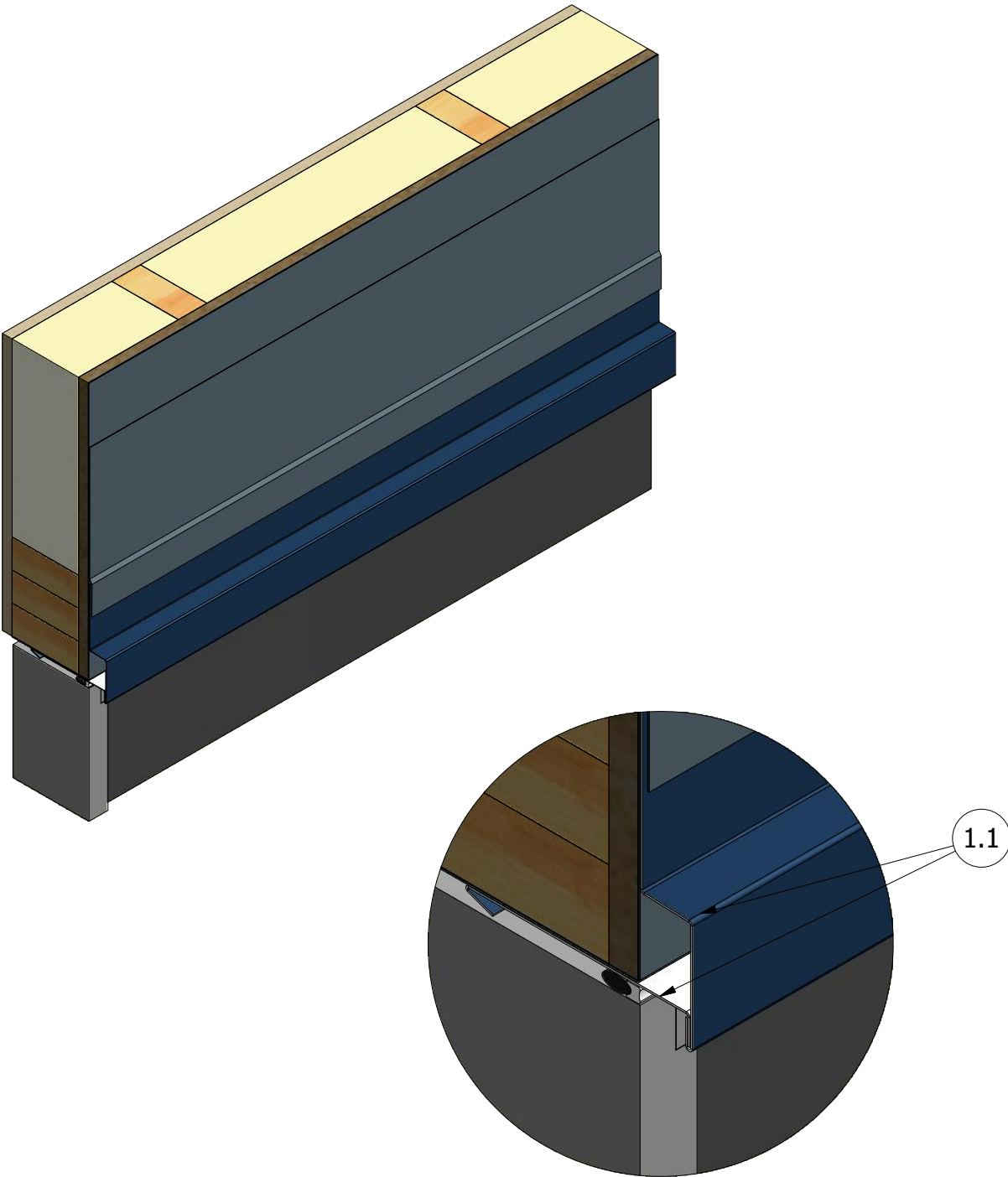


Step 1.1: Install All the Standard Head Trimming.

