

Semi-Truck Trailer Aluminum Radius Panel Patch Repair using LORD Fusor[®] Adhesives

Materials Needed:

- LORD Fusor 171 Clear Double-Sided Tape
- LORD Fusor 110B/111B Metal Bonding Adhesive (Fast)
- LORD Fusor 300 or 301 Manual Dispensing Gun, or LORD Fusor 304X Pneumatic Dispensing Gun

This repair should only be performed on punctures that are well within the riveted portion of the radius panel. There must be enough undamaged material on all sides on which to bond the repair patch without overlapping existing rivets.

Surface Preparation

1. Remove any torn aluminum from the damaged area that may interfere with the patch.
2. If necessary, straighten aluminum so that the patch will sit flush on the radius panel.
3. Prepare an aluminum patch 1-1/2 to 2 inches (38.1 to 50.8 mm) larger than the damaged area. The patch should be shaped to match the contour of the radius panel.
4. Grind mating surfaces of both the patch and radius panel to bare metal.
5. Clean both mating surfaces with wax and grease remover.

Adhesive Preparation

1. Insert the LORD Fusor[®] metal bonding adhesive cartridge (Stock #110B/111B) into the appropriate 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.

Application Procedure

1. Apply LORD Fusor 171 clear double-sided tape (1/2 inch [12.7 mm] wide) to outside edge of patch.
2. Apply a 1/2 inch (12.7 mm) bead of LORD Fusor metal bonding adhesive to the mating side of the patch, approximately 3/4 inch (19.1 mm) inwards from the tape.

Note: In extremely warm weather, LORD Fusor 110B/111B metal bonding adhesive will cure more quickly. Consider using LORD Fusor 108B/109B metal bonding adhesive for larger repairs and during warmer temperatures.

3. Center the patch over the damaged area, and press firmly into place. Secure the patch with duct tape.

Note: Avoid using rivets in this repair; rivets can lead to leaks.

4. Allow adhesive to cure at room temperature for 20-30 minutes to achieve handling strength. If the temperature is below 70°F (21°C), allow for a longer cure time.

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