

## Technical product information

<b>Topic</b>	Flying B mascot clear wings replacement procedure
<b>Market area</b>	Bentley: worldwide (2WBE)
<b>Brand</b>	Bentley
<b>Transaction No.</b>	2069611/1
<b>Level</b>	EH
<b>Status</b>	Approval
<b>Release date</b>	

### New customer code

Object of complaint	Complaint type	Position
body -> vehicle front end, vehicle rear end	high-volume parts	
body fixtures and fittings -> trim, protective strips, brightware, dirt deflector -> brand badge	component / consumables -> missing	front

## Vehicle data

### New Flying Spur

#### Sales types

Type	MY	Brand	Designation	Engine code	Gearbox code	Final drive code
ZG2*	2020	E		*	*	*
ZG2*	2021	E		*	*	*
ZG2*	2022	E		*	*	*
ZG2*	2023	E		*	*	*

## Documents

Document name
<a href="#">master.xml</a>
<a href="#">3094-gel-rev-apds.pdf</a>
<a href="#">3094gel.pdf</a>

## Customer statement / workshop findings

One or both of the Flying B mascot clear wings are missing (Figure 1)

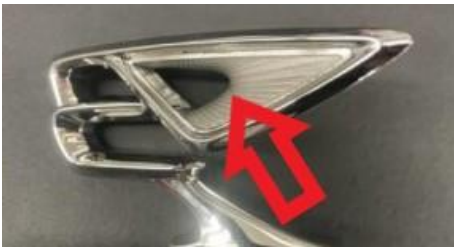


Figure 1



In the event that one Flying B wing is missing the operative must replace both wings to eliminate a repeat repair

**VERY IMPORTANT:** It is no longer a requirement to replace the complete Flying B mascot assembly if the clear wings are missing, the process within the Measure section details how to fit new replacement clear wings

## Technical background



The adhesive that must be used to secure the Flying B clear wings is Dymax Ultra light weld 3094-GEL-REV- A

This must be sourced locally by copying/pasting one of the following links into your browser:

<https://dymax.com/sales-support/contact-us/global-contacts>

Or

<https://dymax.com/forms/find-a-partner>

The adhesive is available for sourcing in the following countries:

- Australia
- Austria
- China
- Costa Rica
- Czech Republic
- Denmark
- Dominican Republic
- Egypt
- Finland
- France
- Germany
- Hungary
- India
- Israel
- Italy
- Japan
- Malaysia
- Mexico
- Netherlands
- Norway
- Poland
- Puerto Rico

- Romania
- Russia
- Singapore
- Slovenia
- South Korea
- Spain
- Sweden
- Switzerland
- Thailand
- Turkey
- United Kingdom
- USA



In the event the adhesive cannot be sourced locally by using one of the afore listed links

Or

The applicable country is not listed the operative should raise a Service Call and await feedback before conducting with any further work

Please ensure the following information is included within the Service call

- My country is not listed within the country matrix

Or

- The adhesive cannot be sourced locally through the suggested regional Dymax supplier

<b>⚠ CAUTION</b>
DO NOT UNDER ANY CIRCUMSTANCES USE A DIFFERENT TYPE OF ADHESIVE OTHER THAN THE TYPE SPECIFIED

<b>ℹ NOTICE</b>
The following must also be sourced locally before continuing with the onward process

**UV light (Figure 2) the specification must be as follows:**

- Minimum power output must be 5W



Figure 2

**The UV Wavelength must be as follows:**

- Minimum wavelength of 395nm (nanometres)
- Grey or dark brown UV safety glasses must be worn when conducting the adhesive bonding procedure
- Standard safety glasses must be worn whilst conducting all other steps other than the UV adhesive bonding procedure

- Dymax Ultra light weld 3094-GEL-REV- A - 30 ML (Figure 3)
- 3M surface cleaner or same specification

**CAUTION**

VERY IMPORTANT: The adhesive must not be applied if the Use by date has expired  
 – Ensure the adhesive is stored as per all manufacturers instructions



