



LORD Assembly-to-Repair Solutions for Heavy Duty Trucks

SELECTOR GUIDE

LORD
AskUsHow™

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For over 50 years, LORD Corporation has provided high-value product solutions and application expertise within the Heavy Duty Truck industry. Our Structural Adhesives offer a myriad of benefits including improved strength and durability, enhanced exterior aesthetics and reduced cost compared to mechanical fastening methods. Our material solutions are employed in all aspects of manufacture from design, to the assembly line and into repair and serve as industry benchmarks for quality, value and durability.

ASSEMBLY ADHESIVES	FUSOR REPAIR ADHESIVES	ELASTOMERIC MOUNTS
<ul style="list-style-type: none"> • Improve Aesthetics, Strength and Durability • Lightweighting Solutions • Shorten Assembly Time 	<ul style="list-style-type: none"> • Approved OEM Repair Procedures • Reduce Cycle Time • Identical Adhesive Technologies Used by OEMs 	<ul style="list-style-type: none"> • Improve Operator Comfort • Reduce Noise and Vibration

- 1 Composite Bonding
- 2 Door Bonding
- 3 Cab Bonding
- 4 Body Seam Sealing
- 5 Side Panel Bonding
- 6 Front Panel Bonding
- 7 Roof Panel Bonding

- 8 Metal Bonding/Sealing
- 9 Composite Bonding
- 10 Trailer Wall Repair Patch
- 11 Flexible Plastic Repair
- 12 Composite Repair

- 13 Engine Mounts
- 14 Cab Mounts
- 15 Hood Bushings & Mounts



PRODUCT SELECTION

Assembly & Repair Adhesives For more than half a century, we have developed and lead the way with innovative manufacturing, high-performance adhesives and body seam sealers. Our products employ the latest acrylic, epoxy and urethane technologies to meet our customers' demanding assembly needs while leveraging the same proven technologies to service the collision repair market.

PRODUCT	TYPICAL PROPERTIES*		
	Work Time	Mix Ratio	Time to Handling Strength
LORD 403 Acrylic Adhesive	2-4 min @ 75°F (24°C)	1:1	4-6 min @ 75°F (24°C)
LORD 406 Acrylic Adhesive	6-10 min @ 75°F (24°C)	1:1	12-17 min @ 75°F (24°C)
LORD 410 Acrylic Adhesive	20-30 min @ 75°F (24°C)	1:1	60-120 min @ 75°F (24°C)
Maxlok T3 Acrylic Adhesive	3-5 min @ 77°F (25°C)	4:1	6-8 min @ 77°F (25°C)
Maxlok T6 Acrylic Adhesive	6-9 min @ 77°F (25°C)	4:1	20-24 min @ 77°F (25°C)
Maxlok T18 Acrylic Adhesive	18-24 min @ 77°F (25°C)	4:1	48-72 min @ 77°F (25°C)
LORD 810 Low Read-Through Acrylic Adhesive	8-12 min @ 70°F (21°C)	2:1	20-25 min @ 70°F (21°C)
LORD 7542 Urethane Adhesive	Varies**	1:1	Varies**
LORD 7545 Urethane Adhesive	Varies**	1:1	Varies**
LORD 7555 Urethane Adhesive/Sealant	Varies**	1:1	Varies**
LORD 7610DTM Direct-to-Metal Adhesive/Sealant	25 min @ 77°F (25°C)	One Component	--

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

**See technical data sheet for multiple work times and handling strengths.

PRODUCT	TYPICAL PROPERTIES*		
	Work Time	Clamp Time	Paint Time
Fusor 108B Metal Bonding Adhesive	40-50 min @ 70°F (21°C)	Immediately when mechanically fastened / 1.5-2 hr @ 70°F (21°C)	--
Fusor 2098 Crash Durable Structural Adhesive	90 min @ 70°F (21°C)	Immediately when mechanically fastened / 6 hr @ 70°F (21°C)	24 hr @ 70°F (21°C)
Fusor 152 Plastic Repair Adhesive	3-5 min @ 70°F (21°C)	30 min @ 70°F (21°C)	2 hr @ 70°F (21°C)
Fusor 114LG Plastic Finishing Adhesive	1-2 min @ 70°F (21°C)	--	1 hr @ 70°F (21°C)
Fusor 100EZ Plastic Repair Adhesive	40 min @ 70°F (21°C)	3 hr @ 70°F (21°C)	1 hr @ 180°F (82°C)
Fusor T21 Composite Adhesive	45 min @ 70°F (21°C)	4 hr @ 70°F (21°C)	1 hr @ 180°F (82°C)
Fusor 800DTM/803DTM Direct-to-Metal Adhesive/Sealant	25 minutes @ 70°F (21°C), 50% RH	--	Immediately or up to 30 days without a scuff

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PRODUCT SELECTION

Elastomeric Mounts LORD mounts are designed to support engines, cabs and accessory units, and accommodate frame racking and twisting while isolating vibration and absorbing shock. LORD mounts provide effective vibration isolation and noise attenuation with a robust mount designs. Consistent performance, high load bearing capabilities and a choice of stiffness characteristics are key features.

PART	ELASTOMER	APPLICATIONS	SAP #
ASSEMBLY CENTER BONDED	Natural Rubber	Cabs, Engines, Gen Sets, Fans/Blowers, Heating-Cooling	CB-2205-3
SANDWICH	Natural Rubber	Fans/Blowers, Heating-Cooling, Pumps, Electric Motors	J-14056-4
SANDWICH	Natural Rubber	Fans/Blowers, Heating-Cooling, Pumps, Electric Motors	SMA095-1200-1
COUPLING	Natural Rubber	Fans/Blowers, Heating-Cooling, Pumps	LCD-15500-02-C
SANDWICH	Natural Rubber	Fans/Blowers, Heating-Cooling, Pumps, Electric Motors	J-5665-46
KIT SANDWICH SAFETIED	Natural Rubber	Engines, Gen Sets, Fans/Blowers, Heating-Cooling	SSB33-1000-4

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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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