



**Technical Service
BULLETIN**

May 5, 2000

Title:

BLACKOUT TAPE APPLICATION

Models:

'00 ECHO

TSB

BODY
BO018-00

Introduction Blackout tape is used instead of black paint on the door sash of the 2000 ECHO. Please use the following instructions to apply blackout tape.

- Applicable Vehicles**
- **2000** model year **ECHO**

Parts Information

MODEL	PART NUMBER	PART NAME
4-Door	75921-52020	Blackout Tape, Front Door, RH
	75922-52020	Blackout Tape, Front Door LH
	75923-52010	Blackout Tape, Rear Door, RH
	75924-52010	Blackout Tape, Rear Door, LH
	75925-52010	Blackout Tape, Center Pillar, RH
	75926-52010	Blackout Tape, Center Pillar, LH
2-Door	PT211-5R001	Blackout Tape, RH (2 pieces)
	PT211-5L001	Blackout Tape, LH (2 pieces)

Required Tools & Material

TOOLS & MATERIALS	QUANTITY
Squeegee (3M PA-1 or equivalent)	1
Squeegee Sleeve (3M SA-1 or equivalent)	1
Spray Bottle	1
3M Prep Solvent 70	As Needed
Clothes Pin	As Needed
Lint Free Rags	As Needed
Flexible Sheet Magnet	As Needed
Mild Liquid Detergent (e.g. dishwashing soap)	As Needed

Warranty Information

OP CODE	DESCRIPTION	TIME	OPN	T1	T2
N/A	Not Applicable to Warranty	-	-	-	-



**2-DOOR
Blackout Tape
Application
Procedure**

A. Installation Temperature

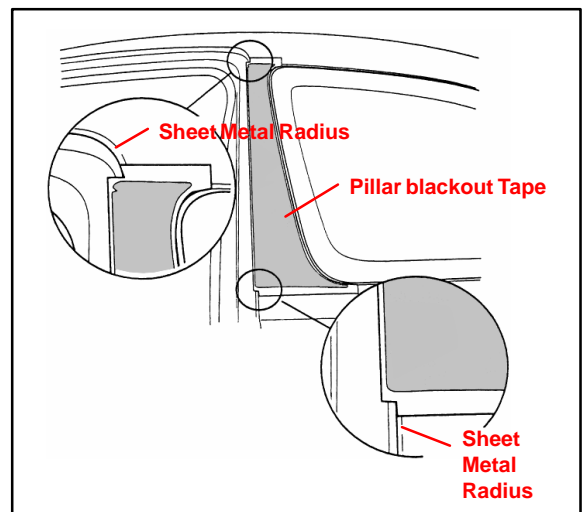
1. The temperature of the blackout tape and the vehicle must be between 60°F and 90°F for optimum installation.
2. The blackout tape should not be installed in direct sunlight or under windy conditions.

B. Clean the Vehicle Surface

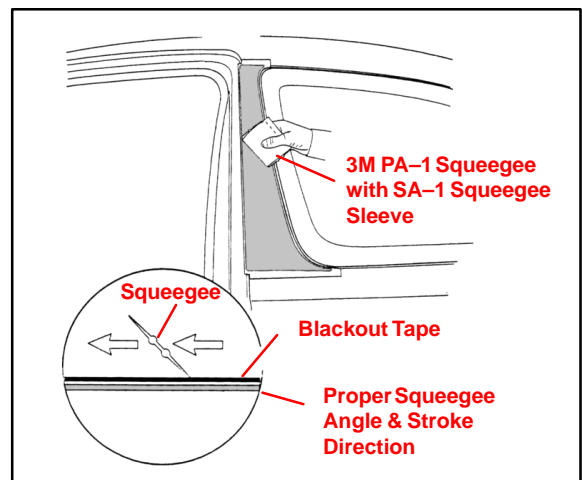
1. Clean the application area with 3M Prep Solvent 70 to remove grease and wax. Immediately dry the area using a clean, dry, lint free cloth.

C. Install the Blackout Tape

1. Using a solution of 1–2 drops of liquid detergent per one quart of water in a spray bottle, wet the installation area of the pillar and the door where the “Pillar” blackout tape is to be applied.
2. Open the door and carefully align the “Pillar” blackout tape in the proper position as shown in the illustration.