**IMPORTANT:** Once the adhesive has been opened both caps (ARROWS) must be refitted as the adhesive will solidify

**Tip:** if the caps are refitted as instructed the adhesive should be suitable to use up to the Use by date

**IMPORTANT:** In the event the adhesive has been left open without one or both caps fitted the adhesive must be discarded as per all local environmental guidelines, a new tube of adhesive must then be sourced

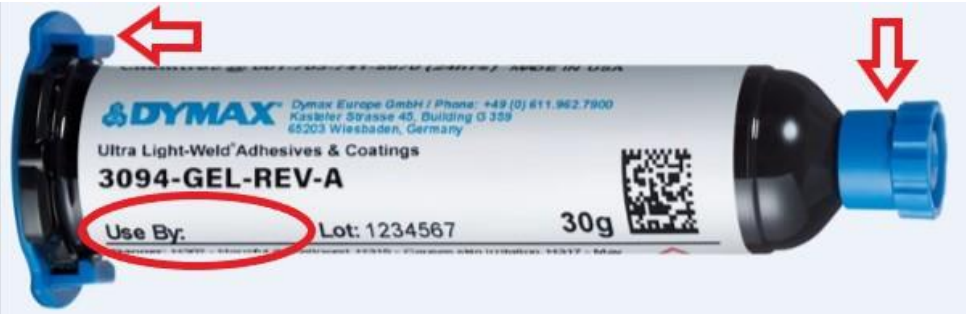


Figure 3

- Adhesive application gun (Figure 4)



Figure 4

**Production change**

-

**Measure**

**CAUTION**

DO NOT UNDER ANY CIRCUMSTANCES ATTEMPT TO REPLACE THE FLYING B MASCOT WINGS WITHOUT REMOVING THE FLYING B ASSEMBLY FROM THE VEHICLE AS PER REP.GR 66

**DAMAGE CAN EASILY BE CAUSED TO THE RADIATOR SHELL AND/OR BONNET, WARRANTY PAYMENTS WILL NOT BE CONSIDERED FOR ANY DAMAGE TO THE RADIATOR SHELL/BONNET AND ASSEMBLY (INCLUDING MASCOT)**

1) Referring to Rep.Gr 66 - Remove the Flying B assembly from the vehicle



In the event that one of the Flying B clear wings is missing, the operative should remove the existing wing as detailed in step 1

Or

If both Flying B clear wings are missing, continue from step 2

**NOTICE**

NOTE: Warranty payments will not be considered for any damage to the Flying B mascot

Hint:: In the event that one of the clear wings is missing and the opposing wing requires removal in most cases the clear wing can be easily removed by using a suitable non metallic tool to remove/push out the wing from the mascot

However

In the event the remaining clear wing is difficult to remove please refer to the steps below

1) Due to the location of the LED light (Figure 5) damage can be caused to the Flying B mascot therefore it is imperative the wings are drilled at the exact location shown within Figure 6



Figure 5

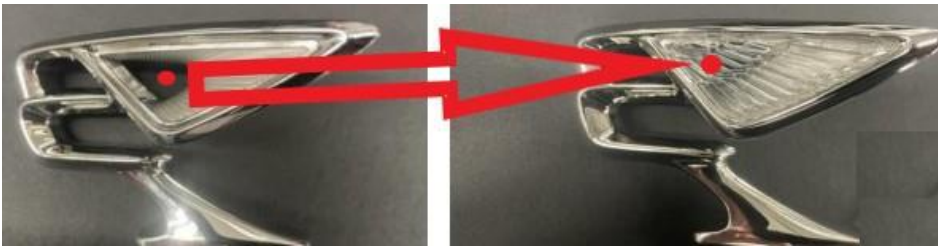


Figure 6

- Safety glasses and gloves must be worn for the duration of this repair process (Figure 7) UV safety glasses are also required to be used when advised within the TPI



