

**Special tools required:**

- [51 0 300](#)

Important!

Do not pull on the sound insulation in jerks (risk of damage)

General:

Sound insulation is bonded to the inner door panel.

Bonded sound insulation must not be subjected to load (e.g. leak test) before 5 hours have elapsed.

On-the-job safety:

When working with bonding products (adhesive, cleaning agent, etc.):

- Wear safety goggles, protective gloves and if necessary an apron.
- Ensure rooms are well ventilated.
- Change work clothing contaminated with adhesive immediately.
- Change work clothing contaminated with solvents and swelling agents immediately (keep spare work clothing on hand).
- Take skin protection measures, provide washing facilities including hot water, use silicone-free skin creams
- Provide eye douche facilities, change water regularly (once a month).
- Comply with the relevant safety regulations

Handling adhesive area on inner door panel:

Adhesive	Cleaning
Â	a. Cleaning agentR2
a. Butyl bead applied to sound insulation with protective film	<i>Under no circumstances: paint thinning</i>
b. Butyl mini-round profile Ø 3 mm from the roller	b. Carry out bonding only after an air drying time ≥ 1 min. Air drying time may be omitted if the entire bonding surface is wiped with a dry cloth
c. Butyl round profile Ø 6 mm from the roller	c. After cleaning, the bonding surface may not be touched with hands or fouled again

Repair in area of sound insulation, door:

Repair	• Cut the butyl rope between the sound insulation and the inner door panel with a sharp knife
Â	• After the repair is finished, position a new butyl rope Ø 3 mm directly on the original adhesive bead • Heat the butyl bead with a standard hot air blower until the butyl rope strings when touched slightly. Do not damage the sound insulation in the process • Press on with special tool 51 0 300. Perform this work extremely carefully because the increased amount of adhesive requires contact pressure of $\geq 20 \text{ N/cm}^2$ (compared to firm thumb pressure $\sim 30 \text{ N/cm}^2$) • Visually check the adhesive bead and its compression (no capillaries or broken adhesive bead permitted)
in the event of damaged sound insulation or leakage	• In the cases mentioned, the complete sound insulation must be replaced. After removing the sound insulation, removal all butyl remnants from the inner door panel. Apply 6 mm Ø butyl rope to new sound insulation • Press on with special tool 51 0 300. Contact pressure $\geq 20 \text{ N/cm}^2$ (compare to firm thumb pressure $\sim 30 \text{ N/cm}^2$)

The sound insulation must be bonded watertight below the door lock:

- Flat bonding surface required all round
- No bonding in event of moisture (e.g. condensation, etc.)

- Bonding area must not show any traces of adhesion-reducing residues (e.g. separating agents, greases, oils, paraffins, plastisols, cavity wax, polishing dust residues, etc.)
- Remove the protective film directly before joining (under no circumstances remove earlier, since the butyl, because of its stickiness, will very quickly pick up adhesion-reducing dirt contaminants)
- The sound insulation must be attached with positional accuracy to the inner door panel, because it is no longer possible to change the position without damaging the butyl bead
- With repainted areas, the maximum permitted temperature of 90°C may not be exceeded in the area of the sound insulation. Otherwise, the sound insulation must be removed (and replaced, if necessary).

Expiry date of adhesive:

24 months, see label on packaging

Disposal of the cleaning cloth:

Cleaning cloths and cleaning agent residues are hazardous waste (see also safety data sheet)

Disposal of adhesive:

Hazardous waste (see also safety data sheet)

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