

 <b>NGDV – Technical Bulletin</b>	<b>Title:</b> Label Adhesive Repair Process	
	<b>Number:</b> NGDVTB0009	<b>Revision:</b> -
	<b>Classification:</b> Highly Restricted	



Exceeding Customer Expectations through Continuous Improvement

# NGDV Technical Bulletin

## Label Adhesive Repair Process

### Table of Contents

<b>INTRODUCTION</b>	2
Initial Concern	2
Suspect Population	2
Frequently Asked Questions	2
Parts	2
Tools	2
Consumables	2
Personnel Requirements	2
<b>PROCEDURE</b>	3
Contact Information	4

**NGDVTB009 – 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.

## NGDVTB009 – LABEL ADHESIVE REPAIR PROCESS

# 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.



**NGDVTB009 – LABEL ADHESIVE REPAIR PROCESS**

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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