

LORD Fusor® 152/153 Extreme Bumper Repair Adhesive (Fast)

LORD Fusor® 152/153 extreme bumper repair adhesive can be used on bumpers, bumper tabs, emblems, door trims, interior and exterior plastic repairs and cosmetic repairs.

Usage

Backing Patch

A backing patch is required if the damage penetrates through the bumper cover.

1. Use 80-grit sandpaper to sand the area around the puncture on the back of the bumper.
2. Apply a light coat of LORD Fusor plastic surface modifier (Stock #602EZ). Allow to dry for 10 minutes.
3. Cut a piece of LORD Fusor bumper reinforcing mesh (Stock #700), large enough to cover the entire repair area.
4. Apply LORD Fusor extreme bumper repair adhesive to the repair area. Spread the adhesive and lay the LORD Fusor bumper reinforcing mesh on the adhesive. Saturate cloth with adhesive using a plastic spreader and spread smooth. Apply more adhesive if needed.
5. Allow the adhesive to cure 30 minutes at room temperature, or 1 minute at 140°F (60°C).

Note: Double-sided repair can be completed in one step.

Bumper Repair

1. Use a DA sander with 80-grit sandpaper to remove surrounding paint damage and cove out the damaged area.
2. Follow the DA-sanding with 80-grit hand-sanding to make sure the area is "dished out" with no sharp edges.
3. Apply LORD Fusor plastic surface modifier (Stock #602EZ) to the repair area. Allow the modifier to dry for 10 minutes.
4. Apply LORD Fusor extreme bumper repair adhesive into the repair area and smooth out with a spreader.
5. Allow adhesive to cure by one of the following methods:
 - cure for 3 minutes with heat gun at 140°F (60°C)
 - cure for 30 minutes at 90°F (32°C)
 - cure for 90 minutes at room temperature
6. Slowly, rough-sand the repair area with DA sander using 80-grit sandpaper. For optimal results, contour with block sander using 180- or 220-grit sandpaper.

Bumper Tabs

1. Scuff the area of broken tab with 80-grit sandpaper.
2. Blow off and dry rag wipe.

3. Apply LORD Fusor plastic surface modifier (Stock #602EZ). Flash for 10 minutes.
4. Apply LORD Fusor extreme bumper repair adhesive and wrap with LORD Fusor bumper reinforcing mesh (Stock #700).
5. Allow to cure. Contour to match original shape. Drill out mounting hole.

Repair Broken Plastic Parts and Bond Moldings and Trim

1. Clean the area to be repaired with plastic & rubber cleaner.
2. Scuff the substrate to be bonded as well as the mating surface. If molding is made of TPO or PP, use LORD Fusor plastic surface modifier (Stock #602EZ).
3. Apply LORD Fusor extreme bumper repair adhesive to the part to be bonded.
4. Quickly mate part to vehicle.
5. If repositioning is necessary, do not pull the part away and reapply. This will result in compromised adhesion. Instead, slide part to reposition.
6. Apply enough pressure to squeeze out a small amount of adhesive.
7. Clamp or tape into position until handling strength is achieved.

Technical Data

Work Time, minutes	3-5
Handling Strength, minutes	
@ 140°F (60°C)	3
@ 70°F (21°C)	30
Adhesive Sandability, minutes	
@ 140°F (60°C)	3
@ 90°F (32°C)	30
@ 70°F (21°C)	90
Part Paintability, minutes	
with Heat Cure	60
@ 70°F (21°C)	120

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.

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.*



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.

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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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