

97 Body Cavity Sealing and Undercoating

97 00 010 Body cavity sealing for entire car 97 - 1

BODY CAVITY SEALING – 3 - E 30 SERIES

Sealing Preparations

- Underside of car must be clean and dry.
 - If applicable, damaged PVC on underside including wheel housings and side panels must be repaired and treated with Tectyl.
- The thickness of undercoating should not exceed 250 μm (0.25 mm/0.010").
- Check car for paint finish damage and damage from flying stones and, if applicable, repair after consulting the customer.
 - Sealing compounds and the car itself should have room temperature (approx. 20° C / 68° F).
 - Check spray pattern of guns and nozzles.
 - When drilling holes, dip the stepped drill bit in sealing compound to trap burrs.
 - Remove dripping sealing compound.
 - Insert plugs dipped in Tectyl in all drilled holes after finishing sealing.
 - Spray engine sealing compound on engine and engine compartment to cover completely.
 - When repairing body parts damaged in an accident or replacing the car body, body cavity sealing must be carried out immediately after painting and before installation of attachments, equipment, trim, etc.. If repair welding seams and joints are only accessible from one side, the side which produces a cavity has to be treated with wax. The same is applicable for the rear side panels, above the wheel housings up to the roof joint, as well as doors especially in the upper corner areas.

Body cavity sealing performed after body repairs must be confirmed on the annual inspection sheets (Owner's Manual)!

Sealing Procedures on Lifting Platform

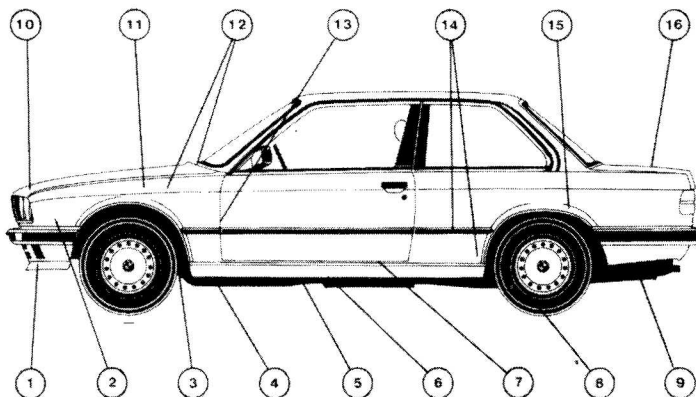
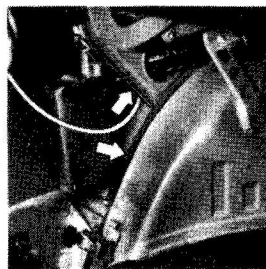
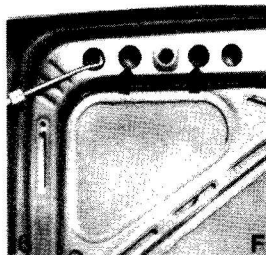
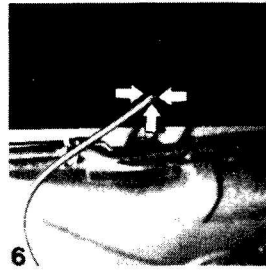
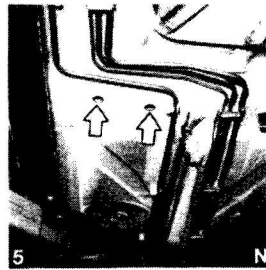
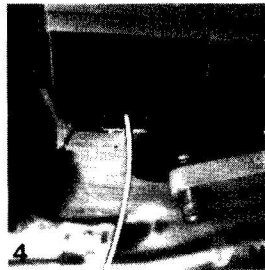
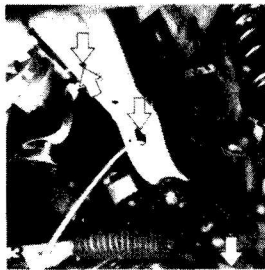
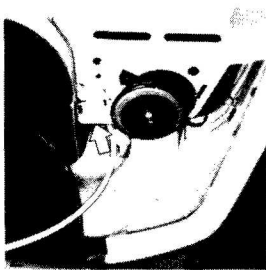
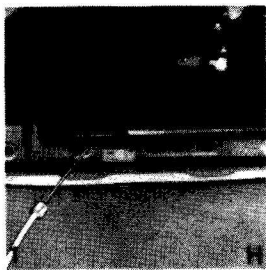
(wheels protected with covers available from HWB)

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|---|-------------|
| 1. Front cross member, through side openings. | H or F |
| 2. Front side panels and wheel houses. | N or RS |
| 3. Engine carrier over entire length. | N or RS |
| 4. Front side panels in rear area from behind through provided opening. | N or RS |
| 5. All reinforcements of floor assembly in front seat area through provided openings. | N or RS |
| 6. Door beams from underneath in middle. | N or RS |
| 7. Doors twice each through provided openings as well as front door window frame at rear (plates removed) | T+N or F+RS |
| 8. Left and right rear spring strut mounts through provided openings. | N or RS |
| 9. Side and cross members underneath trunk through provided openings. | N or RS |

Sealing Procedures without Lifting Platform

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|---|-------------|
| 10. Engine hood braces and all member profiles of front panel through provided openings. | H or F |
| 11. Spring strut reinforcement. | H or F |
| 12. Wheel house reinforcements/cowl panel bottom. | H+N or F+RS |
| 13. A pillars, door contact switches removed (cars with radio: speakers removed). | N or RS |
| 14. Rear side panels and wheel houses through rubber rubbing strip holes (2-door models) or door beam/rear side panel joints (4-door models). | N or RS |
| 15. Rear side panels and wheel houses from trunk. | N or RS |
| 16. Trunk lid braces through provided openings. | H or F |

H = Hook-type probe
 N = Nylon probe
 T = Door probe
 RS = Round spray pattern slotted nozzle
 F = Flat spray pattern nozzle

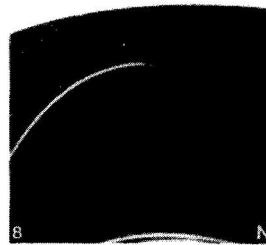


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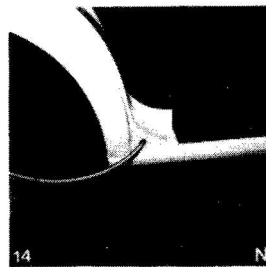
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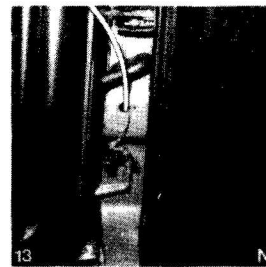
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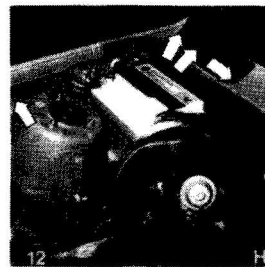
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N



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N



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H

