

Fusor® 100EZ/101EZ Plastic Repair Adhesive (Heat Set)

Technical Data Sheet

Fusor® 100EZ/101EZ adhesive is a two-component, epoxy-based adhesive used for structural and cosmetic repair of auto and heavy duty truck body panels and all types of rigid body plastics.

Features and Benefits:

Easy to Finish – easily sands to feather edge, providing undetectable repairs.

Versatile – bonds rigid plastics, SMC, GTX, fiberglass, Metton® and carbon fiber.

Convenient – one product for all body panel repairs.

Excellent Appearance - cures with no bull's-eyes, read-throughs or halos.

Application:

Prepare – Tape off exposed fibers to avoid wicking cleaner into the substrates. Clean the area to be repaired with Fusor 703 adhesion prep/cleaner.

Make a backing patch if the part is cracked or punctured all the way through. This patch can be made from Fusor 702 fiberglass cloth and Fusor 100EZ/101EZ plastic repair adhesive. It can also be made from a piece of SMC, of the same size and shape, bonded with Fusor plastic repair adhesive (see Figure 1).

Make sure the back of the damaged part is clean and thoroughly sanded with 80-grit sandpaper.

From the front of the repair area, dish out and taper the area all the way to the bottom of the damage, leaving no square edges in the repair area (see Figure 2).

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.

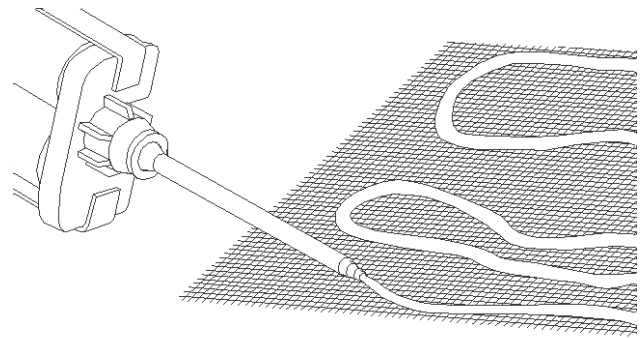


Figure 1. Create Backing Patch

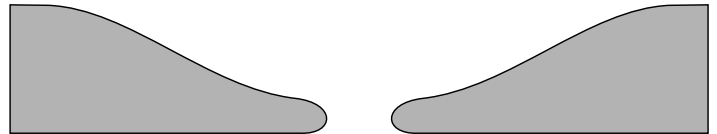


Figure 2. Taper Repair Area

Typical Properties*

Appearance	Beige Paste
Base Chemistry	Epoxy
Work Time	40 minutes @ 70°F (21°C)
Sand Time	10 minutes @ 180°F (82°C)
Paint Time	60 minutes @ 180°F (82°C)
Cure Time	60 minutes @ 180°F (82°C)

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



ENGINEERING YOUR SUCCESS.

Use a piece of plastic film backing, supplied with Fusor 702 fiberglass cloth, as the base. Prepare the filler patch, which consists of multiple layers of Fusor fiberglass cloth sandwiched between alternate layers of Fusor plastic repair adhesive. Layer the cloth and adhesive to fill the repair area (see Figure 3).

Place filler patch in the repair area. Use Fusor 704 saturation roller to press the material into the repair area and force out entrapped air.

After rolling the repair with the saturation roller, heat set the repair with a heat gun for 5-10 minutes at 180°F (82°C). Remove plastic film backing from repair area and rough-sand.

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 – Apply a finish coat of Fusor plastic repair adhesive if needed. 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. 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.

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.

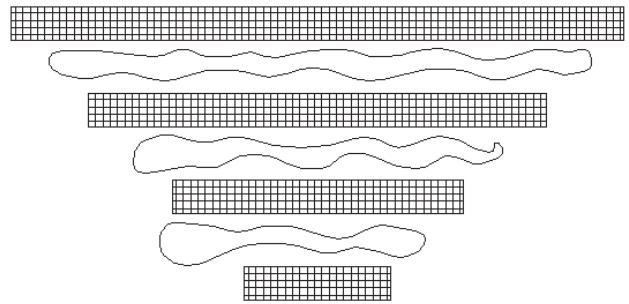


Figure 3. Filler Patch

Durability Performance*	
Lap Shear Strength ASTM D 1002 SMC	500 psi (3.45 MPa); 100% fiber tear
Torsional Impact Resistance GM 9751 P SMC	>106 in-lb (>11.98 N-m); no adhesive failure

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

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.

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.

Information provided herein is based upon tests believed to be reliable. In as much as Parker LORD has no control over the manner in which others may use this information, it does not guarantee the results to be obtained. In addition, Parker LORD 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.

WARNING — USER RESPONSIBILITY. FAILURE OR IMPROPER SELECTION OR IMPROPER USE OF THE PRODUCTS DESCRIBED HEREIN OR RELATED ITEMS CAN CAUSE DEATH, PERSONAL INJURY AND PROPERTY DAMAGE.

This document and other information from Parker-Hannifin Corporation, its subsidiaries and authorized distributors provide product or system options for further investigation by users having technical expertise.

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.

©2021 Parker Hannifin - All Rights Reserved

Information and specifications subject to change without notice and without liability therefor. Trademarks used herein are the property of their respective owners.

OD DS6225 07/21 Rev.0

Parker LORD
Engineered Materials Group

111 LORD Drive
Cary, NC 27511-7923
USA

phone +1 877 ASK LORD (275 5673)

www.lord.com

