

Semi-Truck Trailer Interior Kemlite® Wall Repair using LORD Fusor® Adhesives

Materials Needed:

- LORD Fusor 602EZ Plastic Surface Modifier
- LORD Fusor 147/148 Plastic Bonding Adhesive (Medium) or LORD Fusor 127EZ/128EZ Plastic Bonding Adhesive (Slow)
- LORD Fusor 300 or 301 Manual Dispensing Gun, or LORD Fusor 304 Pneumatic Dispensing Gun

Surface Preparation

1. Remove all torn material from the damaged area that may interfere with the patch.
2. Prepare a Kemlite® patch 2 inches (50.8 mm) larger than the damaged area.
3. Clean mating surfaces of the patch and existing panel with wax and grease remover. Scuff mating surfaces with 80-grit sandpaper.
4. Blow away debris with an air gun. Be sure that the air does not have any oil or water in it.
5. Spray the area to be bonded with LORD Fusor® 602EZ plastic surface modifier. Allow to dry 10-15 minutes or longer if the temperature is below 70°F (21°C).

Adhesive Preparation

1. Depending on the size of the patch and work time needed, use either LORD Fusor 147/148 plastic bonding adhesive or LORD Fusor 127EZ/128EZ plastic bonding adhesive.
2. Insert the LORD Fusor plastic bonding adhesive cartridge into the appropriate dispensing gun. Squeeze a small amount of product from each side of the cartridge to level the plungers.
3. 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 5-7 minutes at 70°F (21°C) to apply the adhesive and patch if using LORD Fusor 147/148 plastic bonding adhesive. If using LORD Fusor 127EZ/128EZ plastic bonding adhesive, you will have about 50-60 minutes at 70°F (21°C) to apply the adhesive and patch.

Application Procedure

1. Apply a 1/2 inch (12.7 mm) bead of adhesive to the mating side of the patch, approximately 3/4 inch (19.1 mm) inwards from the edge of the patch.
2. Center the patch over the damaged area, and press firmly into place. Secure the patch with duct tape or load locks. If using load locks, place wood furring strips across bond area to achieve uniform pressure.
3. If LORD Fusor 147/148 plastic bonding adhesive was used, cure at room temperature for 60-90 minutes, or heat cure at 140°F (60°C) for 15 minutes, to achieve handling strength. If LORD Fusor 127EZ/128EZ plastic bonding adhesive was used, cure at room temperature for 4-5 hours, or heat cure at 140°F (60°C) for 30 minutes, to achieve handling strength.

Note: For smaller repairs, refer to Fusor Repair Procedure - *Semi-Truck Trailer Translucent Roof Panel Patch Repair using LORD Fusor Adhesives.*

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