



# NGDV – Technical Bulletin

**Title:** Tesa Tape Rework

**Number:** NGDVTB0005

**Revision:** -

**Classification:** Highly Restricted



Exceeding Customer Expectations through Continuous Improvement

# NGDV Technical Bulletin

## NGDV Tesa Tape Rework

### Table of Contents

<b>INTRODUCTION</b>	2
Initial Concern	2
Suspect Population	2
Procedure and Material List	2
Frequently Asked Questions	2
Tools	2
Consumables	2
Personnel Requirements	2
<b>PROCEDURE</b>	3
Excess Tape Removal	3
Tape Application	3
Seam Sealant Application	6
Paint Rework	6

## **INTRODUCTION**

### **Initial Concern**

Tape was not fully sealed and connected to the unibody due to excess tape application, causing it to be easily peeled away, allowing dust and water to potentially bypass into the vehicle.

### **Suspect Population**

All ICE and BEV NGDV's

### **Procedure and Material List**

See process outlined below.

### **Frequently Asked Questions**

**Q: Are all NGDV's affected and in need of this procedure?**

**A:** Fix as required

**Q: What happens if the outlined steps are not followed?**

**A:** Dust, air, and/or water intrusion may occur to the vehicle.

## **REWORK TOOLS AND MATERIAL LIST**

### **Tools**

- Knife/Scissors
- Roller or Bondo Spreader

### **Parts and Consumables**

- Tesa Tape 4657 50mm width - D014W331004
- Sikaflex 211 24X300ml - D014V808
- Touch up paint- PPG HSB977428
- Hardener - GXH3170
- Reducer- GX66560

### **Personnel Requirements**

- Procedure: 0.1 Total Man Hours
- 1 person will be required for this job.

## **PROCEDURE**

### **Excess Tesa Tape Removal**

1. Cut seam sealant where it begins to overlap the Tesa Tape (Figure 1).

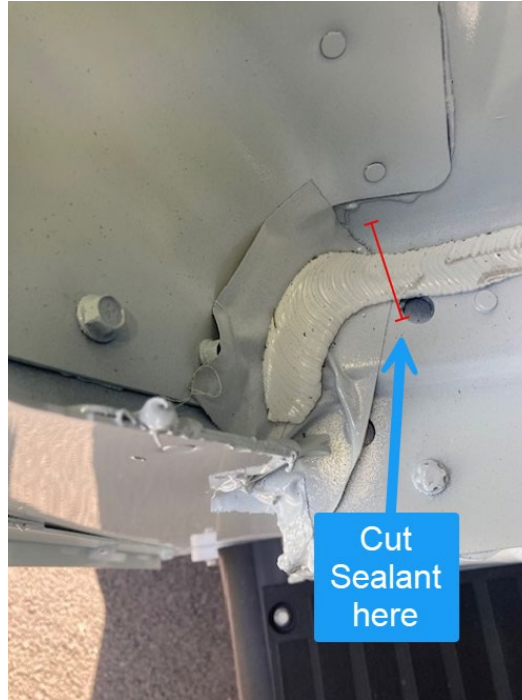


Figure 1

2. Remove non-conforming, improperly sealed Tesa Tape as shown in figure 1.

### **Tesa Tape Application**

1. Using Tesa Tape 4657 50mm width, cut approximately 120mm in length.
2. Place tape in the back corner, flat onto the floor surface.
3. Using sufficient force, wet out tape by using a bondo spreader or similar tool to apply pressure to ensure proper adhesion. Start at the rear and move forward. Avoid allowing the tape to bridge gaps or crease up (Figure 2 Page 4).



Figure 2

4. Cut an additional piece of approximately 25mm in length (Figure 3).
5. Mold additional piece around the corner fully sealing edges and remainder of hole.



Figure 3

## Seam Sealant Application

1. Use Sikaflex 211 white seam sealant 24x300ml tube.
2. Apply sealant along the exposed seam as shown in (Figure 4).
3. Use appropriate spreader tools to achieve sufficient wet out of sealant.

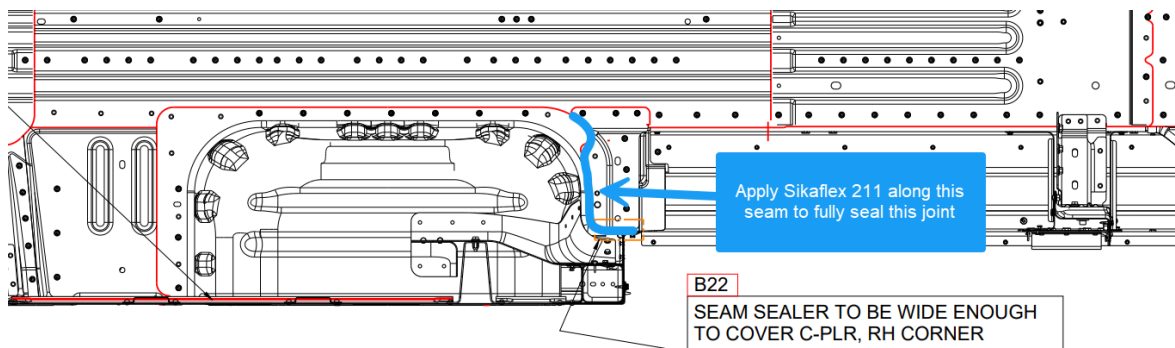


Figure 4

## Paint Rework

1. Abiding by paint prep work as needed, including but not limiting to scuffing neighboring painted areas, back taping/masking.
2. Paint the surrounding area using PPG HSB977428 at a 4:1 ratio. Hardener GXH3170, Reducer GX66560.
3. Final result in Figure 5 is what a properly seamed and painted unibody looks like.



Figure 5



Revision History

Revision	Date	Description	Requestor
-			

Contact Information

NGDV Product Support Line - 1 (800) 830-3554