LORD Fusor® 108B/109B Metal Bonding Adhesive (Medium)

LORD Fusor® 108B/109B metal bonding adhesive is specified for use by General Motors, Ford Motor Company and Nissan. It can be used for panel bonding, weld bonding and rivet bonding of properly prepared metals, including aluminum.

Usage

Follow the vehicle manufacturer's guidelines regarding fastening of the replacement panel.

Metal Preparation

1. Grind the surface of all mating flanges (not greater than 1 inch [25.4 mm]) to which Fusor metal bonding adhesive will be applied. Make sure to remove any adhesive, e-coating, corrosion protection or galvanized coating. If metal has a pewter appearance, then not all of the galvanized coating has been removed. The metal should be shiny in appearance. If sectioning, the seam will need a 10° bevel for a smooth transition into the existing panel (see Illustration A).
2. Pre-fit the new panel to ensure proper alignment.

Product Preparation

1. Insert the Fusor two-component adhesive cartridge into the dispensing gun.
2. Squeeze a small amount of Fusor metal bonding adhesive from each side of the cartridge. This will level the plungers and ensure that adhesive is coming out of both sides of the cartridge.
3. Attach the mixing tip and dispense a small amount of material to verify that the adhesive is evenly mixed and that the color is consistent.

Application

1. Apply a 3/8 to 1/2 inch (9.5 to 12.7 mm) bead of Fusor metal bonding adhesive to the prepared mating surfaces (see Illustration B).
2. Secure the panel using clamps. The glass beads in the adhesive will prevent over clamping. Apply screws or rivets in hard-to-clamp areas. After the panel has been positioned, do not pull it away from the vehicle. If repositioning is necessary, slide the panels against one another. This maintains contact between the two surfaces.
3. Allow adhesive to cure 1-1/2 to 2 hours before unclamping. Remove all excess adhesive from the sectioned area. It is critical to check the sectioned area for a smooth transition to prevent ghost-lines after painting. If necessary, additional grinding can be done to ensure a smooth seam. Skim-coat the section seam with a fiber-filled body filler, rough sand, and blend with a conventional body filler. Wait 8 hours before painting and baking.
4. The adhesive will be a little "tacky" on the surface after full cure. This is a normal property of the adhesive.

Technical Data

Work Time	40-50 minutes @ 70°F (21°C)
Clamp Time	1.5-2 hours @ 70°F (21°C)
Full Cure	3-4 hours @ 70°F (21°C)
Lap Shear Strength (ASTM D 1002)	
Cold Rolled Steel	2250 psi (15.5 MPa) cohesive failure
Aluminum	2150 psi (14.8 MPa) cohesive failure
Torsional Impact Resistance (GM 9751 P)	
Cold Rolled Steel	>106 in-lb (>11.98 N-m) No adhesive failure
Aluminum	>106 in-lb (>11.98 N-m) No adhesive failure

Cautionary Information

Before using this or any LORD product, refer to the Material Safety Data Sheet (MSDS) and label for safe use and handling instructions.

For industrial/commercial use only. Must be applied by trained personnel only. Not to be used in household applications. Not for consumer use.

Illustration A

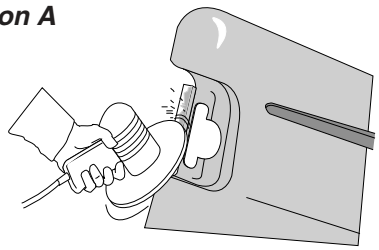
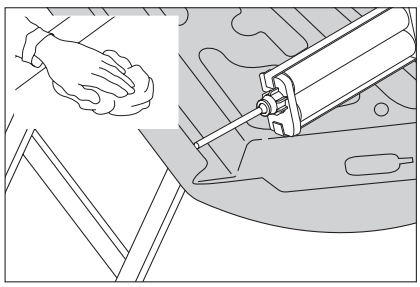


