

# Quarter and Rear Panel Installation using LORD Fusor<sup>®</sup> Adhesives

## Materials Needed:

- LORD Fusor 108B/109B Metal Bonding Adhesive (Medium) or LORD Fusor 112B/113B Metal Bonding Adhesive (Slow)
- LORD Fusor 123/126 Non-Sag Seam Sealer (Fast), or LORD Fusor 123EZ/126EZ Non-Sag Seam Sealer (Medium), or LORD Fusor 800EZ/801EZ/803EZ Factory Match Urethane Sealer/Adhesive
- LORD Fusor 300 or 301 Manual Dispensing Gun, or LORD Fusor 304 or 304X Pneumatic Dispensing Gun

Both LORD Fusor<sup>®</sup> 108B/109B and 112B/113B metal bonding adhesives are recommended for quarter panel and rear body panels, depending on temperature and work time needed. For this repair procedure, LORD Fusor 108B/109B metal bonding adhesive will be used.

## Surface Preparation

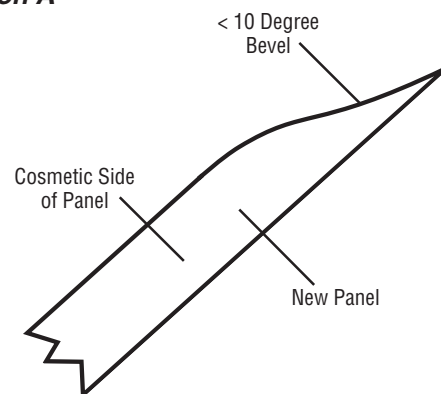
1. Straighten the uni-body on a frame machine to manufacturer's specifications.
2. Once the damaged vehicle has been straightened, remove the damaged panels with an air saw or air chisel. Remove only the large portions, making sure not to cut into the mating flanges or adjacent parts.
3. Using a spot-weld cutter, drill out the spot welds and remove the remaining weld flanges of the panel to be replaced.
4. Pay special attention to preparing any damaged flanges on the vehicle. Straighten these flanges using a hammer and a dolly.
5. Grind the mating surface of the original flanges (not greater than 1 inch [25.4 mm]), being sure to remove any adhesive, e-coating, corrosion protection or galvanized coating. If the metal has a pewter appearance, then all of the galvanized coating has not been removed. The metal should be shiny in appearance. Be careful not to damage the corners or thin the metal.
6. Carefully grind the entire outer edges of the new panel to which LORD Fusor metal bonding adhesive (Stock #108B/109B) will be applied, making sure to remove any e-coat, paint or galvanized coatings as described in Step #5.
7. Pre-bevel to <10 degrees any edges of the new panel where a finished section joint is needed (**see Illustration A**).
8. Ensure that the vehicle is evenly supported at normal suspension points.
9. Pre-fit all parts to ensure proper alignment.

## Adhesive Preparation

1. Insert the LORD Fusor metal bonding adhesive cartridge (Stock #108B/109B) into the dispensing gun. Squeeze a small amount of product from each side of the cartridge to level the plungers.
2. 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.

**Note: From this point you will have about 40-50 minutes at 70°F (21°C) to apply the adhesive and assemble the components.**

### Illustration A

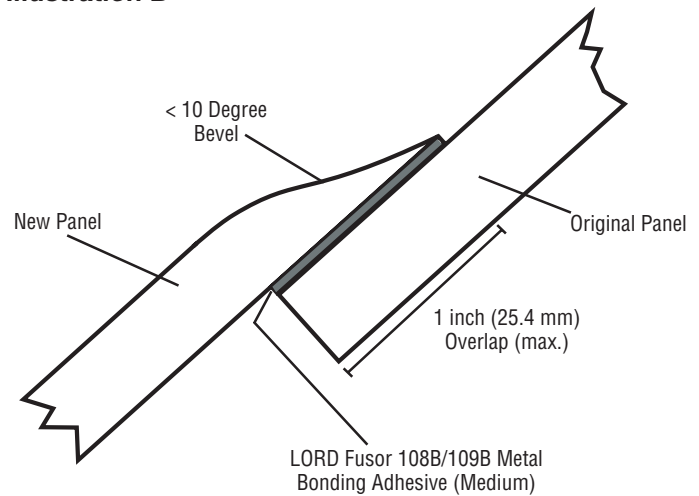


*Note: Not drawn to scale.*

## Panel Installation

1. Apply a 3/8 to 1/2 inch (9.5 to 12.7 mm) bead of LORD Fusor metal bonding adhesive to the bare metal mating surfaces.
2. Properly position the new panel. Once the panel has been positioned, do not pull it away from the vehicle. If repositioning is necessary, slide the panel. This maintains proper contact between the two panels.
3. Clamp tightly and evenly. The glass beads in the adhesive will prevent you from over clamping the bondline. Apply screws in hard-to-clamp areas. Where possible, wipe excess adhesive from panel before it cures. This will save you time later.
4. Allow the adhesive to cure for 1-1/2 to 2 hours. Expect the adhesive to be a little "tacky" on the surface as this is a normal property of the adhesive.
5. Remove clamps and screws. All excess adhesive must be removed from the section repair area.
6. Ensure that the edge of the overlapped metal panel has been beveled to <10 degrees with 36- or 40-grit grinding disks before using filler over the seam. It is important to taper and bevel the edges of the overlapped panel so that there is a smooth transition **(see Illustration B)**.
7. Finish with fiber-filled body filler on the section seam, and then complete the repair with conventional body filler. Cure and sand the filler. Prime and paint per manufacturer's recommendations.
8. Use LORD Fusor non-sag seam sealer (Stock #123/126 or #123EZ/126EZ) or LORD Fusor factory match urethane sealer/adhesive (Stock #800EZ/801EZ/803EZ) wherever a cosmetic seam sealer is required.

**Illustration B**



*Note: Not drawn to scale.*

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