

# Procedure for Bonding Sectioning Joints with Overlap Technique using LORD Fusor® 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® 108B/109B and 112B/113B metal bonding adhesives are recommended for body panel bonding, depending on temperature and work time needed. For this repair procedure, LORD Fusor 108B/109B metal bonding adhesive will be used.

## Panel Sectioning

1. Follow all the steps in this repair procedure for installing panels.
2. Grind a 1 inch (25.4 mm) area of the outer surface of the original panel to remove any primer, 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.
3. At the section joint edge of the new panel, grind a 1 inch (25.4 mm) area of the back side of the original panel to remove any primer, e-coating, corrosion protection or galvanized coating that may be present. Be careful not to damage the corners or thin the metal.
4. Pre-bevel to <10 degrees the outer side of the section joint edge of the new panel (**see Illustration A**).

5. Ensure that the vehicle is evenly supported at normal suspension points.
6. Pre-fit the new panel to ensure proper alignment.

## Adhesive Preparation

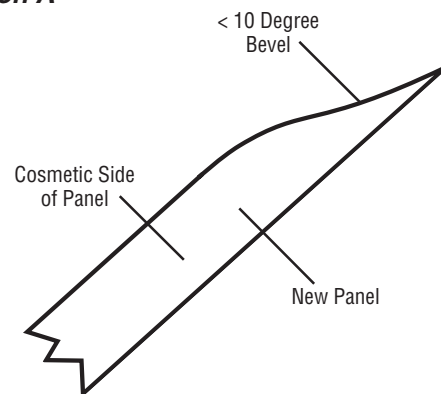
1. Insert the LORD Fusor metal bonding adhesive cartridge (Stock #108B/109B) into the dispensing gun. Squeeze a small amount of product from each side of the cartridge to level the plungers.
2. Attach a mixing tip and dispense a small amount of adhesive, which is about the length and width of the mixer. 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.**

## 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.

**Illustration A**

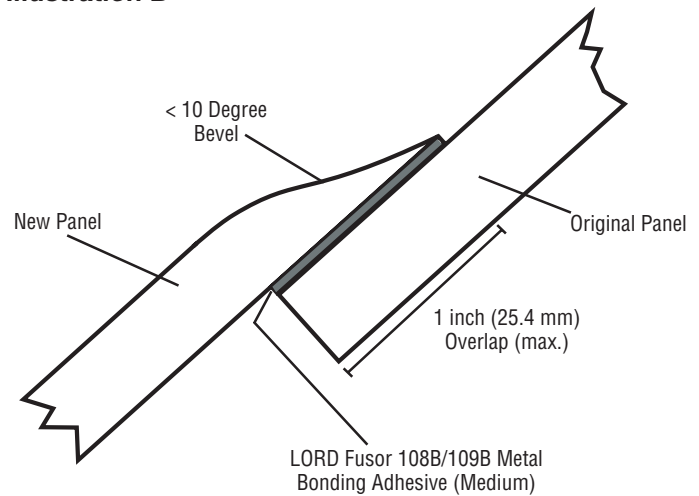


*Note: Not drawn to scale.*

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 cosmetic repair area.
6. Ensure that the sectioned edges have been beveled to <10 degrees with 36- or 40-grit grinding disks. It is important to taper and bevel the edges of the overlapped panel so that there is a smooth transition **(see Illustration B)**.
7. Recess screw holes with a punch and hammer. Finish section seam with fiber-filled body filler, then complete the repair with conventional body filler. Cure and rough-sand the filler after the adhesive has fully cured. Block-sand and then 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.

**Note: Do not hurry the job. Make sure that all cure time requirements are met or exceeded to provide better quality.**

**Illustration B**



*Note: Not drawn to scale.*

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