Illustration B



LORD Ask Us How™

LORD Fusor® Repair Products Lifetime Guarantee*

LORD Corporation guarantees to the installer that LORD Fusor® Repair Products (adhesives, primers, seam sealers and foams only), when used in strict accordance with LORD Corporation's application and use instructions, will provide a durable bond for the life of the vehicle. This guarantee, subject to the terms and conditions stated herein, covers actual costs incurred by the installer for labor, replacement parts and materials to replace the bonded metal components of the vehicle. THIS GUARANTEE IS NOT APPLICABLE TO APPLICATION EQUIPMENT, INCLUDING BUT NOT LIMITED TO DISPENSING EQUIPMENT, CARTRIDGE TIPS AND ACCESSORIES.

THIS EXPRESS WARRANTY IS MADE IN LIEU OF AND EXCLUDES ANY AND ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, BY OPERATION OF LAW OR OTHERWISE, INCLUDING THE IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.

LORD Corporation shall not be liable under any circumstance for any liability, loss, damage or expense directly or indirectly arising from the application and use of LORD Fusor Products sold hereunder or from any other cause. LORD Corporation shall not be liable under any circumstances for consequential, indirect or special damages. **LORD CORPORATION'S LIABILITY FOR BREACH OF WARRANTY HEREUNDER IS IN ALL INSTANCES LIMITED SOLELY AND EXCLUSIVELY TO THE REASONABLE COSTS OF REPAIR AND/OR REPLACEMENT OF THE BONDED METAL COMPONENTS OF THE VEHICLE.**

This guarantee shall only apply to the above referenced LORD Fusor products sold by LORD Corporation on or after January 1, 2001.

LORD Fusor Metal Bonding Adhesives shall only be used for the adhesive-only bonding (no welds or rivets) of metal to metal assemblies (steel or aluminum) in full or partial panel replacements of door skins, roof skins, quarter panels, rear body panels and other outer body sheet metal.

LORD Fusor products shall not be used for adhesive-only bonding of any structural component unless specifically recommended by the vehicle manufacturer. Structural panels must be replaced in strict compliance with vehicle manufacturer guidelines. If in doubt as to what is a structural component or the proper installation method, contact the vehicle manufacturer. Further, any LORD Fusor products used in marine composite repair, such as with personal water craft and the like, shall be limited to repairs above the water line.

If you have any questions or need to receive proper use instructions, contact the LORD Customer Support Center at +1 800 234 Fusor (3876) or visit Fusor.com.

To comply with the requirements of the LORD Fusor Repair Products Lifetime Guarantee, attach a copy of this completed page to the repair record, and retain with your files:

Vehicle Make/Model: _____

Vehicle Identification Number: _____

LORD Fusor Product(s) Used for Repair: _____

Lot Number(s) on Cartridge(s) Used for Repair: _____

**This guarantee is void if product is used after the date printed on the cartridge label. LORD Terms and Conditions of Sale shall apply to all sales of LORD Fusor products.*

I-CAR® INDUSTRY TRAINING ALLIANCE™

ASE Continuing Automotive Service Education CERTIFIED TRAINING PROVIDER

Instructions contained in this document need to be followed to qualify for the LORD Fusor Lifetime Guarantee. Values stated in these instructions represent typical values as not all tests are run on each lot of material produced. For formalized product specifications for specific product end uses, contact the Customer Support Center.

Information provided herein is based upon tests believed to be reliable. In as much as LORD Corporation has no control over the manner in which others may use this information, it does not guarantee the results to be obtained. In addition, LORD Corporation does not guarantee the performance of the product or the results obtained from the use of the product or this information where the product has been repackaged by any third party, including but not limited to any product end-user. Nor does the company make any express or implied warranty of merchantability or fitness for a particular purpose concerning the effects or results of such use.

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LORD provides valuable expertise in adhesives and coatings, vibration and motion control, and magnetically responsive technologies. Our people work in collaboration with our customers to help them increase the value of their products. Innovative and responsive in an ever-changing marketplace, we are focused on providing solutions for our customers worldwide ... Ask Us How.

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