

Solution K60332914 Thursday, November 1, 2018 7:37:00 PM CET

Volvo Models

Volvo Model	VNL
Emission Standard	
Emission Standard	2018, US17
** SOLUTION **	
Title	Volvo Chassis - Fender Panel Crack Repair - Model Year 2018 And Newer
Cause	The purpose of this document is to outline the process to repair cracks in Volvo SMC fender panels for hoods on model year 2018 and newer VNL models.
Solution	Supplies

Tools

- Burr Bit
- Dual Action Palm Sander
- U-POL Fibral Dispensing Gun

Materials

- U-POL Fibral Glass Fiber Filler
- 3MTM PlatinumTM Plus Filler
- 3MTM PlatinumTM Plus Finishing Glaze
- 3MTM Acryl Red Glazing Putty
- 3MTM Creme Hardener
- AxaltaTM Spot Repair Primer
- Scotch-BriteTM
- Tack Rags
- 80 grit sandpaper
- 180 Grit Sandpaper

Repair

1. Mark all areas to be repaired.



 ${f 2.}$ Grind or prepare the marked areas: Ensure good adhesion by using a burr bit to grind out the crack on both the top and bottom surfaces.



3. Using a Dual Action Palm Sander with 80 grit sandpaper, sand around the area to be repaired on both top and bottom.



- 4. Blow the hood off using an air dispensing tool.
- 5. Using a clean mixing board and spreader, mix the Fibral throughly and apply to the cracked or damaged areas.





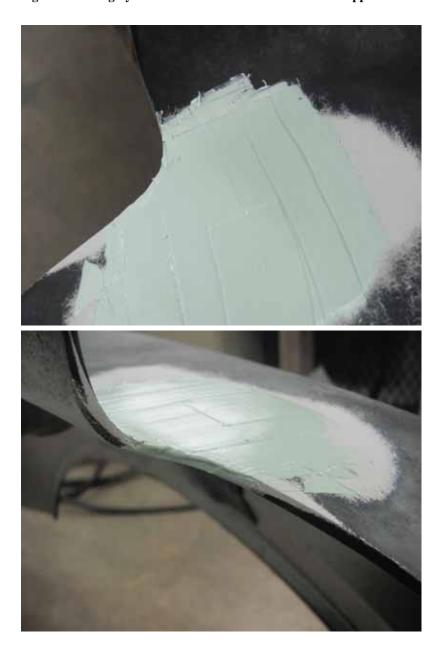


- 6. Allow the material to cure fully before sanding.
- 7. Using the Palm Sander with 80 grit sandpaper, sand the Fibral down to a level surface, then blow the surface clean.





8. Using a clean mixing board and spreader, mix the Metal Glaze and Hardener together thoroughly and cover the areas where Fibral was applied.



- 9. Allow the material to cure fully before sanding procedure.
- 10. Using the Palm Sander with 180 grit sandpaper, sand Metal Glaze down to a level surface and blow the surface clean.



- 11. If pinholes are visible, use $3M^{\rm TM}$ Platinum $^{\rm TM}$ Plus Finishing Glaze to fill in the imperfections.
- 12. After the Finishing Glaze has dried, sand the surface using 180 grit sand paper to achieve a uniform finish.
- 13. Blow off and tack the entire hood before moving on to spot primer.



Function(s)/component(s) affected

Function affected	bodywork
Function Group	
Function Group	821 engine hood, cover with assembly parts
Customer effect	
Visual appearance	crack/fracture
Administration	
Author	RU4469V
Dealer ID	RU4469V
Last modified by	A241298
Creation date	10-10-2018 21:10
Date of last update	16-10-2018 22:10
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