STANDARD OPERATING PROCEDURES

IDENTIFY
Check for OEM repair guidelines in order to determine if the application should be bond only, weld bond or rivet bond and then proceed with the proper Fusor® Standard Operating Procedure.

PREPARE
1. Remove the old panel using care not to damage remaining panels.
   **Tech Tip:** Where original panel is spot welded, use a spot weld removal tool to avoid damage to the mating panel.

2. Clean any remaining adhesive or sealers from bonding flanges.
   **Tech Tip:** Refer to OEM repair guidelines before removing any metal coatings (e.g. zinc coatings such as galvanizing). Always completely remove metal coatings leaving a shiny metal surface when using an acrylic adhesive.

3. Using new panel as a guide, confirm all bonding flanges are undamaged and mate up with the replacement panel. Make repairs as needed.

4. Prepare for the panel installation by having all necessary clamping devices on hand and determine if panel will be 100% weld bonded or if a butt-joint exists which will require MIG welding or MIG brazing.

5. Prepare bonding flanges on replacement panel to receive adhesive.
   **Tech Tip:** Follow OEM repair guidelines regarding the removal of e-coat and metal coatings on service parts. When removing coatings only do so in the bond area and avoid creating areas which are uncoated after the repair is complete.

6. Clean all bonding flanges with solvent.
   **Tech Tip:** Use a quick evaporating solvent, such as acetone or isopropyl alcohol that leaves no residue behind.

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APPLY

7. Prepare adhesive for application by purging the cartridge and leveling the plungers before installation of the mixing nozzle and running out a bead to ensure a homogeneous mix.

8. Apply adhesive to the bonding area.

**Tech Tip:** When using epoxy based adhesives, such as Fusor 208B or Fusor 2098*, always “butter” both bonding flanges first, and then follow up with application of the adhesive bonding bead. When using an acrylic adhesive, such as Fusor 108B, 108BE** or 112B, do not butter the flanges.

**Tech Tip:** If any MIG welded, or MIG brazed, joints exist hold the adhesive back 1” (25-mm) from the weld zone.

9. Install and clamp the panel in position.

**Tech Tip:** Once contact is made with the adhesive, slide the panel to its final position – do not separate panels.

**Tech Tip:** Do not release the clamps until the adhesive has reached its handling strength noted on the label or until mechanically fastened by welds. Application of heat to epoxies will accelerate the adhesive if desired for quicker clamp removal.

10. Begin squeeze type resistance spot welding (STRSW) the panel in position following the OEM or welder manufacture guidelines.

**Tech Tip:** Clamps may be removed as the welding progresses and when fully welded the vehicle may be moved even if adhesive has not fully cured.

FINISH

11. Before the adhesive begins to cure:
   - Tool any adhesive squeeze out (if using an epoxy); or,
   - Wipe off completely (if using an acrylic or epoxy).

*US Only
**Europe Only