

Unless specified otherwise in vehicle-specific or component-specific instructions, the following notes apply.

1. General notes

- Bonding at room and object temperature of $>+18\text{ }^{\circ}\text{C}$.
- Newly painted parts may only be bonded after a drying time of at least 24 hours.
- Optimal bonding/attachment to the background surface is achieved after approx. 48 hours. Components must not be exposed to mechanical strain beforehand (car wash, strength test, etc.).
- Do not touch bonding area.
- It is not the length of time that pressure is applied but rather the force of pressure applied that is crucial.
- Detaching the adhesive tape after pressing destroys the adhesive layer.
- After being pressed on gently, adhesive tape can be pulled off again up to 3 times.

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2. Auxiliary materials and tools

- [Cleaning agent R1 or cleaning agent R2](#) (sourcing reference: BMW Parts Department)
- Fluff-free cleaning cloths
- Pressure roller

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3. Preparations

- Remove all adhesive residue or clean new part thoroughly
- Clean the areas to be bonded immediately before bonding to remove silicone and grease residues.

Note:

Observe air drying time ≥ 1 minute.

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4. Bonding

4.1 Components without pre-fitted adhesive tape

- Pull off liner* from adhesive tape
- Position adhesive tape on component and stick on
- Press down adhesive tape over entire adhesive area
- Continue with Point 4.2

* Liner is the protective film on the adhesive tape.

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4.2 Components with pre-fitted adhesive tape

- Pull off liner* from adhesive side (if adhesive area is large, do not pull off liner completely)
- Align component in correct position on vehicle
- Press down component over entire adhesive area

Minimum contact pressure $\geq 15 \text{ N/cm}^2$ (firm thumb pressure reaches approx. 30 N/cm^2 .)

* Liner is the protective film on the adhesive tape.