Figure 7

**CAUTION**

The use of suitable protective gloves is imperative as the clear wings must be kept clean on the inside and outside as well as the edges, do not conduct the onward procedure without wearing suitable gloves



Once removed from the vehicle the operative must ensure the Flying B assembly is placed on a clean protective surface - The use of a suitable countersink drill (3mmx1.6mm) is recommended (Figure 8) the countersink drill must be capable of a making a hole with a maximum width of 3mm, the tool Must Not contact the mascot or LED



Figure 8

Hint: A standard 3mm drill bit can be used however the drill must be used in conjunction with a drill stop tool to ensure a depth of 3mm is not exceeded (Figure 9)



Figure 9

- Do not use a standard drill without using a drill stop as damage can easily be caused to the mascot or LED (Figure 10)



Figure 10

- Once the hole is drilled use a suitable pick tool to remove the wing

HINT: In the event the glass is secure please use a suitable heat gun (select a low setting to soften the previously applied adhesive)

**WARNING**

Warning: Take care not to apply excessive heat as damaged can be caused to the Flying B and the LED inside the Flying B, any damage will not be covered under Warranty

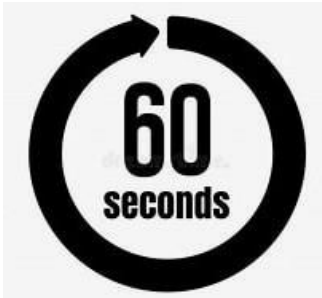
2) Referring to Figure 11 - Using foam cleaning tips in conjunction with 3M surface cleaner thoroughly clean the Flying B aperture



Figure 11

**⚠ CAUTION**

Once the adhesive has been removed using the 3M cleaner the operative should wait 60 seconds to allow the liquid to evaporate



3) Check to confirm that no traces of the original adhesive are evident

**ⓘ NOTICE**

IMPORTANT: In the event there are traces of adhesive this must be removed using a suitable non-metallic tool noting

**⚠ CAUTION**

Before applying the adhesive the operative must ensure the following:

- Ensure the Use by date has not expired
- Ensure a new nozzle is always used
- Before applying the adhesive ensure that any air within the nozzle is removed prior to applying the adhesive

4) Referring to Figure 12 - Apply the adhesive as shown ensuring the adhesive is applied in a consistent manner noting the following:



Should the adhesive dosage be sporadic/not consistent (Figure 13) there is a risk of insufficient sealing and water ingress

- Poor Cleaning of the Flying B mascot can lead to debris inside the mascot
- Should too much adhesive be applied the excess will be visible and would be seen through the clear wings





Figure 12





Figure 13

**⚠ CAUTION**

CAUTION before fitting the clear wings the operative MUST ensure the wings are fitted in the correct location ensuring the serrations are on the outer sides as shown in Figures 14 and 15

