

Fusor® T22 and T23 Truck Plastic Bonding Adhesive (Fast and Medium)

Technical Data Sheet

Fusor® T22 and T23 adhesives are two-component, urethane-based adhesives used for the installation of hood panels, roof panels, fenders, fender liners, fairings, spoilers, wind deflectors, cab extenders, ground effects, headlamp buckets and other body panels.

Features and Benefits:

High Performance – provides high strength and excellent durability for structural applications.

Environmentally Resistant – resists sunlight, weathering, humidity and salt spray.

Non-Sag – remains in position when applied on vertical or overhead surfaces; easy to apply.

Environmentally Recommended – does not contain ozone depleting chemicals.

Application:

Prepare – If bonding metal, prime all bare metal using a two-component epoxy primer. Allow the primer to completely dry, then scuff-sand the primed areas with 180- or 220-grit sandpaper.

If bonding plastic, clean the area to be bonded with Fusor 703 adhesion prep/cleaner. Scuff-sand the bond areas with 80-grit sandpaper. Wipe with a clean dry rag. Do not use a tack rag.

Apply – Load the cartridge into the applicator and remove the end cap. Level the plungers by expelling a small amount of adhesive to ensure that material is coming out of both sides of the cartridge. Attach mixing tip and dispense a mixer length of adhesive to verify the material is evenly mixed.

Apply a bead large enough to fill any gaps between the parts. Clamp parts with enough pressure to hold the parts in place while allowing a small amount of adhesive to squeeze out.

If repositioning is necessary, slide the part to reposition. Do not pull the part away and re-apply as this will result in poor adhesion.

Note: Various applications, cleaners/solvents and coatings may not be compatible with this product and should be tested by the user before proceeding with intended repair procedure.

Finish – Allow adhesive to cure at room temperature, 70°F (21°C), for clamp time indicated before unclamping.

Note: The use of polyester body filler or polyester putty directly on top of the adhesive is not recommended, as compatibility issues may result.

Prime and paint per manufacturer's recommendations.

For more application information, refer to www.lord.com/fusor for standard operating procedures or application training videos.

Typical Properties*

	Fusor T22	Fusor T23
Appearance	Beige Paste	Beige Paste
Base Chemistry	Urethane	Urethane
Work Time	5 minutes @ 70°F (21°C)	20 minutes @ 70°F (21°C)
Clamp Time	60 minutes @ 70°F (21°C); 15 minutes @ 140°F (60°C)	3 hours @ 70°F (21°C); 22 minutes @ 140°F (60°C)
Cure Time	24 hours @ 70°F (21°C); 60 minutes @ 140°F (60°C)	24 hours @ 70°F (21°C); 60 minutes @ 140°F (60°C)

*Data is typical and not to be used for specification purposes.



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Shelf Life/Storage

Shelf life is 24 months from date of manufacture when stored at 75°F (24°C) in original, unopened container.

Cautionary Information:

Before using this or any Parker 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.

Fusor® Repair Products Lifetime Guarantee*

LORD Assembly & Protection Solutions Division of Parker-Hannifin Corporation ("Parker LORD") guarantees to the user that Fusor® Repair Products (adhesives, primers, seam sealers and foams only), when used in strict accordance with Parker LORD application and use instructions, will provide a durable repair for the life of the vehicle per the product's technical data sheet. The user is solely responsible for determining the Fusor product and application method for the repair. Application and product guidance can be found on Fusor.com.

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.

Parker LORD shall not be liable under any circumstance for any liability, loss, damage or expense directly or indirectly arising from the application and use of Fusor Products sold hereunder or from any other cause. Parker LORD shall not be liable under any circumstances for consequential, indirect or special damages. **PARKER LORD'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 COMPONENTS OF THE VEHICLE.**

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

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 where approved by the vehicle manufacturer.

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 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.

Durability Performance*

Lap Shear Strength

ABS, PVC, Acrylic, SMC, Xenoy, SBR

substrate failure

Primed Cold Rolled Steel, Aluminum

>1600 psi (11.3 MPa)

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

To comply with the requirements of the 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: _____

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. Parker LORD Terms and Conditions of Sale shall apply to all sales of Fusor products.*



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 this technical data sheet 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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The user, through its own analysis and testing, is solely responsible for making the final selection of the system and components and assuring that all performance, endurance, maintenance, safety and warning requirements of the application are met. The user must analyze all aspects of the application, follow applicable industry standards, and follow the information concerning the product in the current product catalog and in any other materials provided from Parker or its subsidiaries or authorized distributors.

To the extent that Parker or its subsidiaries or authorized distributors provide component or system options based upon data or specifications provided by the user, the user is responsible for determining that such data and specifications are suitable and sufficient for all applications and reasonably foreseeable uses of the components or systems.

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