

Semi-Truck Trailer DuraPlate® Side Panel Patch Repair using LORD Fusor® Adhesives

Materials Needed:

- LORD Fusor 171 Clear Double-Sided Tape
- LORD Fusor 110B/111B Metal Bonding Adhesive (Fast) or LORD Fusor 108B/109B Metal Bonding Adhesive (Medium)
- LORD Fusor 300 or 301 Manual Dispensing Gun, or LORD Fusor 304 or 304X Pneumatic Dispensing Gun

Surface Preparation

1. Remove the damaged material, squaring off the area.
2. If necessary, straighten side panel so that the patch will sit flush on the panel.
3. Prepare a DuraPlate® patch 2 inches (50.8 mm) larger than the damaged area.
4. Hold the patch centered over the damaged area on the outside of the trailer wall. 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. Hold the patch centered over the damaged area from the inside of the trailer wall. Using a pencil or marker, trace the damaged area onto the patch.
7. On the patch, remove all material outside of the traced line down to the outside layer of metal (i.e., remove the inside layer of metal and foam).
8. 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.
9. Blow away debris with an air gun. Be sure that the air does not have any oil or water in it.

Adhesive Preparation

1. Depending on the size of the patch and work time needed, use either LORD Fusor® 110B/111B metal bonding adhesive or LORD Fusor 108B/109B metal bonding adhesive.
2. Insert the LORD Fusor metal 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 5-8 minutes at 70°F (21°C) to apply the adhesive and patch if using LORD Fusor 110B/111B metal bonding adhesive. If using LORD Fusor 108B/109B metal bonding adhesive, you will have about 40-50 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. If LORD Fusor 110B/111B metal bonding adhesive was used, cure at room temperature for 20-30 minutes to achieve handling strength. If LORD Fusor 108B/109B metal bonding adhesive was used, cure at room temperature for 1-1/2 to 2 hours to achieve handling strength.

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