- Figure 14 - Left hand side



Figure 14

- Figure 15 - Right hand side

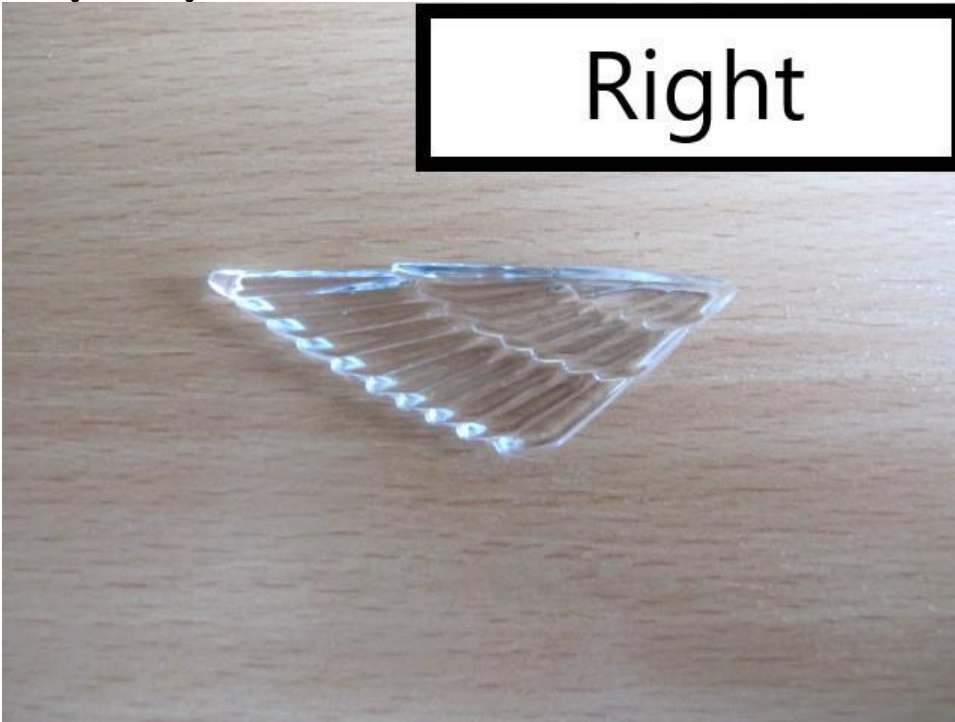


Figure 15

5) Referring to Figure 16 - Ensuring suitable gloves are worn – Use suitable double sided tape to hold the wing at the location shown, fit the replacement wing ensuring the adhesive is not disturbed, once fitted wipe away any excess adhesive from the outside of the clear wing and mascot using a clean cloth and 3M surface cleaner

**⚠ CAUTION**

Do Not hold the wing as shown in Figure 17 as the adhesive can easily be disturbed when using this method



Figure 16



Figure 17

6) Once fitted the wing should be as shown in Figure 18

**CAUTION**

CAUTION before fitting the clear wings the operative MUST ensure the wings are fitted in the correct location ensuring the serrations are on the outer sides as shown back in Figures 14 and 15



Figure 18

7) Referring to Figure 19 - With the Flying B assembly placed on a suitable clean surface – Ensure suitable UV safety glasses are worn - Switch on the UV lamp

**NOTICE**

The operative should be aware that the distance quoted of 100mm and the time of 60 seconds to cure the adhesive may vary depending on the type of light which has been sourced, the operative should refer to the manufacturer's instructions of the lamp

**NOTICE**

Ensure the beam is projecting equally onto the newly fitted clear wing for a duration 60 seconds as shown in Figure 19

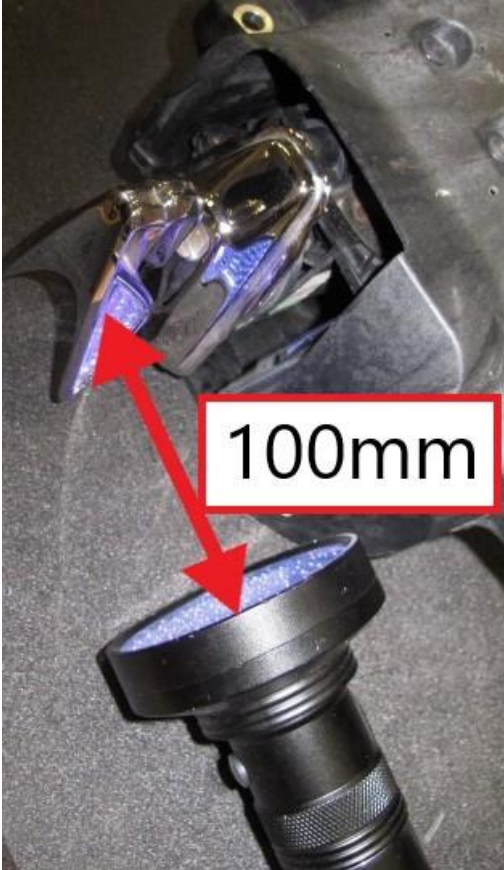


Figure 19

8) Repeat steps 2 through to 7 on the opposing side of the mascot

9) Once both wings have been fitted - Refit the Flying B assembly - Refer to Rep.Gr 66

