

LORD USER INSTRUCTIONS

LORD Fusor® 120/T20/T21 SMC Repair Adhesive (Slow)

LORD Fusor® 120/T20/T21 SMC repair adhesive can be used for repair or bonding of composite body panels including large assembly bonding of fairings, body panels, spoilers, ground effects, wind deflectors, roofs and fender liners. Composite body panels include substrates such as fiberglass, SMC, carbon fiber, FRP, RTM, Metton®, GTX, etc.

LORD Fusor 120/T20/T21 SMC repair adhesive can also be used to repair cracks, punctures and tears.

Usage

1. Tape off exposed fibers to avoid wicking cleaner into the substrates. Clean the area to be repaired with plastic & rubber cleaner.
2. Make a backing patch if the part is cracked or punctured all the way through. This patch can be made from LORD Fusor fiberglass cloth (Stock #702) and LORD Fusor SMC repair adhesive. It can also be made from a piece of SMC, of the same size and shape, bonded with LORD Fusor SMC repair adhesive (see Illustration A). Make sure the back of the damaged part is clean and thoroughly sanded with 80-grit sandpaper.
3. Dish out the repair area and taper it all the way to the bottom of the damage, leaving no square edges in the repair area (see Illustration B).
4. Use a piece of plastic film backing, supplied with LORD Fusor fiberglass cloth (Stock #702), as the base. Prepare the filler patch, which consists of multiple layers of LORD Fusor fiberglass cloth (Stock #702) sandwiched between alternate layers of LORD Fusor SMC repair adhesive. Layer the cloth and adhesive to fill the repair area (see Illustration C).
5. Place the filler patch in the repair area. Use a LORD Fusor saturation roller (Stock #704) to press material into the repair area and force out entrapped air.
6. After rolling the repair with the saturation roller, heat set the repair with a heat gun or heat lamp for 15-20 minutes at 180°F (82°C) (see Illustration D). This will set the repair material so it can be rough-sanded.
7. Remove the plastic film backing and apply a finish coat of LORD Fusor SMC repair adhesive. Heat cure the entire repair area for one hour at 180°F (82°C). Allow repair area to cool to room temperature before final sanding.
8. Primer and paint per manufacturer's recommendations.

Metton is a trademark of Metton America, Inc.

Technical Data

Work Time, minutes @ 70°F (21°C)	45
Full Cure Strength, hours @ 180°F (82°C)	1
Handling Strength	
hours @ 70°F (21°C)	2
minutes @ 180°F (82°C)	15-20
Part Paintability	
hours @ 70°F (21°C)	4
minutes @ 180°F (82°C)	60
Lap Shear Strength, psi (MPa)	
SMC	fiber tear
SBR	substrate failure
Primed Cold Rolled Steel	>1600 (11.0)
Aluminum	>2500 (17.2)

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.

Illustration A

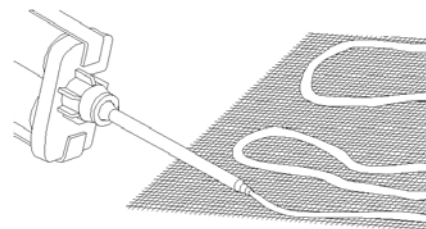


Illustration B

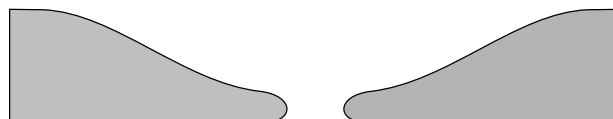
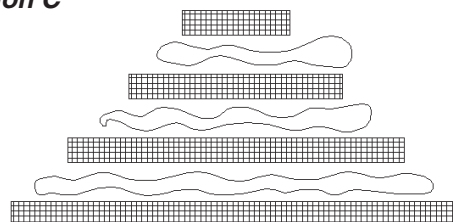


Illustration C



LORD USER INSTRUCTIONS

LORD Fusor Repair Products Lifetime Guarantee*

LORD Corporation guarantees to the original purchaser 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 covers actual costs incurred by the installer for labor, replacement parts and materials, and for the reasonable cost of loss of use of the vehicle during the period of replacement. 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 loss, damage, or expense directly or indirectly arising from the application and use of LORD Fusor Products sold hereunder or from any other cause, and LORD Corporation shall not be liable under any circumstances for consequential or incidental 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 Lifetime Guarantee shall only apply to the above listed LORD Fusor products sold by LORD Corporation on or after January 1, 2001.

LORD Fusor Metal Bonding Adhesives shall only be used for bonding metal to metal (steel or aluminum) in full or partial panel replacements of:

- door skins
- roof skins
- other outer body sheet metal
- quarter panels
- rear body panels

LORD Fusor products SHALL NOT be used for bonding structural components such as rails, pillars, rocker panels, core supports, etc. If in doubt as to what is a structural component, contact the vehicle manufacturer. If you have any questions or need to receive proper use instructions, contact the LORD Customer Support Center at +1 877 ASK LORD (275 5673) or visit www.lord.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: _____

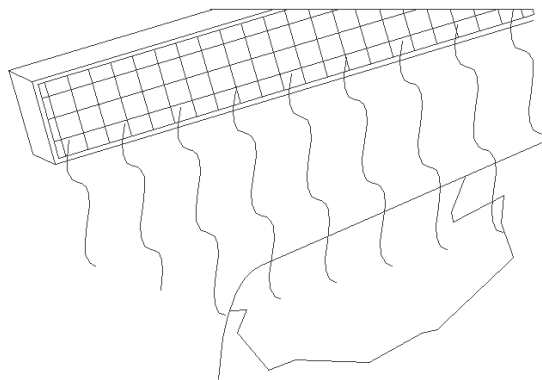
Vehicle Identification Number: _____

LORD Fusor Product(s) Used for Repair: _____

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

**This guarantee is void if adhesive is used after the date printed on the cartridge label.*

Illustration D



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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