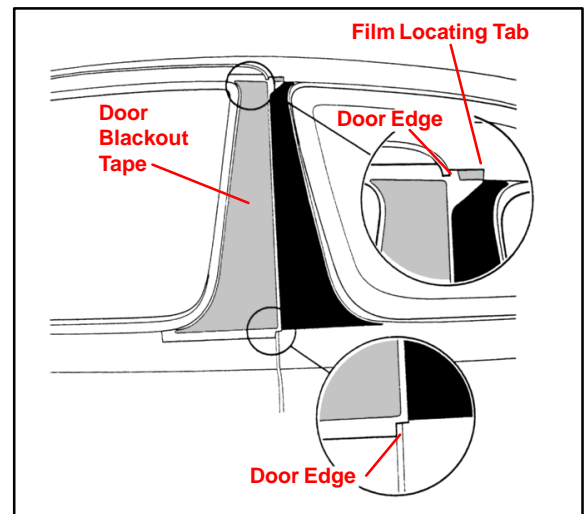


3. Squeegee the “Pillar” blackout tape to adhere it to the vehicle surface using firm overlapping squeegee strokes.
4. Remove the clear covering at a 180° angle to the installed part. If necessary, wet the covering with water to ease removal.
5. Use your finger or the squeegee to wrap the leading edge. Ensure that the leading edge of the tape is fully adhered to the front edge of the pillar.

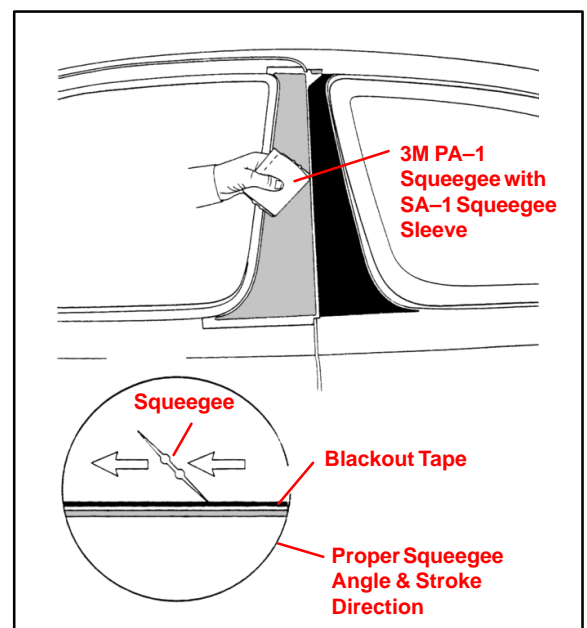


**2-DOOR
Blackout Tape
Application
Procedure**
(Continued)

6. Carefully align the “Door” blackout tape in the proper position as shown. Ensure that the “Door” blackout tape is properly aligned with the “Pillar” blackout tape using the film locating tab.



7. Prop the door open and squeegee the “Door” blackout tape to the vehicle surface using firm overlapping squeegee strokes.
8. Remove the clear covering at a 180° angle to the installed part. If necessary, wet the covering with water to ease removal.
9. Use your finger or the squeegee to wrap the trailing edge. Ensure that the trailing edge is fully adhered to the back of the door.
10. Repeat steps B-1 to C-9 for the opposite side of the vehicle.



4-DOOR Blackout Tape Application Procedure

A. Installation Temperature

1. The temperature of the blackout tape and the vehicle must be between 60°F and 90°F for optimum installation.
2. The blackout tape should not be installed in direct sunlight or under windy conditions.

