

Annex 1

Flexible wheel arch extensions fitment guide using liquid adhesive**5 Bonding wheel arch extensions to the vehicle with liquid adhesive.**

- 5.1 Skip steps 3-4 and Familiarise yourself with your chosen adhesives clean up recommendations in case of accidental excess.
- 5.2 Gauge what size adhesive bead will be required to fill the void between the vehicle wheel arch and bonding faces of the extension, this will depend on the profile of the vehicle wheel arch but as a guide the bead size should be twice that of the void indicated by the grey arrows (FIG 10).
For example if the void is 4mm, the approximate bead size should be 8mm, we recommend using the smallest bead size possible to fill the void minimising excess.

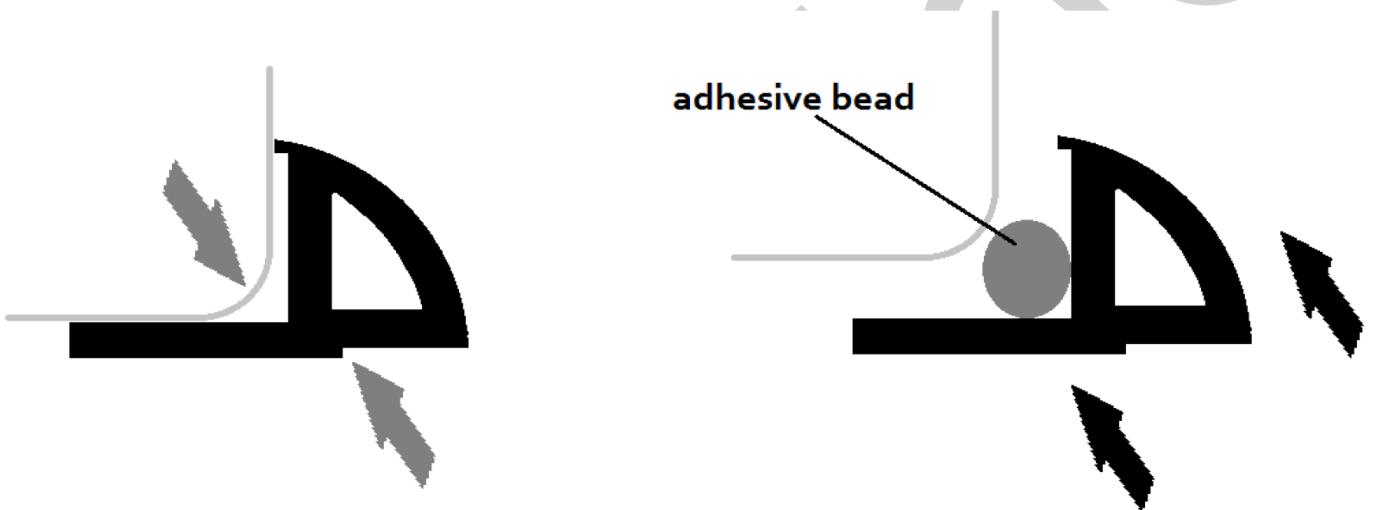


FIG 10

FIG 11

- 5.3 Lay each extension out on a clean flat surface and apply a continuous bead of adhesive to the inner corner of the inner bonding face (FIG 11), continue along the entire length.
- 5.4 Working at one end first, the extension should be offered up to the vehicle wheel arch as in steps 4.2 – 4.3, however it is recommended to offer up the extension in a diagonal plane as indicated by the black arrows (FIG 11) to allow the liquid adhesive to better flow into the join.
Support the first section with masking tape, then carefully work around the length approximately 6 inches at a time securing each section with additional masking tape taking care to not distort the extension, ensure the ends are securely supported with masking tape.
- 5.5 once the whole extension is secured in place, you can make any final adjustments depending on the drying time of your chosen adhesive, if some areas require more adhesive it's advisable to let the initial bond set (follow manufacturers recommendations) then add more adhesive later behind the extrusion using a small diameter nozzle.