

Bumper Cosmetic Repair Procedure using LORD Fusor[®] 114 Plastic Finishing Adhesive

Materials Needed:

- LORD Fusor 703 Plastic & Rubber Cleaner
- LORD Fusor 114 Plastic Finishing Adhesive (Fast)

LORD Fusor[®] 114 plastic finishing adhesive is intended for cosmetic repair of nicks, gouges and other minor cosmetic defects on all types of bumper covers. It is intended for minor damage which does not penetrate the bumper cover. If the damaged area requires a structural repair, we recommend the use of LORD Fusor extreme bumper repair adhesive (Stock #142/143) or LORD Fusor extreme bumper repair adhesive (Stock #152/153).

When application instructions are carefully followed, LORD Fusor plastic repair products will produce a Class-A finish.

Surface Preparation

1. Plastics to be repaired should be brought into the body shop in advance so that they are dry and at room temperature, 65-75°F (18-24°C), before anything is done to them.
2. Clean the damaged plastic with plastic & rubber cleaner to remove all waxes, silicones, dirt and road oils before sanding the repair area.

Repairing the Damaged Area

1. Sand the damaged area with a DA sander or by hand using 80-grit sandpaper. Make a gradual taper in the repair area rather than a V-groove (**see Illustrations A and B**). This will prevent “bull’s-eyes” or “readthrough” in the finished repair. Blow away all dust with an air hose to ensure a clean bond surface. Be sure that the air does not have any oil or water in it. Do not use a cleaner after the damaged area has been sanded.

Note: This product does not require an adhesion promoter or surface modifier. However, the adhesive will not bond to melted plastics. To prevent bond failure, use hand-sanding or operate DA sander at low rpms during surface preparation.

2. Insert the black plunger into the backside of the LORD Fusor 114 plastic finishing adhesive cartridge. Hand dispense at temperatures above 70°F (21°C). Use a caulking gun to dispense adhesive at temperatures below 70°F (21°C). Squeeze a small amount of the product from each side of the cartridge to level the plungers. Dispense required amount of adhesive needed for the repair onto a palette mixing board and mix by hand using a plastic spreader.

Note: This product has a short work time to help you complete your job quickly. Once you have dispensed the product and mixed it on the palette, the product has a 1-2 minute open time at 70°F (21°C) before it will start to cure.

3. Immediately apply the mixed adhesive to the prepared area.

Note: The repair adhesive should be slightly higher than the surface to allow for sanding.

Illustration A: V-groove – DO NOT USE!



Illustration B: Taper/cove – USE!



4. Allow the repair adhesive to cure for 10-15 minutes at room temperature, 70°F (21°C).
5. After the adhesive cures, use a DA sander with 180-grit sandpaper to rough and contour into the plastic. Block-sand and feather-edge using 220- and 320-grit sandpaper. In the event that pinholes exist, apply more adhesive. Work the adhesive into the pinholes with a plastic spreader. Cure and finish-sand again.
6. Allow the product to final cure a total of 60 minutes at 70°F (21°C). Prime and paint per manufacturer's recommendations.

Technical Tips

- For plastics that have been stressed from impact, apply light heat to the damaged area and massage the back side to allow the plastic to come back to its natural state before doing your repair. If this step is omitted, the dent may result in a "bull's-eye" in the repair area after placing it under a heat lamp or in a paint booth.
- A mixer tip is not required for this product.
- TPO, TPE and PP bumpers do not require LORD Fusor plastic surface modifier (Stock #602EZ).
- Do not use polyester body fillers over LORD Fusor 114 plastic finishing adhesive.
- Smooth LORD Fusor 114 plastic finishing adhesive with a plastic spreader until the surface starts to feel drag on the spreader. This will eliminate the chances of pinholes.
- Wipe off the cartridge nozzle and cap with a clean rag after use to prevent cured particles from entering inside the cartridge.

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