B. Remove the Glass Run

C. Remove the Belt Molding

D. Remove the Window Frame Molding

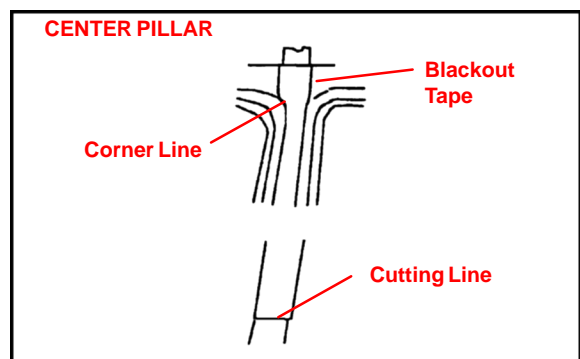
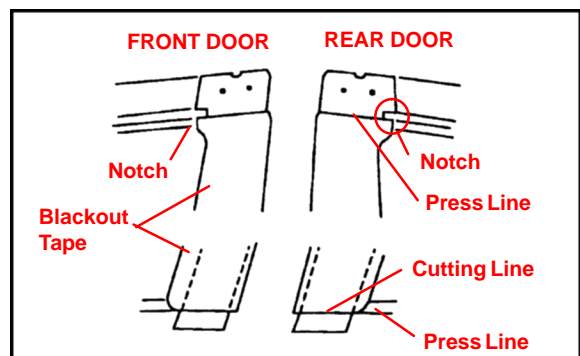
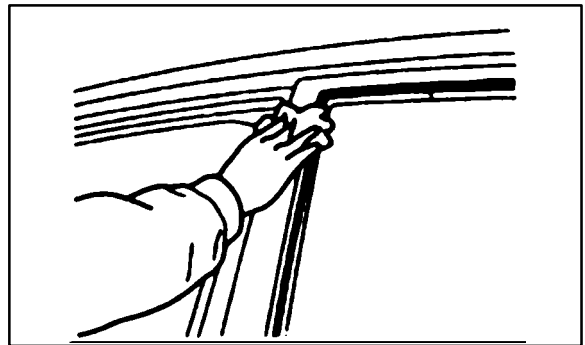
E. Remove the Door Glass

F. Clean the Vehicle Surface

Clean the application area with 3M Prep Solvent 70 to remove grease and wax. Immediately dry the area using a clean, dry, lint free cloth.

G. Install the Blackout Tape

1. Doors:
 - a. At the top of each door, align the notch in the tape with the press line of the sash as shown in the illustration. Hold the tape in place temporarily with a clothes pin at the top of the door.
 - b. At the bottom, align the cutting line at the opposite end of the tape with the press line of the door.
2. Center Pillar:
 - a. Align the curves in the tape with the corner line at the upper end of the pillar, as shown.
 - b. Align the cutting line at the other end of the tape with the press line at the bottom of the pillar.

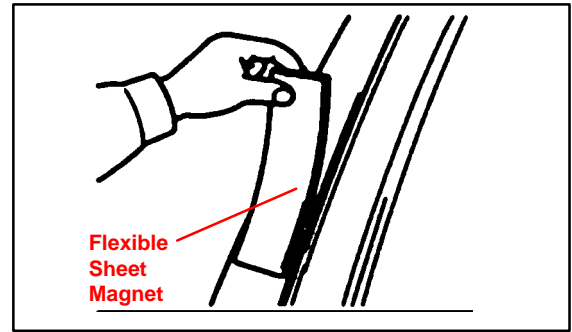


NOTE:

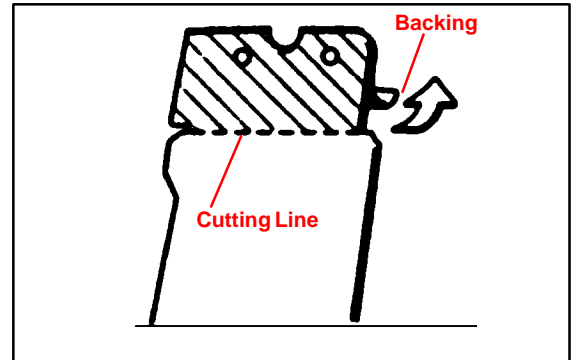
Fitting the tape in the correct place is important for appearance and to avoid wear. Assess the position accurately and be careful to fit the tape without moving it.

**4–DOOR
Blackout Tape
Application
Procedure
(Continued)**

3. Hold the blackout tape in place with a flexible sheet magnet.
 - a. After confirming that the position of the blackout tape is correct, attach a flexible sheet magnet to hold the tape more securely in place.
 - b. Remove the clothes pin.



