

Drip Rail/Roof Ditch Seam Sealing Procedure using LORD Fusor® Adhesives

Materials Needed:

- LORD Fusor 703 Plastic & Rubber Cleaner
- LORD Fusor 122EZ/125EZ Self-Leveling Seam Sealer (Fast)
- LORD Fusor 300 or 301 Manual Dispensing Gun, or LORD Fusor 304 Pneumatic Dispensing Gun

LORD Fusor® Automotive Repair Systems has developed this repair procedure in conjunction with Ford Motor Company and the major aftermarket refinish paint companies. Ford Motor Company has a Technical Service Bulletin outlining their specific repair procedure.

To insure professional results, it is important that these instructions are followed exactly and the repair is refinished according to the paint manufacturer's recommendations. Refer to the proper refinish procedures for your paint system.

Surface Preparation

1. Remove original sealant materials from the roof ditch area using an air gun with a chisel bit.
2. Prep and clean the roof ditch area with 180-grit sandpaper and blow off with compressed air.
3. Wipe the area with LORD Fusor 703 plastic & rubber cleaner or a wax and grease remover.
4. Mix and apply one medium coat of primer, that is recommended by your paint line, to all bare metal in the roof ditch.
5. Allow the primer to fully cure per your paint manufacturer's recommendations.
6. Lightly scuff-sand the primer with P400-grit sandpaper or red Scotchbrite pad.
7. Blow off the roof ditch with compressed air. Do not use a cleaner after sanding.

Application Procedure

1. Stand the LORD Fusor 122EZ/125EZ self-leveling seam sealer in a vertical position (nose up) for 10-15 minutes before use, allowing air bubbles to rise to the top where they can be purged.

Note: It is very important that the seam sealer be placed in a vertical position to ensure proper air removal. If trapped air is not removed from the cartridge, multiple visible air bubbles in the seam could result during application, causing the paint to pop after refinishing. Be sure that all air has been removed from the product before you begin the repair.

2. Mask off all areas on the roof ditch that could be affected by spills.

Note: Do not use masking tape along the inside of the roof ditch channel. Any sealer that covers the tape during the application is not removable without damaging the cured sealer.

3. Apply masking tape to form a dam where the windshield pitch weld meets the front end of the roof ditch. The tape dam will prevent the sealer from flowing into the pinch weld. Remove the tape after the sealer has cured.

Note: If the windshield is in place, prop the windshield moulding up so it is level and use as a dam.

4. Position the vehicle so it is level front to rear.
5. Insert LORD Fusor 122EZ/125EZ seam sealer cartridge into the appropriate dispensing gun. Remove the plastic caps and squeeze out a small amount until both parts dispense equally. Keeping the gun in an upward position will push any air out first.
6. Attach the mixing tip keeping the gun tipped upward.

7. Dispense a small amount of material in an upward position to force the air out of the tube, then tilt the nozzle down and run out another small amount to verify air purging.

Note: Air bubbles may be present as the material passes through the mixing tip. After there are no more bubbles you are ready to begin the repair.

8. Starting from the back of the vehicle and moving forward, apply the sealer to the center of the channel allowing it to flow into the entire seam area. Keep the mixing tip in the sealer stream as you move down the channel.
9. Reduce the volume of sealer being applied as the curvature of the roof panel is being approached. Stop dispensing the sealer as soon as it begins to flow down the slope, and allow it to flow naturally.
10. No tooling should be needed, but if necessary, shape the bead within 3-5 minutes after application.
11. Allow sealer to cure for 45-60 minutes before paint application. If sealer has cured longer than 2 hours, scuff the surface with red Scotchbrite pad.

Note: Contact your paint manufacturer for specific paint procedures to prevent paint flex cracking on the surface.

Technical Tips

- Use one 300 ml cartridge per seam. Do not change cartridges in the middle of the seam.
- When inserting the cartridge in the dispensing gun, keep the gun pointed upward.
- When attaching the mixing tip, make sure the attaching nut is tight. This will prevent air from being sucked in and creating bubbles. Never cut off the mixing tip as it provides the correct back pressure for correct flow.
- When filling the channel, keep the flow as continuous as possible.
- Remove any visible air bubbles in the seam immediately after application by using a pin, pick or razor to pop each bubble individually.

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