

# Bonding Body Side Moldings using LORD Fusor® Plastic Repair Systems

## Materials Needed:

- LORD Fusor 703 Plastic & Rubber Cleaner
- LORD Fusor 602EZ Plastic Surface Modifier
- LORD Fusor 170/171 Clear Double-Sided Tape
- LORD Fusor 142/143 Extreme Bumper Repair Adhesive (Super Fast), or LORD Fusor 152/153 Extreme Bumper Repair Adhesive (Fast), or LORD Fusor 141/140 Plastic Bonding Adhesive (Super Fast)
- LORD Fusor 300 or 301 Manual Dispensing Gun, or LORD Fusor 304 Pneumatic Dispensing Gun

## Removing the Body Side Molding

1. The vehicle and the body side moldings to be bonded 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. Remove the side molding using a heat gun and piano wire. Molding can be distorted or paint can blister if the temperature is greater than 200°F (93°C).
3. Use a putty knife to scrape the adhesive or tape from the side molding.
4. Use plastic & rubber cleaner to remove any residual adhesive from the side molding or from the vehicle body panels.

## Bonding the Body Side Molding

1. If there are any distortions, kinks, etc. in the body side molding, apply heat to relieve stress. Return the molding to its original condition.
2. Scuff the bond side of the molding with 80-grit sandpaper. Remove any loose contaminants. Spray apply a thin coating of LORD Fusor® plastic surface modifier (Stock #602EZ) to the scuffed side of the molding. Allow the plastic surface modifier to dry for 10-15 minutes at 70°F (21°C).

**Note: Use of LORD Fusor plastic surface modifier (Stock #602EZ) is required due to body side moldings being made of materials such as PP (polypropylene) and TPO (thermo-plastic olefin) rather than PVC (vinyl).**

3. Prepare the vehicle body panels for bonding (i.e., prime and paint per manufacturer's recommendations).
4. Bond the molding to the vehicle using double-sided tape or by using a two-component adhesive.
5. Double-Sided Tape
  - a. Use either LORD Fusor 170 (7/8" [22.2 mm] wide) clear double-sided tape or LORD Fusor 171 (1/2" [12.7 mm] wide) clear double-sided tape.
  - b. Apply the tacky side of the tape to the body side molding.
  - c. Remove the release paper from the tape.
  - d. Carefully place the molding against the vehicle. If realignment is needed, do that now. If the position is correct, apply pressure against the complete profile of the body side molding.

**Note: Do not apply pressure until proper alignment is made.**

6. Two-Component Adhesive
  - a. Three adhesive systems are recommended for use with this repair procedure:
    - LORD Fusor Extreme Bumper Repair Adhesive (Stock #142/143)
    - LORD Fusor Extreme Bumper Repair Adhesive (Stock #152/153)
    - LORD Fusor Plastic Bonding Adhesive\* (Stock #141/140)

Choosing which adhesive to use depends on the work time and adhesive sandability time needed.

\* LORD Fusor Plastic Bonding Adhesive (Stock #141/140) is only to be used for bumper tab and bonding applications.

- b. Insert LORD Fusor adhesive cartridge 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 material is evenly mixed.
- c. Apply the adhesive onto the molding. Immediately attach the molding to the vehicle. Make sure the position is correct as repositioning will leave an adhesive trail.
- d. Hold the molding against the vehicle for approximately 5 minutes, allowing the adhesive to cure per product recommendation. Vehicle can be moved after 30 minutes.

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