



Fitting Polyurethane (PU) Body Kits

First ,wipe the position of bodykits where needs affix the 3M glue paper.It is better to wipe using sand paper.

1. The characteristics of PU Body Kits

PU (Polyurethane) body kits are light, offer strong shock and fracture resistance, and retain their appearance over a wide range of temperatures (-40°C—80°C) . PU body kits are pliable, like most types of plastic. However, under conditions of high pressure and temperature the parts can become distorted. To avoid this:

- (1) store parts flat without any stress that could cause them to become bent or twisted;
- (2) when spray-painting, keep the temperature below 50°C.

In the event that parts become distorted, the part should be heated uniformly (e.g with a hair drier) and twisted into the correct shape by hand.

2. Installing PU body kits to ensure the correct fit

There are two stages to fitting PU body kits:

- (1) Gluing parts to the car using 3M adhesive tape, and
- (2) Fixing them with stainless steel screws.

The strength of the bond will be weaker if the 3M adhesive tape is wet. To avoid this, during spray-painting, cleaning and installation, the 3M adhesive tape should be kept dry. If it is necessary to clean the car during fitting, the 3M adhesive tape should be covered with a sticker to avoid getting it wet. It takes 72 hours for the 3M adhesive tape to reach its maximum bonding strength after it is attached to the car. Therefore, to ensure that parts bond fully, the car should not be driven for at least 4 hours after fitting unless the parts are supported by packaging tape. The car should also not be washed for at least 24 hours after fitting PU parts.

3. Fitting the PU body kit

Before you begin:

1. Place each part on the car and check its correct position using paper tape (Figures 1 and 2).



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2. Clean the area where the PU part will be joined to the body of the car with a clean, lint-free cloth. Then, wipe the place where the 3M adhesive tape will be attached to the car with a pre-sol cleaner such as Dupont 3919S. Once the cleaner evaporates apply a

coating of 3M 94 Primer. This will increase the bonding of the 3M adhesive tape to the body of the car.

3. Tear a section of protective film of 3M adhesive tape (about 3 to 5 mm). This makes it easier to remove the protective film when fitting the parts (Figure 3).



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4. Install the Front Bumper Lip (Figure 4).

1. Depending on to the shape of the car and the installation position, place the Front Bumper Lip against the body of the car. During checking, avoid damaging the paintwork of the car or allowing the exposed part of the 3M adhesive strip from touching the body kits or the body of the car.
- 2.. Gently remove the protective film from the 3M adhesive strip. While removing the protective film, check carefully to ensure that the part is in the correct position (Figure 5).



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- 3 The chemical reaction between the 3M adhesive tape and the 3M 94 Primer reaches its maximum adhesiveness in 15 minutes. This allows the fitter about 15-20 minutes to press the part onto the car using their fingers (Figure 6).
4. To complete the installation of the front bar, tighten the stainless steel screws on both sides of Front Bumper Lip (Figure 7). Finally, check that the part is stable, and at the correct angle.



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5. The fitting technique for the Rear Bumper Lip is the same as the Front Bumper Lip.
6. The fitting technique for the side skirts is the same as for the Front Bumper Lip and Rear Bumper Lip (Figure 8).