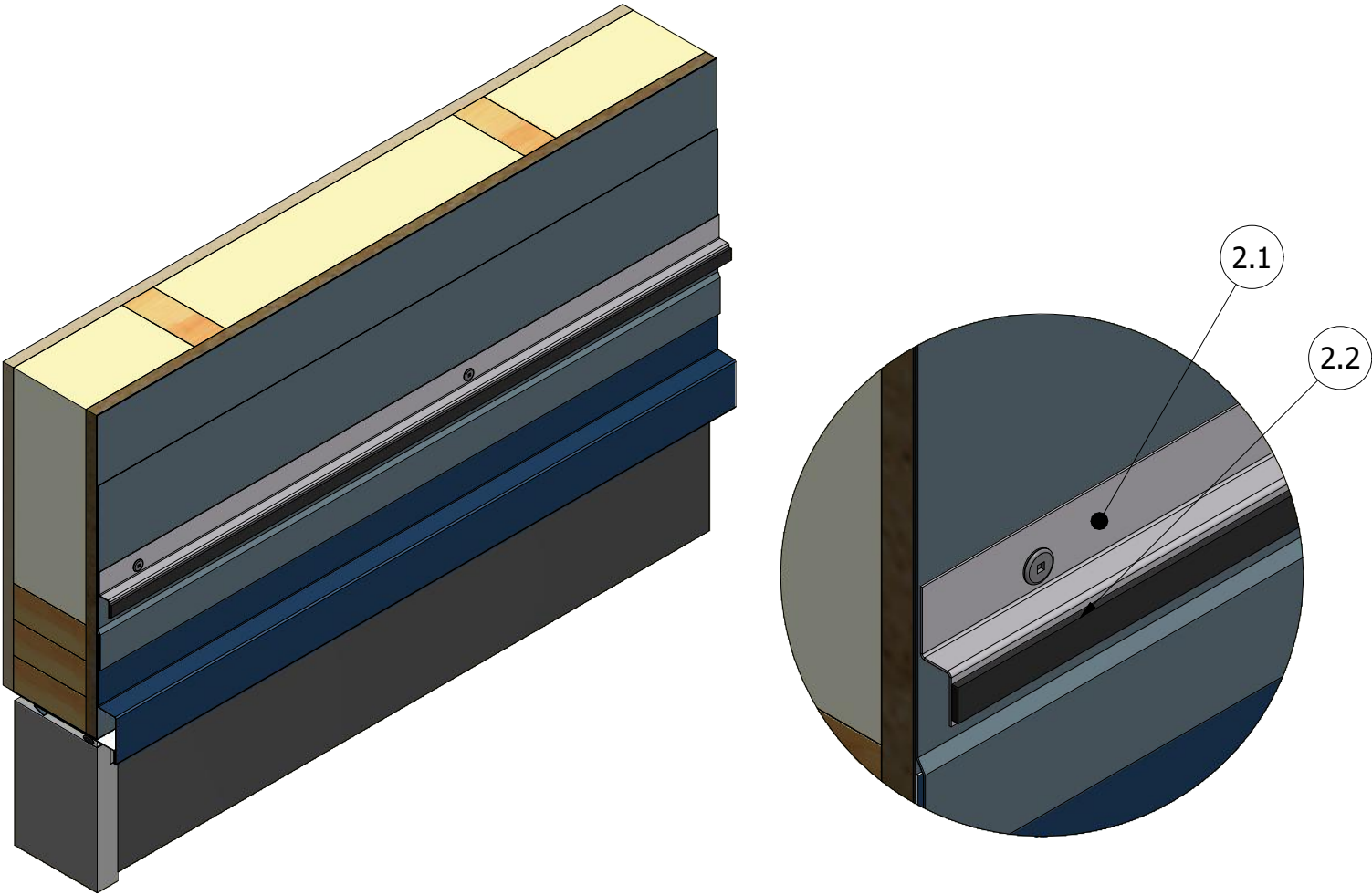



Step 2.1: Fasten Support Z in the Appropriate Area.
Step 2.2: Lightly abrade the surface that will receive the VHB Tape™ using a 3M™ Scotch-Brite® Hand Pads (7447 Maroon)
Step 2.3: Support Z Surface Should be Cleaned Using the Following Preparation Methods:

IPA/Water: Clean Surface with a 50:50 Mixture of Isopropyl Alcohol (IPA) and Water.

