesive on the tape. During cold weather applications the vehicle surface can be heated with a heat gun or heat lamps, but do not heat the surface of the moulding. Application of the BSM at temperatures below 64°F (17°C) or above 110°F (44°C) must be avoided.



C. Body Side Moulding Preparation:

1. The BSM should be stored at room temperature in a clean dry area. Cold temperatures require heating to warm the moulding to the proper application temperature (i.e. Floor heater of vehicle). There is no damage to the tape or moulding stored at colder temperatures, but moisture and condensation must be avoided.
2. The moulding can be heated up to 100°F (38°C) for application. This will soften the moulding, making it easier to conform to the vehicle contours, as well as improve adhesive wet-out.
3. The liner on the adhesive should not be removed until application to the vehicle. This will help prevent contamination of the adhesive surface.

D. Body Side Moulding Application:

1. Align the moulding with a key feature such as the front and rear bumpers or with a body line to ensure proper moulding alignment. Placing ½" masking tape along the desired installation area is an excellent guide for applying the moulding straight.



2. Use moulding cutters to trim the moulding at door jams and body seams. Be certain to leave enough room for the door to open properly after the moulding has been installed. (Bevel cut if necessary).



3. Remove the liner from the tape as you are applying the moulding to the vehicle. Be careful not to contaminate the adhesive. Common sources of contamination are: oil from the applicator hands, dust or lint from clothing, work tables, or the floor. Do not touch the adhesive at any time. Contaminated mouldings should not be used



4. Apply the mouldings with a rolling motion to prevent entrapment of air between the tape and the vehicle surface. Use firm hand pressure to ensure good adhesion of the moulding.



5. A roll down with a hard rubber hand roller is recommended to assure complete wet-out of the adhesive to the vehicle surface. Apply firm pressure while rolling the moulding to properly wet-out the adhesive.



6. Check the edges of the moulding to assure good tape adhesion. Re-roll with more pressure as necessary to achieve a good bond.

