# Fusor® 2098 Crash Durable Structural Adhesive (Slow)

Technical Data Sheet

Fusor® 2098 adhesive is a two-component, epoxy-based, structural metal bonding adhesive providing the strength and durability of OEM quality repairs. It can be used for weld bonding, rivet bonding and bonding of replacement structural and non-structural auto body panels. Fusor 2098 adhesive replaces any structural adhesive currently used by automobile manufacturers, returning vehicles to pre-accident condition.

## Features and Benefits:

**Durable** – provides higher impact strength performance; restores original OEM, NVH and crash durability.

**Convenient** – allows heat-accelerated cure; weldable immediately after panel is positioned reducing cycle time.

**Versatile** – bonds plastic, e-coat and bare metals; adheres to all prepared steel and aluminum.

**Environmentally Resistant** – provides lifetime corrosion protection.

## Application:

**Prepare** – Follow the vehicle manufacturer's guidelines regarding the fastening of the replacement panel (welding, mechanical fasteners, or bond only) and their position on the removal of any metal coatings (zinc or aluminum coatings and e-coat).

Remove existing adhesive and e-coating from metal flange surfaces to which adhesive will be applied. Grind the surface of all mating flanges (not greater than 1 inch [25.4 mm]) using a 100-grit disk or finer.

Pre-fit the new panel to ensure proper alignment and plan the mechanical fastening (STRSW welds or rivets) and clamping locations for the final installation. If pull rivets or solid rivets are being used, then the holes should be drilled at this time. Wipe bonding surface with solvent (acetone, heptanes, isopropyl alcohol, MEK, etc.), leaving no residue.

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

Apply a small amount of adhesive to the bonding flange of both panels. Quickly spread adhesive over all bare metal, as a priming operation. Apply a 1/4 to 3/8 inch (6.4 to 9.5 mm) bead of adhesive to the prepared mating surfaces.

Secure the panel using clamps. Mating surfaces must be held in contact during the curing process. The glass beads in the adhesive will prevent over clamping. Apply screws or rivets in hard-to-clamp areas. After the panel has been positioned, do not pull it away from the vehicle. If repositioning is necessary, slide the panels against one another. This maintains contact between the two surfaces.

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.

| Typical Properties* | |
|---|---|
| Appearance | Blue Paste |
| Base Chemistry | Epoxy |
| Work Time | 90 minutes @ 70°F (21°C) |
| Clamp Time | 6 hours @ 70°F (21°C);<br>30 minutes @ 140°F (60°C) |
| Paint Time | 24 hours @ 70°F (21°C);<br>30 minutes @ 140°F (60°C) |
| Cure Time | 24 hours @ 70°F (21°C);<br>2 hours @ 140°F (60°C) |

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

**Finish** – Weld the panel (STRSW) or install the appropriate mechanical fasteners (rivets) in their respective locations. Once fastened, remove any remaining clamps or temporary fasteners. If a bond-only application, the clamps/fasteners may be removed after 6 hours at 70°F (21°C), or 30 minutes at 140°F (60°C).

Adhesive squeeze out may be tooled, or removed and surface wiped clean with a solvent. Adhesive is paintable, but must cure for 24 hours at room temperature. If heat cured at 140°F (60°C) for 30 minutes, adhesive may be painted immediately. Check paint system compatibility before proceeding. Applying a 2K sealer allows the refinish operation to begin more quickly when room temperature curing.

Cure requires 24 hours at room temperature (70°F [21°C]). Cure can be accelerated by applying heat [140°F (60°C)] for 1 hour.

## Shelf Life/Storage

Shelf life is 18 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.

| Bond Performance* | |
|---|---|
| Tensile Strength<br>DIN EN ISO 527-1 | 3190 psi (22 MPa) |
| Lap Shear Strength | |
| Cold Rolled Steel (DIN EN 1465) | 3336 psi (23 MPa) |
| Aluminum | 2466 psi (17 MPa) |
| Impact Wedge Peel<br>ISO 11343 | 171.3 pli (30 N/mm) |
| Elongation<br>DIN EN ISO 527-1 | 20% |

* 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.*

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