



SURFACE VEHICLE RECOMMENDED PRACTICE

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The Selection of Adhesives for the Attachment of Exterior Aftermarket Accessories

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Foreword—This Document suggests materials and procedures for obtaining a good bond between two surfaces. It does not address or guarantee adequate strength, or the performance of the bond, for the intended purpose of the bonded parts.

1. Scope—The scope of this SAE Recommended Practice is to provide a mechanism for the proper surface preparation and selection of adhesive for the attachment of exterior aftermarket accessories.

1.1 Purpose—To provide the aftermarket with guidelines for the selection of adhesives to attach various aftermarket components to the exterior of the automobile body. Covered in this document is also the proper preparation of the surfaces to be adhered.

1.2 Field of Application—This document will find application in the body repair shop, body customizing shop, car dealer preparation department, and the do-it-yourself enthusiast.

2. References

2.1 Applicable Publication—The following publication forms a part of the specification to the extent specified herein. Unless otherwise indicated the latest revision of SAE publications shall apply.

2.1.1 SAE PUBLICATION—Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001.

SAE J1344—Marking of Plastic Parts

3. Identification of the Various Accessories for the Body Exterior

3.1 There are a variety of components that are adhered to the exterior of the automobile. Each one serves either a decorative or a functional purpose (or both) that is desired for the automobile body.

- 3.2** The following is a listing of aftermarket components for attachment to the exterior body of an automobile or truck:

- Body Side Molding
- Deflectors, Bug
- Deflectors, Sun, Rear Window Pick-up and Car
- Deflectors, Sunroof Wind (acrylic)
- Door Edge Guards
- Grills
- Headlamp Covers
- Lock and Keyhole Anti-Chip Covers
- Logos, Emblems, and Medallions, Three-Dimensional
- Luggage and Deck Rack Center Strips
- Mirror Covers, Side-View
- Protectors, Side Cap for Pick-Ups
- Rocker Panel Claddings and Moldings
- Rocker Panel, PVC "Chrome" Moldings
- Rocker Panel, Stainless Steel Moldings
- Roof Drip Moldings
- Spoilers, Rear, on Pick-Up Tailgates
- Spoilers/Wings (supplemental to mechanical attachment)
- Step Shield Protectors
- Sun Visors, Acrylic
- Tail Light Covers
- Vent Visors (acrylic and stainless)
- Vents, Decorative
- Wheel Covers, Decorative Emblems
- Wheel Opening Molding
- Wind Deflectors, Rear (acrylic-style)

4. Identification of the Various Surfaces to be Adhered

- 4.1** Surfaces to be adhered can vary depending upon the material used to manufacture the aftermarket component. The exterior body surface of the automobile will be either bare metal (steel or aluminum), bare sheet-molded compound, or the paint used on these surfaces (either an acrylic, epoxy, polyester, polyurethane, or combinations of these.)
- 4.2** The aftermarket components usually are made from one of the following types of materials listed in Table 1. For plastic parts, the approved marking, or symbol, for the plastic is shown with the type of plastic.

5. Preparation of the Surface to be Adhered

- 5.1 Two-Part Adhesives**—All of the surfaces to be bonded should be cleaned thoroughly with a premium grade of solvent (white spirits or alcohol) or degreaser. No recycled products should be used as they tend to leave a residue on the cleaned surface after they evaporate. The surfaces of the parts to be bonded must be dry and free of dust and grease before bonding. If the parts are polyurethane and not primed, care must be taken to ensure that the manufacturer has removed the mold release. If this can not be determined, then clean all surfaces with soap and water first. Let dry. Roughen, or scuff, the bonding surfaces along the bond line, then wipe down all surfaces with a plastic prep or plastic adhesion promoter.

Mark exact outline of parts to be glued in the correct position on the vehicle with a water-soluble felt pen. This marking is used to align parts when bonding them later.