

LORD USER INSTRUCTIONS

LORD Fusor[®] 114 Plastic Finishing Adhesive (Fast)

LORD Fusor[®] 114 plastic finishing adhesive can be used as a finishing adhesive for all plastic bumpers and body panels, including such plastics as PP, fiberglass, Metton[®], Telene[®], SMC, TEO and urethane.

Usage

Surface Preparation

1. Dry plastics to be repaired and bring to room temperature.
2. Clean the damaged plastic with plastic & rubber cleaner.
3. Sand the damaged area using 80-grit sandpaper. Make a gradual taper around the repair area to eliminate sharp edges. Blow away all dust. To prevent bond failure, use hand-sanding or operate DA sander at low rpms during surface preparation.

Note: This product does not require an adhesion promoter or surface modifier. This adhesive will not bond to melted plastics.

Product Preparation

1. Insert the black plunger into the backside of LORD Fusor 114 plastic finishing adhesive cartridge. Hand dispense at temperatures above 70°F (21°C) (see Illustration A). Use a caulking gun to dispense adhesive at temperatures below 70°F (21°C) (see Illustration B).
2. Push out a small amount of product from each side of the cartridge to level the plungers. Dispense a small amount of adhesive onto a palette mixing board. Mix by hand using a plastic spreader. The product will start to cure in 3-5 minutes.

Application

1. Apply LORD Fusor 114 plastic finishing adhesive to the prepared area. Apply the adhesive slightly higher than the surface to allow for sanding.
2. Allow adhesive to begin curing at room temperature, 70°F (21°C), for 10-15 minutes before sanding.
3. Use a DA sander with 180-grit sandpaper to rough and contour into the plastic. Block-sand and feather-edge using 220- and 320-grit sandpaper.
4. Allow adhesive to cure for 60 minutes at 70°F (21°C) before final finishing.

5. Prime and paint per manufacturer's recommendations.

Note: Do not use polyester body fillers over LORD Fusor 114 plastic finishing adhesive, as compatibility issues may result.

Technical Data

Work Time, minutes @ 70°F (21°C)	1-2
Full Cure Strength, hours @ 70°F (21°C)	1
Adhesive Sandability, minutes @ 70°F (21°C)	15-20
Part Paintability, hours @ 70°F (21°C)	1
Bakeable, °F (°C)	140 (60)

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.

Telene is a trademark of B.F. Goodrich Company. Metton is a trademark of Metton America, Inc.

Illustration A

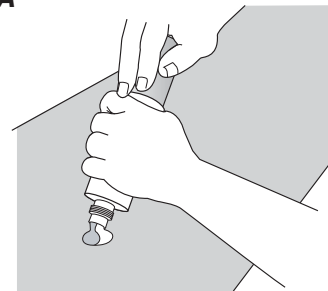
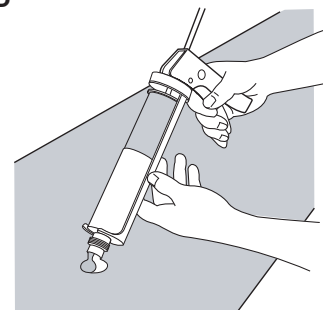


Illustration B



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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:

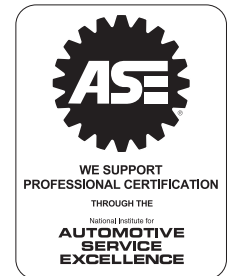
Vehicle Make/Model: _____

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.*



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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