Procedure for Installation of Spare Tire Hump to Decklid using LORD Fusor® Adhesives

Materials Needed:

- LORD Fusor 703 Plastic & Rubber Cleaner
- LORD Fusor 120/T20/T21 SMC Repair Adhesive (Slow) or LORD Fusor 127EZ/128EZ Plastic Bonding Adhesive (Slow)
- LORD Fusor 301 Manual Dispensing Gun, or LORD Fusor 303 or 304X Pneumatic Dispensing Gun
- LORD Fusor 702 Fiberglass Cloth
- LORD Fusor 100EZ/101EZ Plastic Panel Repair Adhesive (Heat Set)
- LORD Fusor 704 Saturation Roller

Alignment and Preparation of Hump & Decklid

1. The hump and decklid should be at room temperature (65-75°F [18-24°C]) and dry before repair work begins.
2. Thoroughly clean both sides of the hump panel and the metal decklid with LORD Fusor® plastic & rubber cleaner before sanding.
3. Drill a 1 inch (25.4 mm) vent hole in the center of the decklid where the hump will be installed. Treat all bare metal with a rust inhibitor.
4. Align hump in center of decklid. Every 6 inches (152.4 mm) drill 1/8-inch (3.2-mm) alignment holes around entire hump, about 1/2 inches (12.7 mm) from hump edge. These holes will be used to secure hump uniformly until adhesive is completely cured.

Attachment of Hump to Decklid

1. Pre-bevel the outer edges of the hump to a 20-degree angle where it will bond to the decklid.

Note: Edges should be rounded back, leaving no sharp edges.

2. Scuff the paint on the decklid with 220-grit sandpaper where the hump will attach to the decklid.
3. Blow all sanded areas with an air gun. Be sure that the air does not have any oil or water in it. Do not use a cleaner after sanding.
4. Insert the LORD Fusor SMC repair adhesive cartridge (Stock #120/T20/T21) or LORD Fusor plastic bonding adhesive cartridge (Stock #127EZ/128EZ) into the appropriate dispensing gun. Squeeze a small amount of the adhesive from each side of the cartridge to level the plungers. Attach a mixing tip and dispense a small amount of adhesive, which is about the length and width of the mixer. Dispense until the product is evenly mixed and the color is consistent.
5. Apply a 3/8-inch (9.5-mm) bead of adhesive to the perimeter of the hump.
6. Place hump on deck. Align with pre-drilled screw holes and tighten in place.

Note: Use even pressure; do not over tighten screws.

7. With a dry rag, wipe off excess adhesive that squeezed out of the panels.
8. If LORD Fusor SMC repair adhesive (Stock #120/T20/T21) was used, heat cure at 180°F (82°C) for 1 hour or cure at room temperature for 24 hours. If LORD Fusor plastic bonding adhesive (Stock #127EZ/128EZ) was used, heat cure at 140°F (60°C) for 30 minutes or cure at room temperature for 24 hours.
9. Remove screws after adhesive is fully cured.

Finishing the Cosmetic Edge

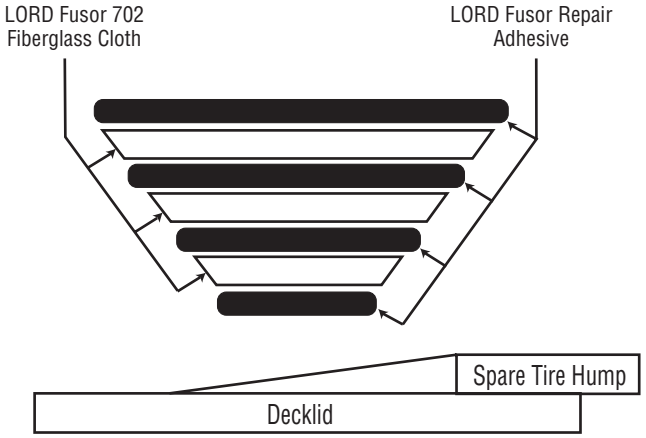
1. Sand the prepared area with a DA sander or by hand-sanding with 80-grit sandpaper.
2. Build a "pyramid patch" using LORD Fusor fiberglass cloth (Stock #702) and LORD Fusor SMC repair adhesive (Stock #120/T20/T21) or LORD Fusor plastic panel repair adhesive (Stock #100EZ/101EZ) **(see Illustration A)**.

Note: The use of the fiberglass cloth is critical to control the expansion and contraction in hot and cold weather. This will control visible "bull's-eyes" and "readthrough" in the finished repair, and provide a high-quality repair with maximum strength characteristics.

3. Start by removing the LORD Fusor fiberglass cloth (Stock #702) from the plastic film backing. Set aside the plastic film backing for use in Step #5. Cut a layer of the fiberglass cloth slightly smaller than the perimeter of the repair area. Cut two or more additional layers of fiberglass cloth, each being slightly smaller than the previous one.

Note: It is important to work as much fiberglass cloth into the repair as possible while attaining a thickness similar to the original panel.

Illustration A



Note: Not drawn to scale.

4. Insert the LORD Fusor SMC repair adhesive cartridge (Stock #120/T20/T21) or LORD Fusor plastic panel repair adhesive cartridge (Stock #100EZ/101EZ) into the appropriate dispensing gun. Squeeze a small amount of product from each side of the cartridge to level the plungers. Attach a mixing tip and dispense a small amount of adhesive, which is about the length and width of the mixer. Dispense until the product is evenly mixed and the color is consistent.
5. Apply the adhesive to the lap joint of the decklid and smooth using a plastic spreader. Spread the adhesive evenly from the center toward the sides. Place the smallest piece of fiberglass cloth onto the adhesive and use a plastic spreader to saturate the cloth with adhesive. Apply a thin coat of the adhesive to this layer of fiberglass cloth. Smooth with a plastic spreader. Continue to apply at least two subsequent layers of cloth and adhesive. Place the plastic film backing over the repair and level the adhesive by rolling with the LORD Fusor saturation roller (Stock #704). Initially, roll from the center toward the sides to eliminate air pockets and pin holes, and improve overall adhesion.
6. Heat the pyramid patch repair with a heat gun or heat lamp for 5-10 minutes at 180°F (82°C) or until the material sets.
7. After the repair cools, remove the plastic film backing and rough-grind to remove all excess adhesive. Sand the repair with 80-grit sandpaper, making sure to cut slightly below the SMC-finished surface. This will allow for application of a thin, smooth final coat of adhesive.
8. Apply the finish coat of LORD Fusor plastic panel repair adhesive (Stock #100EZ/101EZ). Rough-spread the adhesive. Then, to help force trapped air bubbles to the surface, slightly warm this final coat of adhesive with a heat gun. The heat allows for even pull with limited drag on the plastic spreader.

Note: Be careful not to overheat or heat too long, as this will cure the adhesive before final smoothing.

9. To ensure a high-quality repair, heat cure the entire repair for one hour at 180°F (82°C) using a heat lamp.

Note: This final heat cure will bring the plastic and adhesive up to the maximum temperature generally experienced in a bake oven or under unusual weather conditions. This step ensures total shrinkage with no "bull's-eyes."

10. Cool the repair to room temperature. Feather- and contour-sand the repair with 80-grit sandpaper. Finish-sand using 180- and 220-grit sandpaper. In the event that pin holes exist, apply more adhesive. Work it into the pin holes with a plastic spreader and heat until cured. Finish-sand again. Prime and paint per manufacturer's recommendations.

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