

# Semi-Truck Trailer Aluminum Side Panel Patch Repair using LORD Fusor<sup>®</sup> Adhesives

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## 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
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## 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 aluminum side panel.
3. Prepare a white aluminum patch 2 inches (50.8 mm) larger than the damaged area.
4. Hold the patch centered over the damaged area. Using a pencil or marker, trace around the edge of the patch.
5. Grind only the area inside the traced line to bare metal.
6. Clean mating surfaces of the patch and side panel with wax and grease remover. Scuff the mating side of the patch with 80-grit sandpaper.

## Adhesive Preparation

1. Insert the LORD Fusor<sup>®</sup> 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.
3. Position the patch inside the marked area, and press firmly into place.
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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