

# Door Skin Installation Procedure using LORD Fusor® Metal Bonding Adhesives

## Materials Needed:

- LORD Fusor 108B/109B Metal Bonding Adhesive (Medium) or LORD Fusor 112B/113B Metal Bonding Adhesive (Slow)
- LORD Fusor 123/126 Non-Sag Seam Sealer (Fast), or LORD Fusor 123EZ/126EZ Non-Sag Seam Sealer (Medium)
- LORD Fusor 300 or 301 Manual Dispensing Gun, or LORD Fusor 304 or 304X Pneumatic Dispensing Gun

Both LORD Fusor® 108B/109B and 112B/113B metal bonding adhesives are recommended for door skin installation, depending on temperature and work time needed. For this repair procedure, LORD Fusor 108B/109B metal bonding adhesive will be used.

## Surface Preparation

1. Remove the damaged door skin. First, grind the outer edge of the hem with an angle grinder until you have cut through the outer skin. Then, remove the remaining door skin from the door frame with an air chisel.
2. Grind-weld nuggets flush with the door frame. Remove rust, adhesives, e-coatings or galvanized coating from any flange area where the LORD Fusor metal bonding adhesive (Stock #108B/109B) will be applied. If the metal has a pewter appearance, then all of the galvanized coating has not been removed. The metal should be shiny in appearance. Be careful not to damage the corners or thin the metal.
3. Straighten and align the door flange with a hammer and dolly.
4. On the new door skin, wherever bonding is to occur, scuff with an abrasive pad to remove the gloss of the e-coat. Clean all bond surfaces of dust and debris. Pre-fit the part for proper alignment

## Adhesive Preparation

1. Insert the LORD Fusor metal bonding adhesive cartridge (Stock #108B/109B) into the dispensing gun. Squeeze a small amount of product from each side of the cartridge to level the plungers.
2. Attach a mixing tip and dispense a small amount of adhesive, which is about the length and width of the mixer. Dispense until the product is evenly mixed and the color is consistent.

**Note: From this point you will have about 40-50 minutes at 70°F (21°C) to apply the adhesive and assemble the components.**

## Door Skin Installation

1. Apply a 3/8 to 1/2 inch (9.5 to 12.7 mm) bead of LORD Fusor metal bonding adhesive to the bare metal mating surfaces.
2. Properly position the new door skin. Once the door skin has been positioned, do not pull it away from the vehicle. If repositioning is necessary, slide the door skin. This maintains proper contact between the door skin and frame.
3. Clamp the frame and door skin together to hold alignment while rolling the hem flanges. Where possible, wipe excess adhesive from the door skin before it cures. This will save you time later.
4. Allow the adhesive to fully cure for 1-1/2 to 2 hours. Expect the adhesive to be a little "tacky" on the surface as this is a normal property of the adhesive.
5. Scuff the hemmed area with a scratch pad and prime per manufacturer's recommendations.
6. Use LORD Fusor non-sag seam sealer (Stock #123/126 or #123EZ/126EZ) wherever a cosmetic seam sealer is required.
7. Paint per manufacturer's recommendations.

**Note: For door skin replacement that involves sectioning, refer to Fusor Repair Procedure - *Procedure for Bonding Sectioning Joints with Overlap***

***Technique using LORD Fusor Adhesives, or Fusor Repair Procedure - Procedure for Sectioning Joints with Backer Plate using LORD Fusor Adhesives.***

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