

Patch Panel Installation Procedures using LORD Fusor® Adhesives

Materials Needed:

- LORD Fusor 703 Plastic & Rubber Cleaner
 - LORD Fusor 110B/111B Metal Bonding Adhesive (Fast)
 - LORD Fusor 300 or 301 Manual Dispensing Gun, or LORD Fusor 304X Pneumatic Dispensing Gun
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Surface Preparation

1. Clean the metal panel with plastic & rubber cleaner.
2. Remove the rusted or damaged area of the panel with an air saw or air chisel.
3. Carefully grind the outer edges of the old panel to which LORD Fusor® metal bonding adhesive (Stock #110B/111B) will be applied. Make sure to remove any e-coat, paint, rust 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.
4. Cut a patch panel about 3/4 inch (19.05 mm) larger than the repair area. Grind the outer edges of this piece, making sure to remove e-coat, paint, rust or galvanized coating as described in Step #4.
5. Clean the patch panel with plastic & rubber cleaner to remove oils, dirt, etc.
6. Pre-bevel the edge of the overlapped metal to <10 degrees with 36- or 40-grit grinding disks. Taper the beveled edge so there is a smooth transition.

Note: Using a flanging tool is not a recommended procedure.

7. Pre-fit the patch to ensure a proper fit.

Adhesive Preparation

1. Insert the LORD Fusor metal bonding adhesive cartridge (Stock #110B/111B) 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 5-8 minutes at 70°F (21°C) to apply the adhesive and patch.

Panel Installation

1. Apply a 1/4 inch (6.35 mm) bead of LORD Fusor metal bonding adhesive approximately 1/4 inch (6.35 mm) from the prepared edge of the patch. The adhesive can be dispensed on the original panel.
2. Quickly and properly position the new patch. Once the patch has been positioned, do not pull it away from the vehicle. If repositioning is necessary, slide the patch. 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 20-30 minutes. If the temperature is below 70°F (21°C), allow for a longer cure time. 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 side of the repair area. Fill any screw holes with a water-proof, fiber-filled body filler.
6. Finish with fiber-filled body filler on the section seam, and then complete the repair with conventional body filler. Cure and rough-sand the filler after the adhesive has fully cured. Block-sand, then prime and paint per manufacturer's recommendations.

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