

LORD Fusor[®] 208B Panel Bonding Adhesive

(Slow)

LORD Fusor[®] 208B adhesive is an epoxy-based panel bonding adhesive with extremely low odor during application and tack-free when cured. It can be used for panel bonding, weld bonding, and rivet bonding of all steel or aluminum panels while providing excellent corrosion protection and strength. Curing and handling strength of Fusor 208B adhesive can be accelerated with heat.

Usage

Follow the vehicle manufacturer's guidelines regarding the fastening of the replacement panel (welding, mechanical fasteners, or bond only) and their position on the removal of any metal coatings (zinc or aluminum coatings).

Metal Preparation

1. Using an 80-grit disk, or finer, grind the surface of all mating flanges (not greater than 1 inch [25.4 mm]) to which Fusor metal bonding adhesive will be applied. Make sure to remove any existing adhesive or e-coating.
2. Pre-fit the new panel to ensure proper alignment and plan the mechanical fastening (STRSW welds or rivets) and clamping locations for the final installation. If pull rivets or solid rivets are being used, then the holes should be drilled at this time.
3. Wipe bonding surface with solvent (acetone, heptanes, isopropyl alcohol, MEK, etc.), leaving no residue.

Product Preparation

1. Insert the Fusor two-component adhesive cartridge into the dispensing gun.
2. Squeeze a small amount of Fusor metal 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 and that the color is consistent.

Assembly

1. Apply a small amount of adhesive to the bonding flange of both panels. Quickly spread adhesive over all bare metal, as a priming operation.
2. Apply a 1/4 to 3/8 inch (6.4 to 9.5 mm) bead of Fusor metal bonding adhesive to the prepared mating surfaces.
3. Secure the panel using clamps. The glass beads in the adhesive will prevent over clamping. Apply screws or rivets in hard-to-clamp areas. After the panel has been positioned, do not pull it away from the vehicle. If repositioning is necessary, slide the panels against one another. This maintains contact between the two surfaces.
4. Weld the panel (STRSW) or install the appropriate mechanical fasteners (rivets) in their respective locations. Once fastened remove any remaining clamps or temporary fasteners. If a bond-only application, the clamps/fasteners may be removed after 4 hours @ 70°F (21°C), or 30 minutes @ 140°F (60°C).
5. Adhesive squeeze-out may be tooled as desired, or removed and the surface cleaned with a solvent.

Note: Adhesive may be painted immediately, if desired, using an automotive refinish system. Check paint system compatibility before proceeding.

Technical Data

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| Work Time | 90 minutes @ 70°F (21°C) |
| Clamp Time | immediately when mechanically fastened; 30 minutes @ 140°F (60°C); 4 hours @ 70°F (21°C) |
| Paint Time | immediately |
| Full Cure | 24 hours @ 70°F (21°C); 1 hour @ 140°F (60°C) |
| Lap Shear Strength (ASTM D 1002) | |
| 0.032" Cold Rolled Steel | 2400 psi (16.5 MPa) cohesive failure |
| 0.060" Cold Rolled Steel | 3000 psi (20.7 MPa) cohesive failure |
| SMC to SMC | 589 psi (4 MPa) substrate failure |

LORD USER INSTRUCTIONS

LORD Fusor® Repair Products Lifetime Guarantee*

LORD Corporation guarantees to the installer that LORD Fusor® Repair Products (adhesives, primers, seam sealers and foams only), when used in strict accordance with LORD Corporation's application and use instructions, will provide a durable bond for the life of the vehicle. This guarantee, subject to the terms and conditions stated herein, covers actual costs incurred by the installer for labor, replacement parts and materials to replace the bonded metal components of the vehicle. THIS GUARANTEE IS NOT APPLICABLE TO APPLICATION EQUIPMENT, INCLUDING BUT NOT LIMITED TO DISPENSING EQUIPMENT, CARTRIDGE TIPS AND ACCESSORIES.

THIS EXPRESS WARRANTY IS MADE IN LIEU OF AND EXCLUDES ANY AND ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, BY OPERATION OF LAW OR OTHERWISE, INCLUDING THE IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.

LORD Corporation shall not be liable under any circumstance for any liability, loss, damage or expense directly or indirectly arising from the application and use of LORD Fusor Products sold hereunder or from any other cause. LORD Corporation shall not be liable under any circumstances for consequential, indirect or special damages. **LORD CORPORATION'S LIABILITY FOR BREACH OF WARRANTY HEREUNDER IS IN ALL INSTANCES LIMITED SOLELY AND EXCLUSIVELY TO THE REASONABLE COSTS OF REPAIR AND/OR REPLACEMENT OF THE BONDED METAL COMPONENTS OF THE VEHICLE.**

This guarantee shall only apply to the above referenced LORD Fusor products sold by LORD Corporation on or after January 1, 2001.

LORD Fusor Metal Bonding Adhesives shall only be used for the adhesive-only bonding (no welds or rivets) of metal to metal assemblies (steel or aluminum) in full or partial panel replacements of door skins, roof skins, quarter panels, rear body panels and other outer body sheet metal.

LORD Fusor products shall not be used for adhesive-only bonding of any structural component unless specifically recommended by the vehicle manufacturer. Structural panels must be replaced in strict compliance with vehicle manufacturer guidelines. If in doubt as to what is a structural component or the proper installation method, contact the vehicle manufacturer. Further, any LORD Fusor products used in marine composite repair, such as with personal water craft and the like, shall be limited to repairs above the water line.

If you have any questions or need to receive proper use instructions, contact the LORD Customer Support Center at +1 800 234 Fusor (3876) or visit Fusor.com.

To comply with the requirements of the LORD Fusor Repair Products Lifetime Guarantee, attach a copy of this completed page to the repair record, and retain with your files:

Vehicle Make/Model: _____

Vehicle Identification Number: _____

LORD Fusor Product(s) Used for Repair: _____

Lot Number(s) on Cartridge(s) Used for Repair: _____

**This guarantee is void if product is used after the date printed on the cartridge label. LORD Terms and Conditions of Sale shall apply to all sales of LORD Fusor products.*

Cautionary Information

Before using this or any LORD product, refer to the Safety Data Sheet (SDS) 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.



Continuing Automotive
Service Education
CERTIFIED TRAINING PROVIDER

Instructions contained in this document need to be followed to qualify for the LORD Fusor Lifetime Guarantee. Values stated in these instructions represent typical values as not all tests are run on each lot of material produced. For formalized product specifications for specific product end uses, contact the Customer Support Center.

Information provided herein is based upon tests believed to be reliable. In as much as LORD Corporation has no control over the manner in which others may use this information, it does not guarantee the results to be obtained. In addition, LORD Corporation does not guarantee the performance of the product or the results obtained from the use of the product or this information where the product has been repackaged by any third party, including but not limited to any product end-user. Nor does the company make any express or implied warranty of merchantability or fitness for a particular purpose concerning the effects or results of such use.

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LORD provides valuable expertise in adhesives and coatings, vibration and motion control, and magnetically responsive technologies. Our people work in collaboration with our customers to help them increase the value of their products. Innovative and responsive in an ever-changing marketplace, we are focused on providing solutions for our customers worldwide ... Ask Us How.

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