

## A. General

Clean all surfaces that are intended for being provided with a permanent underfloor protection on principle, mainly remove any wax and oil residues, and loose PVC particles – even at transitions to former permanent underfloor protection.

Following application of permanent underfloor protection, paint the areas within range of vision in the vehicle color – in galena grey within range of entrance.

In case of damage to the underfloor protection, grind the corroded spots to a bright finish, pretreat them with MB-2K primer and then coat them with bright MB permanent underfloor protection.

### Attention!

Do not spray permanent underfloor protection on individual units.

Following body repairs, seal weld seams and overlaps on underfloor prior to spraying permanent underfloor protection (97-400).

## B. Permanent underfloor protection material

### MB permanent underfloor protection – (synthetic rubber)

#### Processing data

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Container	one-way screw-type can at 1 liter, part no. 000 989 20 21
Color	light beige
Shelf life	approx. 6 months at 20 °C
Processing temperature	15–20 °C/59–68 °F
Spraying pressure	3.5–5 bar
Thickness of layer	0.8–1 mm dry film or approx. 2 mm wet film
Drying time	4–6 hours at 20 °C/68 °F 45 minutes at 80 °C/176 °F Top coat can be applied at end of drying period.
Dangerous materials class	A II
Solvent or cleaner	benzine

## Processing unit

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Spray gun for screw-type cans, e.g. Teroson record spray gun,  
item no. 106 84 N

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**Note:** The bright MB permanent underfloor protection is made on synthetic rubber basis and suitable for application on the underfloor, to the inner side of fenders as well as for sealing jobs. This material alone can be used at transitions to the PVC permanent underfloor protection applied ex factory.

## MB permanent underfloor protection (dispersion soluble in water)

### Processing data

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Container	one-way screw-type can at 1 kg each, part no. 001 986 46 10 canister at 30 kg each, part no. 001 986 01 10
Color	grey
Shelf life	6 months at 20 °C/68 °F. Protect against frost.
Processing temperature	approx. 20 °C/68 °F
Spraying pressure	3–4 bar
Thickness of layer	0.8–1 mm dry film or approx. 2 mm wet film
Drying time	up to 5 hours at approx. 20 °C/68 °F (depending on thickness of layer) 15–30 min at 70–80 °C/158–176 °F
Dangerous materials class	not applicable
Solvent or cleaner	water

### Processing equipment

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For 1-kg one-way screw can	spray gun for screw-type cans, e.g. Teroson-record- spray gun, item no. 106 84 N
For 30 kg canister	
a) Pressure vessel	paint pressure                      3–4 bar (at.) atomizer pressure                3–4 bar (at.) spray jet                                3–4 mm
	Hose dia. inside min. 20 mm
b) Airless unit	spray pressure                      100–250 bar (at.) spray jet                                0.4–0.6 mm

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**Note:** This material is not suited for sealing jobs at welding seams and overlaps as well as on transitions of the PVC permanent underfloor protection applied ex factory.

If the MB permanent underfloor protection is intended for application to the outer skin as well, dilute the material by 5 % of water in order to obtain better flow characteristics. MB permanent underfloor protection can be sanded wet after drying. It is particularly suited for the underfloor, the inner sides of fenders and the entrance range at the main floor.

The MB permanent underfloor protection quickly will get dry-struck to become a solvent-resistant film. For this reason, place the paint-spray gun into water during interruptions and at the end of the job performed. Prior to re-using, coat air cap with mineral oil in order to prevent the spray from drying out.

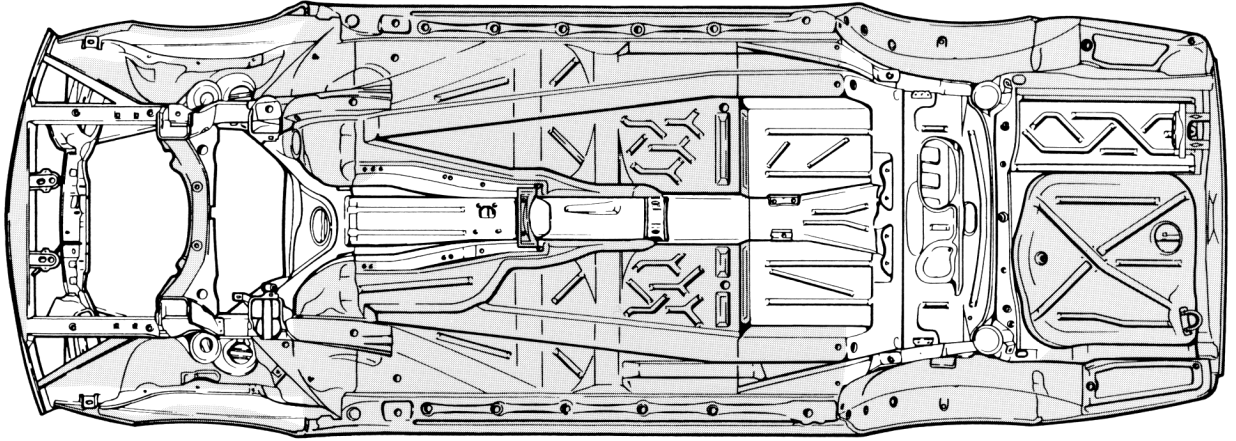
Spray can be removed from the body by means of a moist cloth, even after up to 10 minutes. If the drying time is still somewhat longer, add approx. 0.5 % of a dish washing agent. After approx. 1 hour, the spray can only be removed by sanding paper, grain P 1200, and subsequent polishing.

Clean the appliances used for this work with water after termination.

## C. Processing on body

### Sedan

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1973 - 12 909

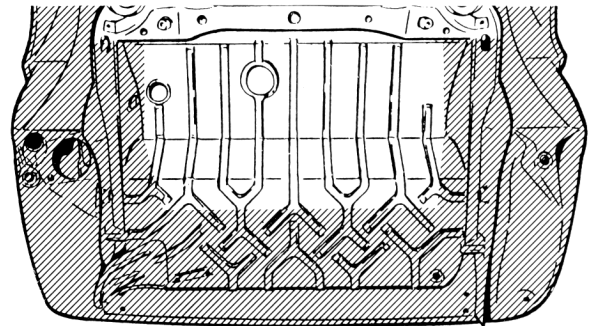
Bright range = coated  
Dark range = uncoated

**Note:** Do not coat fastening points for axle components, spring plate inside, bores for fastening steering gear and threads for fastening axle (dark range).

### T-sedan

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(ranges deviating from sedan)



1974 - 13760