

Fusor[®] 800DTM/803DTM Direct-to-Metal Adhesive/Sealant

Description

LORD Fusor[®] 800DTM/803DTM direct-to-metal adhesive/sealant is a one-component, moisture-cure product used for duplicating factory appearance on standing seams, cosmetic seams, truck bed seams, tooled door skin seams, floor pan seams, core support seams, brushed seams and other applications in which a non-sag cosmetic seam sealer is required.

Fusor adhesive/sealant is available in the following colors:

- Neutral – Fusor 800DTM Adhesive/Sealant
- Black – Fusor 803DTM Adhesive/Sealant

Features and Benefits

Durable – creates high strength bonds; exhibits excellent primerless adhesive properties.

Convenient – requires no mixing; skins over quickly at room temperature.

Chemically Resistant – solvent resistant when cured. Painting and most cleaning processes do not affect bond strength.

Temperature Resistant – uncured material can endure 225°F (107°C) for 60 minutes, and cured material can endure 325°F (163°C) for 60 minutes with no negative effect.

Environmentally Resistant – resists weathering and aging; provides excellent resistance to indirect UV exposure.

Non-Sag – remains in position when applied on vertical or overhead surfaces, allowing for greater process flexibility.

Application

Prepare – Clean the area to be sealed with Fusor adhesion prep/cleaner (Stock #703). Surfaces should be free of grease, dirt and other contaminants.

Apply – Using Fusor 313 manual seam sealer gun, apply adhesive/sealant to substrate and mate the parts within the work time of the material. Do not allow the material to skin over before mating parts.

Typical Properties*

Appearance	Neutral or Black Paste
Base Chemistry	Silane Terminated Polymer (STP)
Skin Time	15-45 minutes @ 70°F (21°C), 50% RH
Work Time	25 minutes @ 70°F (21°C), 50% RH
Paint Time	Immediately; up to 30 days without a scuff
Full Cure	72 hours @ 70°F (21°C)

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

LORD TECHNICAL DATA

If desired, tool or acid brush the adhesive/sealant to the desired texture. If tooling, use the reducer from your paint system. Avoid using other solvents or water as this may inhibit the curing characteristics or performance of the product.

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 – Through cure will vary depending on temperature and humidity. Product cures 1/8 inch every 24 hours at 77°F (25°C). Product thickness will determine full cure time.

Prime and paint per manufacturer's recommendations immediately or within 30 days on dirt- and dust-free surface..

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

Shelf Life/Storage

Shelf life is 15 months when stored in a well ventilated area at or below 80°F (27°C) in original, unopened container. Once cartridge has been opened, leave the dispense tip on to act as a seal against moisture.

Cautionary Information

Before using this or any 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.

LORD TECHNICAL DATA

Durability Performance*

Hardness Shore A	50
Tensile Strength	200 psi (1.38 MPa) minimum
Lap Shear Strength	200-500 psi (1.38-3.45 MPa)
Elongation ASTM D412	400 % minimum
Bond Strength**	
Hot Dipped Galvanize (HDG)	
0.047"	439 psi (3.03 MPa); cohesive failure (95%)
0.047" & 80-grit Grind	400 psi (2.76 MPa); cohesive failure (98%)
Galvaneal	
0.029"	411 psi (2.83 MPa); cohesive failure (97%)
0.029" & 80-grit Grind	311 psi (2.14 MPa); adhesive failure (53%)
Cold Rolled Steel (CRS)	
0.030"	285 psi (1.96 MPa); adhesive failure (97%)
0.030" & 80-grit Grind	434 psi (3.00 MPa); cohesive failure (98%)
Aluminum (AL)	
0.034" 6022T6	157 psi (1.09 MPa); adhesive failure 99%
0.034" 6022T6 & 80-grit Grind	393 psi (2.71 MPa); cohesive failure (90%)
Cromax 2580CR Scuffed on 0.030" CRS	498 psi (3.44 MPa); cohesive failure (100%)
Valspar VP50 Scuffed on 0.030" CRS	418 psi (2.88 MPa); cohesive failure (100%)
Polyester Paint on 19 Ga 3003 H16 AL	483 psi (3.33 MPa); cohesive failure (100%)

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**Bond strength data was obtained using Fusor 800DTM/803DTM adhesive/sealant with 0.010" glass beads. Please contact LORD Corporation regarding the use and/or performance of using other combinations (+1 877 ASK LORD).

LORD TECHNICAL DATA

LORD Fusor® Repair Products Lifetime Guarantee*

LORD Corporation guarantees to the user 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 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.

LORD Corporation shall not be liable under any circumstance for any liability, loss, damage or expense directly or indirectly arising from the application and use of LORD Fusor Products sold hereunder or from any other cause. LORD Corporation shall not be liable under any circumstances for consequential, indirect or special 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 guarantee shall only apply to the above referenced LORD Fusor products sold by LORD Corporation on or after January 1, 2001.

LORD 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.

LORD 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 LORD 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 LORD Customer Support Center at +1 800 234 Fusor (3876) or visit Fusor.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 product is used after the date printed on the cartridge label. LORD Terms and Conditions of Sale shall apply to all sales of LORD Fusor products.*



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 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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