

Fusor[®] 141/140 Clear Plastic Bonding Adhesive (Fast)

Technical Data Sheet

Fusor[®] 141/140 adhesive is a two-component, urethane-based adhesive used for structural repair of bumper tabs, headlamps and other interior and exterior plastic components.

Features and Benefits:

Fast Cure – can be sanded and/or painted within 30 minutes.

Outstanding Adhesion – cured adhesive provides a high strength, flexible bond.

Versatile – bonds plastics, primed and painted metals, glass, wood and other surfaces.

Excellent Appearance – cures to a clear, non-yellowing surface.

Application:

Prepare – Before any plastic repair, identify whether a structural repair (torn or pierced) or cosmetic repair (surface scratches or gouging) will be necessary. Refer to Fusor 002 I-Car Alliance Training for details.

Using masking tape, cover any torn or exposed plastic on the front and rear of damaged area. Clean front and back sides of repair area with Fusor 703 adhesion prep/cleaner to remove silicones and contaminants.

Note: Structural repairs require application of a backer patch for strength.

Sand repair area with 80-grit sandpaper, and lightly contour if needed. Apply a light coat of Fusor 602EZ surface modifier to front and back side of repair area. Allow modifier to flash for 10-15 minutes.

Apply – Load the cartridge into the applicator and remove the end caps. 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 adhesive to the plastic repair area and spread evenly. If needed, immediately install Fusor 700 reinforcing mesh to the back side and smooth with a spreader. Adhesive can be applied to the front side of the repair area immediately or after the back side has cured.

Lightly abrade cured exposed adhesive with 80-grit sandpaper to remove gloss before applying additional fill to front of repair area.

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 for 30 minutes at room temperature before sanding. Slowly rough-sand the repair area with a DA sander using 80-grit sandpaper. For optimal results, contour with a block sander using 180- or 220-grit sandpaper. For minor surface imperfections such as pin holes or sand scratches, apply Fusor 114 plastic finishing adhesive and sand smooth. 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*

Appearance	Clear Paste
Base Chemistry	Urethane
Work Time	1 minute @ 70°F (21°C)
Clamp Time	5 minutes @ 70°F (21°C)
Sand Time	30 minutes @ 70°F (21°C)
Paint Time	30 minutes @ 70°F (21°C)
Cure Time	24 hours @ 70°F (21°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.

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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	
Primed Steel	1680 psi (11.6 MPa); cohesive failure
Polypropylene	432 psi (2.98 MPa); stock break
Torsional Impact Resistance GM 9751 P	
Primed Steel	No adhesive failure; >106 in-lb (>11.98 N-m)
Polypropylene	34.9 in-lb (3.9 N-m)

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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.*



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(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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