



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 Fibril Dispensing Gun

Materials

- U-POL Fibril Glass Fiber Filler
- 3M™ Platinum™ Plus Filler
- 3M™ Platinum™ Plus Finishing Glaze
- 3M™ Acryl Red Glazing Putty
- 3M™ Creme Hardener
- Axalta™ Spot Repair Primer
- Scotch-Brite™
- Tack Rags
- 80 grit sandpaper
- 180 Grit Sandpaper

Repair

1. Mark all areas to be repaired.



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 thoroughly 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™ Platinum™ 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

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