



4960 SW 29<sup>th</sup> Way, Ft. Lauderdale, FL 33312  
Phone: 305-345-9444

### **Primary Insert Installation Guide**

- 1) Clean chrome primary cover insert area well with lacquer thinner to remove all grease, wax, oil, detailer spray, or polish. This is imperative to maintain the proper permanent bond of the adhesive. Final clean with 50/50 solution of rubbing alcohol and water. Clean powdercoated surfaces with straight alcohol and finish with 50/50 alcohol/water for final clean. \*SEE NOTE AT BOTTOM.
- 2) Remove backing CAREFULLY and slowly using the edge of a razor, razor knife, or Exacto knife to make sure you do not damage or touch the applied adhesive.
- 3) Carefully position your insert in the recessed area ('07 and earlier) or on the raised area ('08 and newer) on your primary cover (left side transmission cover). Press firmly in place.
- 4) NOTE: You only have one shot to get it placed properly as this adhesive bonds quickly and firmly and once in place will damage the adhesive if removed.
- 5) For the best bond we recommend to leave it overnight before riding.

\*NOTE: The use of adhesion promoter to prep the surface it's going on is not necessary, but it is highly recommended and it is readily found in any local auto parts store.

#### WARNINGS:

- 1) DO NOT TOUCH THE ADHESIVE AFTER REMOVING THE BACKING OR YOU MAY HAVE BONDING ISSUES AS OILS AND DIRT WILL SPOIL THE ADHESIVE.
- 2) DO NOT INSTALL AT TEMPERATURES BELOW 70 DEGREES OR PROPER ADHESION WILL NOT OCCUR.

*We do not warranty inserts for falling off is because we know the only way this special 3M adhesive will release is if the steps in the instructions were not carefully followed, meaning it was touched, or the surface is poorly prepped before installation.*