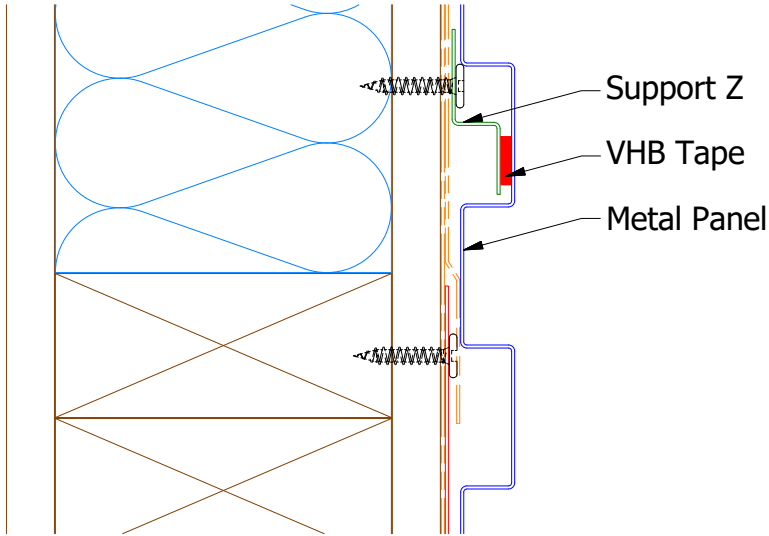
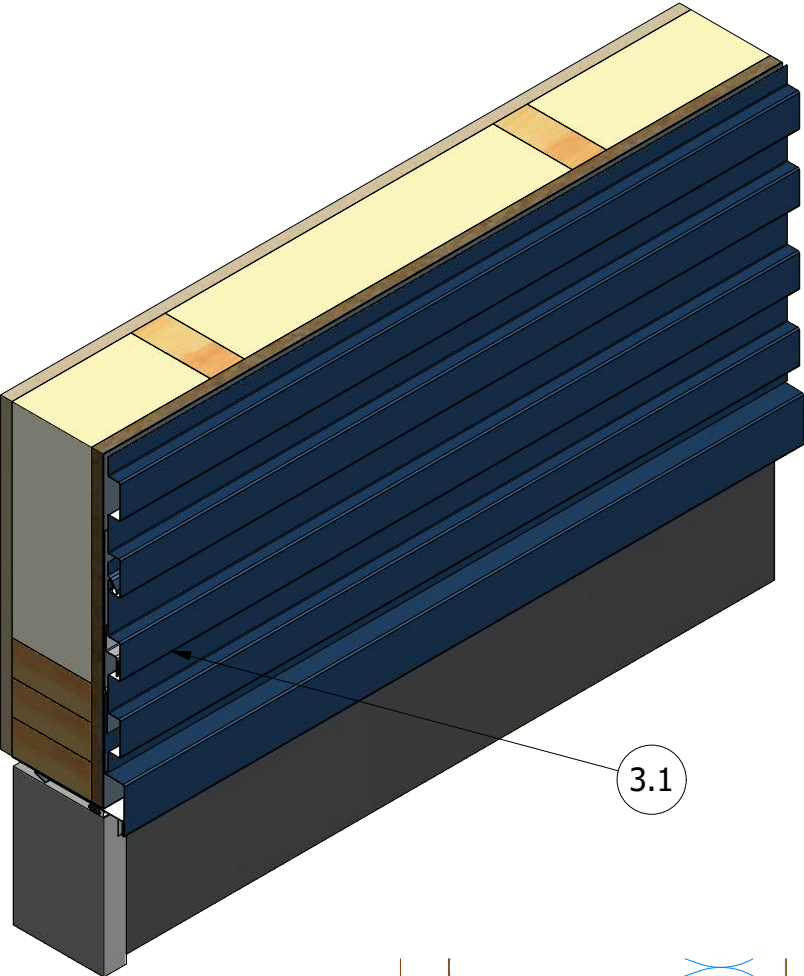
3M Adhesion Promoter 111 (AP111): Clean Surface with 50:50 IPA/Water Mixture Followed by Priming Surface with (AP111) Solution. Primer is Applied with a Clean Wetted Cloth and Allowed to Dry/ Evaporate Prior to Applying VHB Tape.

3M Primer 94 (P94): Clean Surface with 50:50 IPA/Water Mixture Followed by Priming Surface with (P94). Solution is Applied Wet and Allowed to Dry Without Wiping.

