

# 97 Body Cavity Sealing and Undercoating

97 00 010	Body cavity sealing for entire car .....	97- 1
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Sealing Preparations

- Underside of car must be clean and dry.
  - If applicable, damaged PVC on underside including wheel housings and side panels must be repaired and treated with Tectyl.
- The thickness of undercoating should not exceed 250 µm (0.25 mm / 0.010").
- Check car for paint finish damage and damage from flying stones and, if applicable, repair after consulting the customer.
  - Sealing compounds and the car itself should have room temperature (approx. 20°C / 68°F).
  - Check spray pattern of guns and nozzles.
  - When drilling holes, dip the stepped drill bit in sealing compound to trap burrs.
  - Remove dripping sealing compound.
  - Insert plug dipped in Tectyl in all drilled holes after finishing sealing.
  - Spray engine sealing compound on engine and engine compartment to cover completely.
  - When repairing body parts damaged in an accident or replacing the car body, body cavity sealing must be carried out immediately after painting and before installation of attachments, equipment, trim, etc.. If repair welding seams and joints are only accessible from one side, the side which produces a cavity has to be treated with wax. The same is applicable for the rear side panels, above the wheel housings up to the roof joint, as well as doors especially in the upper corner areas.

Body cavity sealing performed after body repairs must be confirmed on the annual inspection sheets (Owner's Manual) !

Sealing Procedure on Lifting Platform

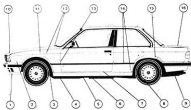
(vehicles protected with covers available from HWS)

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| 1. Front cross member, through openings on sides   | H or F      |
| 2. Side panels and wheel housings - front  | N or RS     |
| 3. Engine carrier over entire length   | N or RS     |
| 4. Front side panels in rear area from behind through provided holes                                   | N or RS     |
| 5. All reinforcement of floor assembly in front seat area through provided openings                    | N or RS     |
| 6. Door member at center from underneath   | N or RS     |
| 7. Doors twice each through provided holes as well as front door window frame at rear (plates removed) | T+N or F+RS |
| 8. Left and right rear spring mounts through provided openings   | N or RS     |
| 9. Side and cross members underneath trunk through provided openings                                   | N or RS     |

Sealing Procedure without Lifting Platform

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| 10. Braces of engine hood and all member sections of front panel through provided openings   | H or F      |
| 11. Spring strut peak reinforcement  | H or F      |
| 12. Wheel house braces / oval panel from underneath  | H+N or F+RS |
| 13. A pillar (door contact switches removed; cars with radio speakers removed)   | N or RS     |
| 14. Rear side panels and wheel housing through rubber rubbing strip openings (2-door cars) or door member/rear side panel joints (4-door cars) | N or RS     |
| 15. Rear side panels and wheel housings from trunk   | N or RS     |
| 16. Braces of trunk lid through provided openings  | H or F      |

H = Hook-type probe  
 N = Nylon probe  
 T = Door probe  
 RS = Round spray pattern slotted nozzle  
 F = Flat spray pattern nozzle



30, P 101

