



NGDV – Technical Bulletin

Title: Label Adhesive Repair Process

Number: NGDVTB0009

Revision: -

Classification: Highly Restricted

Exceeding Customer Expectations through Continuous Improvement



NGDV Technical Bulletin

Label Adhesive Repair Process

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INTRODUCTION

Initial Concern

Safety and Warning labels in the cab are peeling. A change to remove the texture on the panels, where these labels adhere, will be made in mid-2026, so this is a permanent fix option until that time.

Suspect Population

All NGDV's could be affected.

Frequently Asked Questions

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

A: Only NGDVs with labels that have started peeling or lifting

Q: What happens if the outlines steps are not followed?

A: Labels could fall off or become unreadable. Safety Labels are required to be properly placed and adhered per NHTSA.

REWORK TOOLS AND MATERIAL LIST

Parts

- D011K045 (Mail Tray Warning Label)
- 5124026 (Tow Label)

Tools

- Knurled Roller
- Felt Tipped Applicator or similar type applicator

Consumables

- Isopropyl Alcohol
- 3M adhesion promoter - 4298UV
- Gravity Feed Wipes

Personnel Requirements

- Procedure: 0.10 Total Man Hours (10 minutes))
- 1 person will be required for this job.

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PROCEDURE

1. Removal

- Remove damaged/peeling labels – D011K045 and 5124026
- Discard old labels

**2. Surface Preparation**

- The bonding surface should be clean and dry. Contaminated surfaces should be cleaned with isopropyl alcohol.

3. Equipment

- 3M adhesion promoter 4298UV can be applied by a gravity feed wipe, knurled roller, and felt-tipped applicator or other similar type applicator. Applicator heads should be cleaned or replaced regularly.

4. Adhesion Promotor Application

- Shake well before using.
- Apply a thin, uniform coating of the 3M Adhesion promoter 4298UV to the bonding surface, using the minimum amount that will fully coat the surface. A wet coating thickness of approximately 0.002 inch (0.05 mm) or less is recommended.
- Although drying times may vary due to temperature and/or humidity, a drying time of 30-90 seconds is typical of this thickness. The adhesion promoter should be dry before applying the label.
- For best results, apply new labels within one hour after applying the adhesion promoter. Be sure the primer surface remains free from contaminants prior to label installation.

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5. Label Installation

- For best bonding conditions, application surface should be between 70°F (21°C) and 100°F (38°C) with a minimum temperature of 50°F (10°C).
- Peel backing from new label and install in location as shown below.
- Pressure should be applied evenly to all surfaces of the label to ensure proper adhesion.

Revision	Date	Description	Requestor

Contact Information

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