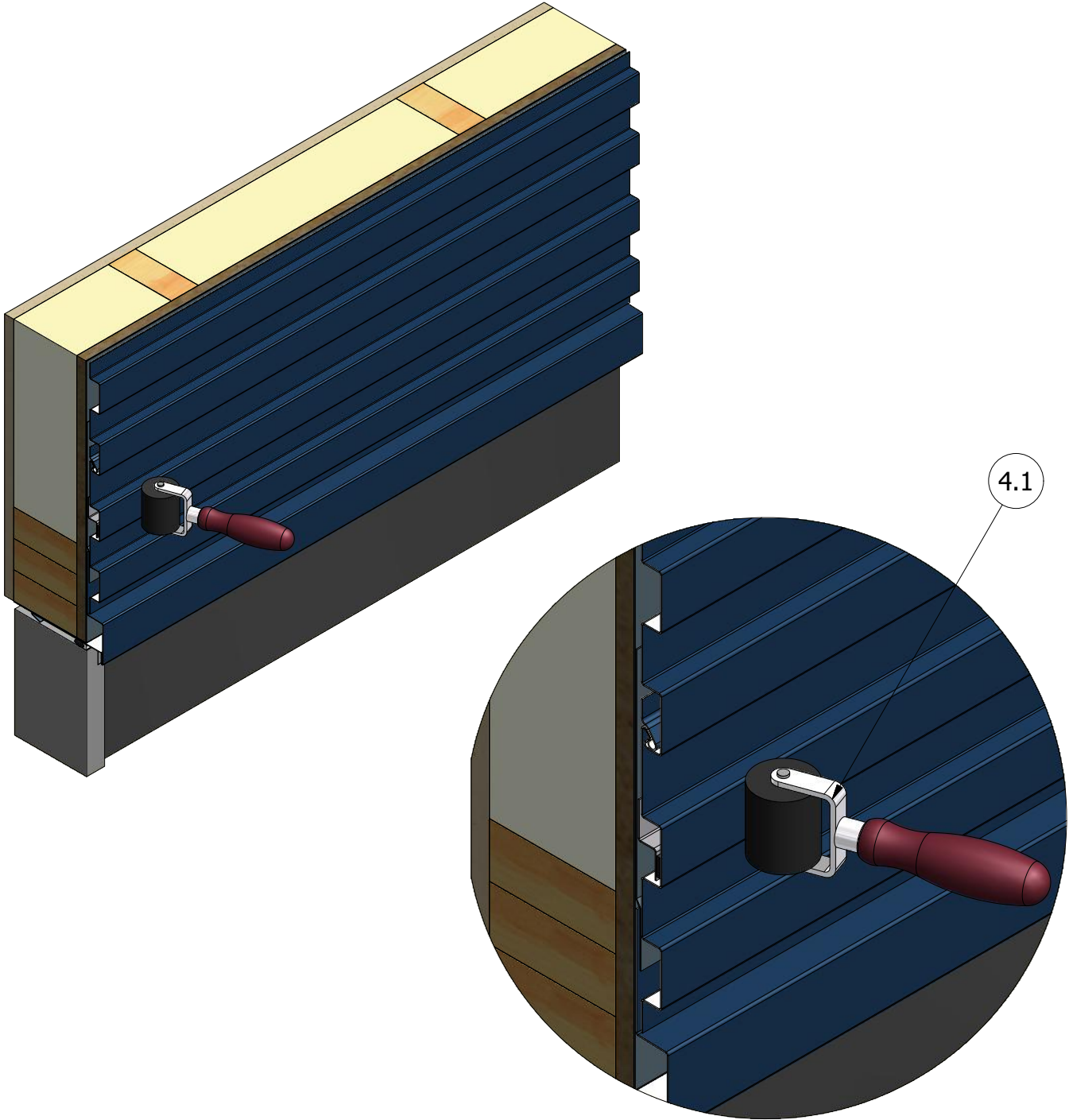


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				TITLE VHB Tape Installation Detail			
		DWG. NO.		DR	DMR	DATE	5/19/2021
01		10/3/2022		Updated Step 2 to Include Scotch-Brite		APP	DATE
REV. NO.	DATE	DESCRIPTION OF REVISION		BY	APP	SH. SIZE	B
						SCALE	X:X

Step 3.1: Clean Metal Panel Surface with Previously Mentioned Surface Preparation Methods and Install Metal Panel over Trimming and Sticking to the VHB Tape.



Step 4.1: Use a Roller to Compress and Fully Install Metal Panel to Support Z with VHB Tape.



				<div><div><div>ATAS</div><div>ATAS INTERNATIONAL, INC</div><div>Allentown PA</div><div>610-395-8445</div><div>Mesa AZ</div><div>480-558-7210</div></div></div>		
				TITLE VHB Tape Installation Detail		
REV. NO.		DATE	DESCRIPTION OF REVISION	BY	APP	
01		10/3/2022	Updated Step 2 to Include Scotch-Brite	KRK		
				DR	DMR	DATE 5/19/2021
				APP		DATE
				SH. SIZE	B	SCALE X:X