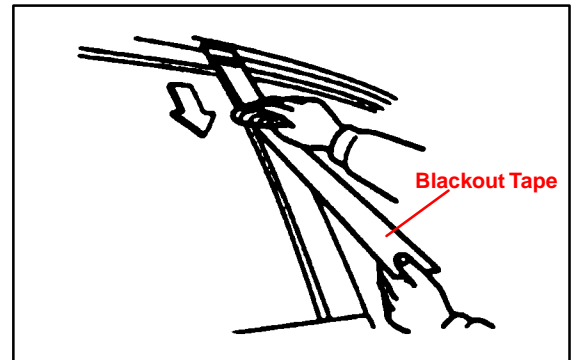
4. Apply the Blackout Tape.
 - a. Remove the tape backing at the top end of the blackout tape above the cutting line.
 - b. Attach the top of the tape first by applying gentle pressure (approximately 0.5 N [50 gf]) upward with your fingers or the squeegee.
 - c. Remove the magnet.
 - d. Hold the lower part of the blackout tape and slowly remove the remaining backing.



NOTE:

Hold the tape taut from the bottom, angled away from the vehicle. Be careful not to let it adhere to the door accidentally.

- e. Apply the tape with relatively strong pressure (30 N : 3 kgf) in a downward direction and at a constant speed (3–7 cm/sec).

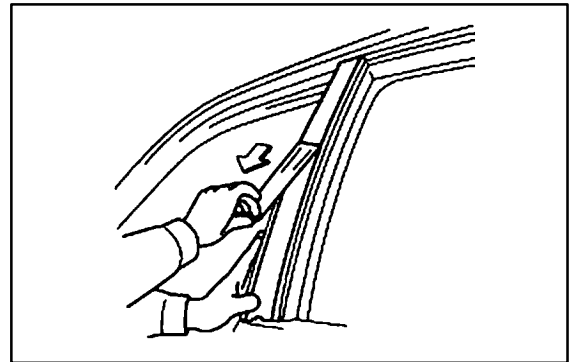


NOTE:

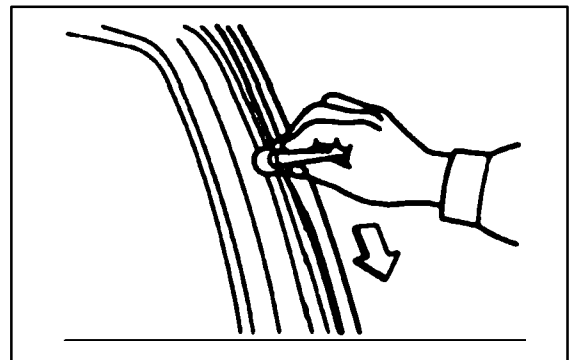
- To avoid the forming of air bubbles in the blackout tape, hold the squeegee at an angle away from the tape while applying steady pressure, as shown in the illustration.
- To avoid wrinkles, apply pressure at a constant speed, without stopping or going too fast.
- If the tape bends, or the application speed or pressure change, a vertical wrinkle called a shockline will occur. To prevent this, follow the hints above carefully.

**4-DOOR
Blackout Tape
Application
Procedure
(Continued)**

- f. Remove the clear covering, as shown in the illustration.



- g. Fold the blackout tape over the edge of the door, making sure the tape adheres to the back of the door using your fingers or the squeegee.



- h. Remove the top and bottom ends of the blackout tape at the cutting line.

- 5. Repeat steps B-1 through G-5 for the opposite side of the vehicle.

**Inspection
Procedures**

- 1. Check for the following:
 - a. Bubbles, wrinkles or shocklines.
 - b. Correct positioning at the folds and corners.
 - c. Loose edges.

NOTE:
Check the surface visually from several angles.

- 2. If there are bubbles smaller than 1 mm in diameter, flatten them by making a hole with a needle and applying pressure with your finger or the squeegee.

NOTE:
If there are shocklines or bubbles larger than 1 mm in diameter, or groups of smaller bubbles close together, the tape needs to be removed and reapplied.

