

Semi-Truck Trailer Translucent Roof Panel Patch Repair using LORD Fusor[®] Adhesives

Materials Needed:

- LORD Fusor 602EZ Plastic Surface Modifier
- LORD Fusor 171 Clear Double-Sided Tape
- LORD Fusor 141/140 Plastic Bonding Adhesive (Super Fast)
- LORD Fusor 300 or 301 Manual Dispensing Gun, or LORD Fusor 304 Pneumatic Dispensing Gun

Surface Preparation

1. Remove all material from the damaged area that may prevent the patch from sitting flush.
2. Prepare a Kemlite[®] translucent patch 1-1/2 to 2 inches (38.1 to 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. Insert the LORD Fusor plastic bonding adhesive cartridge (Stock #141/140) 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 90 seconds 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 plastic bonding adhesive to the mating side of the patch, approximately 3/4 inch (19.1 mm) inwards from the tape.

Note: For larger repairs or during warm temperatures, consider using either LORD Fusor 147/148 plastic bonding adhesive or LORD Fusor 127EZ/128EZ plastic bonding adhesive.

3. Quickly center the patch over the damaged area, and press firmly into place. Secure the patch with duct tape.
4. Allow adhesive to cure at room temperature for 5 minutes to achieve handling strength.

Note: For larger repairs, refer to Fusor Repair Procedure - Semi-Truck Trailer Interior Kemlite Wall Repair using LORD Fusor Adhesives.

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