

Semi-Truck Trailer Corner Post Replacement using LORD Fusor® Adhesives

Materials Needed:

- LORD Fusor 108B/109B Metal Bonding Adhesive (Medium)
- LORD Fusor 301 Manual Dispensing Gun

Removal of Corner Post

Note: Trailer repair should be performed in dry environment at room temperature, 70°F (21°C).

1. With a marker, trace down the edge of the corner post on the white front panel (**see Illustration A**).
2. Remove all rivets from side panel (**see Illustration B**). On each side of corner post, remove two rivets from upper rail and all lower rail rivets.
3. Separate bonded front seam using a putty knife and heat gun on the inside of the corner post. Starting at the top and working down, separate the joint.
4. Remove the corner post.
5. Remove any remaining seam sealer.

Surface Preparation

1. Using duct tape, mask the front panel to the center side of the marker line on the white front panel (**see Illustration C**).
2. Remove all old adhesive on the front panel using a red scuff pad wheel or 80-grit sandpaper. Wipe mating surface clean with acetone or alcohol.

Illustration A

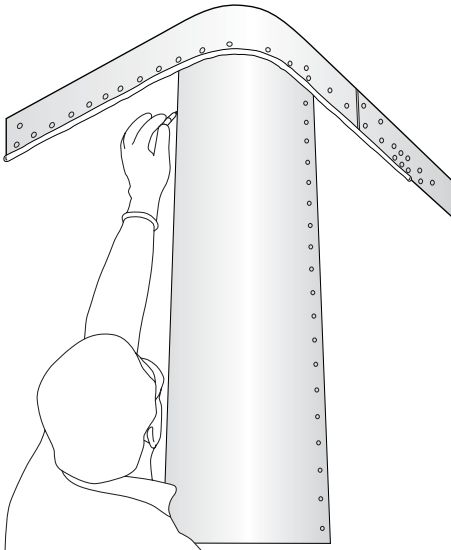


Illustration B

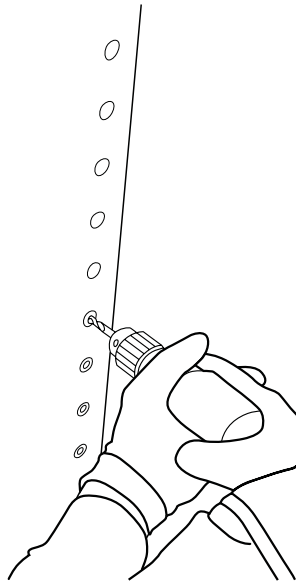
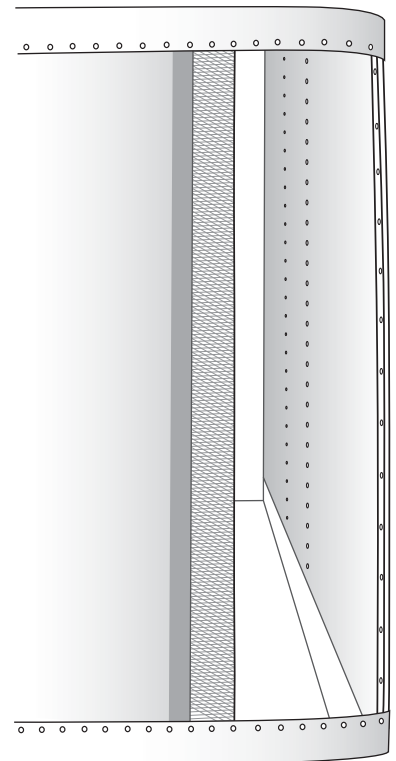


Illustration C



3. Scuff the mating surface of the new corner post with a course scratch pad or 80-grit sandpaper (**see Illustration D**). Wipe mating surface clean with acetone or alcohol.

Adhesive Preparation

1. Insert the LORD Fusor® metal bonding adhesive cartridge (Stock #108B/109B) into the 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.

Corner Post Installation

1. Install the corner post, drilling the necessary holes and replacing all rivets (**see Illustration E**).
2. Apply a 3/8 inch (9.5 mm) bead of adhesive between the corner post and white front panel.

Note: It is not recommended to apply adhesive when temperature is below 50°F (10°C).

3. From inside the trailer, place a 1" x 2" board against the corner post seam, centered from top to bottom. Evenly place five c-clamp style vise grips to hold the board in place (**see Illustration F**).
4. Push wood shims between the vise grips and board, applying firm pressure to the bond joint.

Illustration D

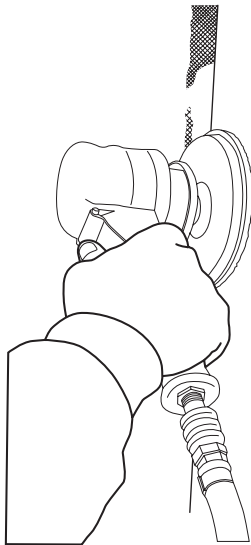


Illustration E

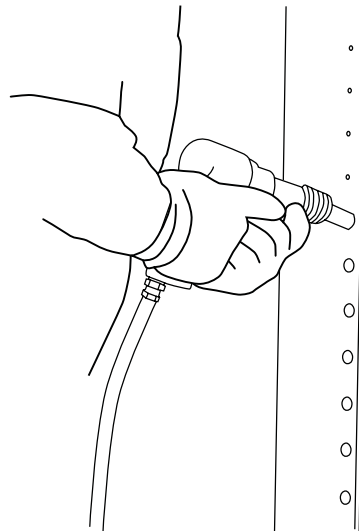
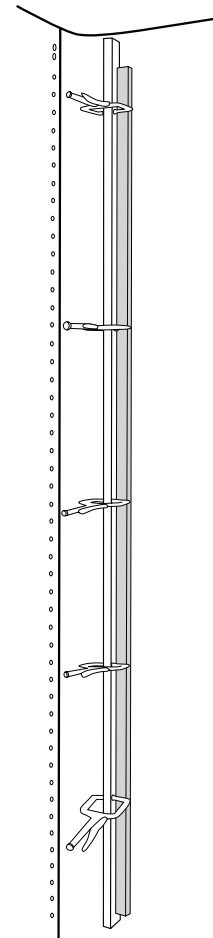


Illustration F



5. Allow adhesive to cure for two hours at a minimum of 70°F (21°C). If temperature is below 70°F (21°C), allow for a longer cure time.
6. After adhesive cures, remove the vise grips and board from the inside seam and the duct tape from the outside of the trailer.
7. Apply gray seam sealer as necessary to match the existing sealer.

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