

## LORD Fusor® 180/181/182 Clear Double-Sided Tape

LORD Fusor® 180/181/182 clear double-sided tape can be used to bond a variety of automotive substrates including many plastics, composites, sealed wood and painted metals. When used with LORD Fusor 602EZ plastic surface modifier, LORD Fusor 180/181/182 double-sided tape will also bond low surface energy materials such as TPO, polypropylene and vinyl.

### Usage

#### Surface Preparation

1. Clean the areas to be bonded with isopropyl alcohol (IPA) or LORD Fusor plastic & rubber cleaner (Stock #703).
2. Scuff-sand the bond areas with 180-grit sandpaper or a red scuff pad.
3. Wipe bond areas with a clean dry rag. Ensure part(s) and body panel are thoroughly dry.

Note: For optimum adhesion, temperature of substrates should be between 50-100°F (10-38°C) at time of product applications.

4. If required, apply a light coat of LORD Fusor plastic surface modifier (Stock #602EZ) to the bond areas. Allow to dry for approximately 15 minutes.

#### Application

1. Apply LORD Fusor double-sided tape to the loose part(s) to be installed.
2. Remove the protective polyethylene backing from the tape immediately prior to installing the part. Be careful not to contaminate the adhesive surface.
3. Ensure the part is properly aligned to the body panel. Masking tape can be used a guide along the length of the panel edge.
4. Install the taped part to the body panel. Maintain uniform application pressure (15 pounds per inch of tape width) to achieve maximum bond strength and avoid entrapping air between the tape and substrates.

### Technical Data

|   |      |
|---|------|
| Work Time, minutes @ 70°F (21°C)          | 5    |
| Full Cure Strength, hours @ 70°F (21°C)   | 24   |
| Handling Strength, minutes @ 70°F (21°C)  | 15   |
| Peel Adhesion Test*, lb (N) @ Room Temp   |      |
| 24 hours                                  | 7.6  |
| 72 hours                                  | 16.7 |
| 72 hours after 25 minutes @ 300°F (149°C) | 14.1 |

\*Tested with Fusor 181 tape (1/2" width).

### 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.

# LORD USER INSTRUCTIONS

## LORD Fusor Repair Products Lifetime Guarantee\*

LORD Corporation guarantees to the original purchaser 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 covers actual costs incurred by the installer for labor, replacement parts and materials, and for the reasonable cost of loss of use of the vehicle during the period of replacement. 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 loss, damage, or expense directly or indirectly arising from the application and use of LORD Fusor Products sold hereunder or from any other cause, and LORD Corporation shall not be liable under any circumstances for consequential or incidental 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 Lifetime Guarantee shall only apply to the above listed LORD Fusor products sold by LORD Corporation on or after January 1, 2001.

LORD Fusor Metal Bonding Adhesives shall only be used for bonding metal to metal (steel or aluminum) in full or partial panel replacements of:

- door skins
- roof skins
- other outer body sheet metal
- quarter panels
- rear body panels

LORD Fusor products SHALL NOT be used for bonding structural components such as rails, pillars, rocker panels, core supports, etc. If in doubt as to what is a structural component, contact the vehicle manufacturer. If you have any questions or need to receive proper use instructions, contact the LORD Customer Support Center at +1 877 ASK LORD (275 5673) or visit [www.lord.com](http://www.lord.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 adhesive is used after the date printed on the cartridge label.*



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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For a listing of our worldwide locations, visit [LORD.com/locations](http://LORD.com/locations).