

LORD Fusor[®]

Automotive Repair Adhesives

Technical Tips

HOLDEN WHEEL TUB ASSEMBLY LORD Fusor 127EZ Plastic Bonding Adhesive 300mL

- Before replacing the wheel tub assembly all areas must be cleaned free from oil, grease, road grime and old sealers/adhesives.
- Removal of the original wheel tub can be accelerated with the aid of a heat gun used to soften the bonding agent.
- Any bare steel must be over coated with a two pack epoxy primer and be allowed to dry (refer to your preferred paint brand technical data sheet for application).
- Sand the cured epoxy primer lightly (do not sand through to bare metal).
- Clean the new plastic tub liner with LORD Fusor[®] 703 Plastic & Rubber Cleaner and wipe dry with a clean cloth.

Note: Do not sand the plastic tub liner as it will destroy the flame treated surface of the wheel tub channel and reduce the adhesion of the LORD Fusor[®] 127EZ Plastic Bonding Adhesive to the plastic tub liner.

- Apply LORD Fusor[®] 602EZ Plastic Surface Modifier (shake the aerosol can thoroughly for at least 1 minute before application) to the tub liner surface where the adhesive will be applied and allow 12-20 mins flash off.
- Apply a 5mm bead of LORD Fusor[®] 127EZ Plastic Bonding Adhesive to the plastic tub liner followed by a further 5mm bead on top of the first bead. The double bead of adhesive will seal the flange. Clamp in place and allow 24 hours cure time.

Handy Hints

- Prepare all parts first.
- Level the adhesive cartridge plungers
- Attach the mixing tip to the cartridge
- Apply a small 50mm length of LORD Fusor[®] 127EZ to a scrap piece of cardboard. This will check that the mix of adhesive is uniform. Under no circumstance hand mix the adhesive.
- Leave the mixing tip on the cartridge when adhesive application is finished
- Once the liner is clamped in place and a sound fit is achieved, any excess material may be cleaned up with a Wax & Grease/Prepsol type material

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LORD USER INSTRUCTIONS

LORD Fusor[®] 127EZ/128EZ Plastic Bonding Adhesive (Slow)

LORD Fusor[®] 127EZ/128EZ plastic bonding adhesive can be used for bonding plastic body panels, spoilers and ground effects.

Usage

Metal Preparation

1. Prime all bare metal using a two-component epoxy primer.
2. Allow the primer to completely dry, then sand the primed areas with 180- and 220-grit sandpaper.

SMC Preparation

1. Clean the area to be bonded with plastic & rubber cleaner (see Illustration A).
2. Sand the bond areas with 80-grit sandpaper.

Product Preparation

1. Insert the LORD Fusor two-component adhesive cartridge into the dispensing gun.
2. Squeeze a small amount of LORD Fusor plastic bonding adhesive from each side of the cartridge. This will level the plungers and ensure that adhesive is coming out of both sides of the cartridge.
3. Attach the mixing tip and dispense a small amount of material to verify that the adhesive is evenly mixed.

Application

1. Apply a bead large enough to fill any gaps between the panel and the inner reinforcement (see Illustration B). The recommended bead size is 1/2 inch (12.7 mm).
2. Clamp panels with enough pressure to hold the panel in place while allowing a small amount of adhesive to squeeze out.
3. Allow adhesive to fully cure and cool to room temperature before unclamping.

Note: LORD Fusor plastic bonding adhesive is not to be used as a seam sealer or filler. Avoid the application of polyester body fillers directly on top of the adhesive or swelling and/or blistering may occur.

4. Prime and paint per manufacturer's recommendations.

Technical Data

Work Time, minutes @ 70°F (21°C)	50-60
Full Cure Strength	
hours @ 70°F (21°C)	24
minutes @ 140°F (60°C)	60
Handling Strength	
hours @ 70°F (21°C)	4-5
minutes @ 140°F (60°C)	30
Part Paintability	
hours @ 70°F (21°C)	4
minutes @ 140°F (60°C)	30
Lap Shear Strength	Substrate failure occurred before bond failure on ABS, PVC, SMC acrylic, XENOY [®] or polycarbonate
Torsional Impact Resistance	Substrate failure occurred before bond failure or bond assembly exceeded test protocol on ABS, PVC, SMC, acrylic, XENOY or polycarbonate

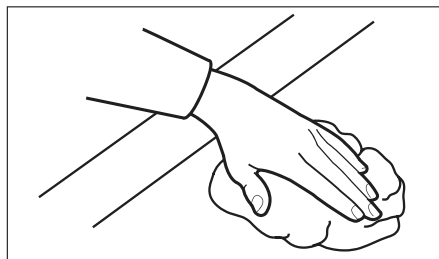
Cautionary Information

Before using this or any LORD product, refer to the Material Safety Data Sheet (MSDS) and label for safe use and handling instructions.

For industrial/commercial use only. Must be applied by trained personnel only. Not to be used in household applications. Not for consumer use.

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Illustration A



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