### **Warranty accounting instructions**

#### **Time to remove the Flying B assembly and replace both Flying B mascot wings**

Warranty Type 110 or 910

Damage Service Number 66 07

Damage Code 00 10

#### **Time to replace both Flying B mascot wings**

Labour Operation Code 66 07 50 51

Time 20 TU

#### **Time to remove and refit the radiator grill**

Labour Operation Code 66 05 19 00

Time 30 TU

#### **Time to remove and refit the Flying B assembly**

Labour Operation Code 66 07 1 950

Time 10 TU

#### **NOTICE**

IMPORTANT: As the kits can be used on 5 vehicles the operative must claim a quantity of 0.2x Kits per repair, this is to ensure a full kit of parts is not claimed for every repair



## Parts information

### **!** NOTICE

Dymax Ultra light weld 3094-GEL-REV- A must be sourced by using one of the following links:

<https://dymax.com/sales-support/contact-us/global-contacts>

Or

<https://dymax.com/forms/find-a-partner>

### **3SE 898 810 - REPAIR KIT FLYING B WINGS (Figure 20)**

The kit contains the following and can be used on multiple vehicles

- Syringe Needles x5
- Sets of clear wings x10 (5 left hand side wings - 5 right hand side wings)
- Foam Cleaning Tips x5

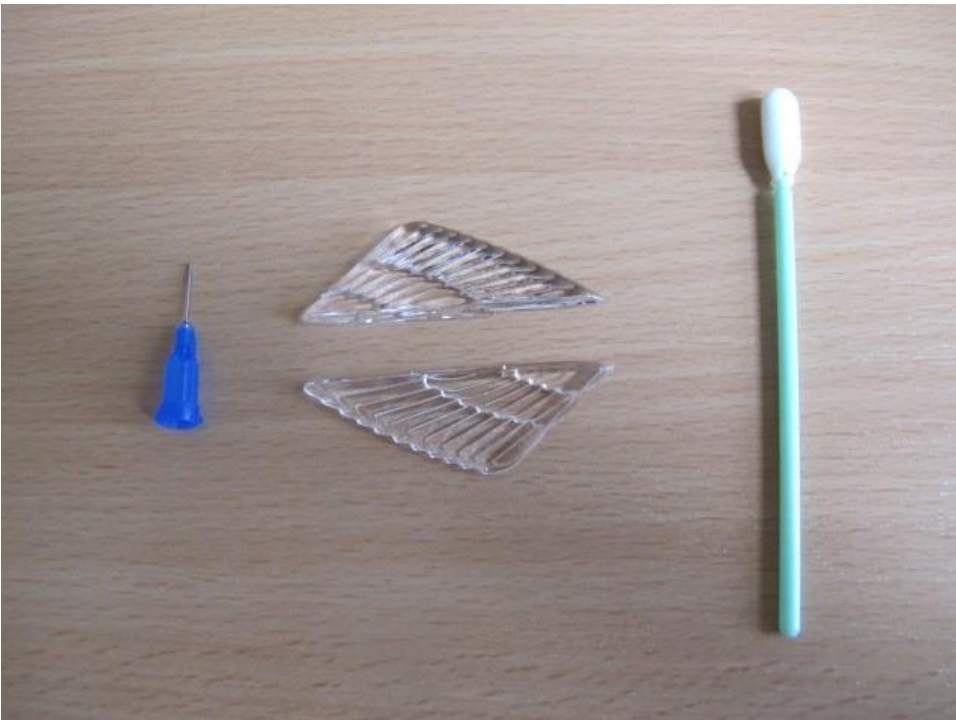


Figure 20

### **!** NOTICE

**IMPORTANT:** As the kits can be used on 5 vehicles the operative must claim a quantity of 0.2x Kits per repair, this is to ensure a full kit of parts is not claimed for every repair