

Safety First

When using solvents and adhesives, follow appropriate safety precautions. These include personal protection equipment (gloves & protective eye wear) and adequate ventilation. Refer to MSDS/SDS for complete information. Read all instructions before starting work.

Step 1 Prepare Substrate

Clean

Clean substrate to remove all surface contaminants:

- Use a clean, lint-free cloth and fresh cleaning solvent (CB911 or acetone is recommended). Saturate cloth with solvent and wipe substrate with a single rolling motion.
- Check cloth for residue. If present, fold cloth over to use a clean side, or use a fresh clean cloth and repeat wipe.

Tip: Always use clean side of cloth for each wipe. Never use same side more than once.

- If necessary, use clean dry cloth to remove any solvent left on substrate.

Wipe using a single rolling motion.



Abrade

Abrade substrate where part is to be installed:

- Use appropriate abrasive, and method. (Metallic 120-180 grit, Composite 160-180 grit)
- Caution:** If installing on composite substrate, do not damage fibers during abrading.
- Remove surface oxides, top coat, and primer to expose bare material.

Tip: Use random motion to abrade substrate.



Clean

Repeat cleaning process to remove abrasion residue:

- Solvent wipe the substrate with a single rolling motion.

Tip: Solvent clean progressively smaller areas to avoid introducing contamination.

- Check cloth for residue. If present, fold cloth over to use a clean side, or use a fresh clean cloth and repeat wipe.

Tip: Always use clean side of cloth for each wipe. Never use same side more than once.

- If necessary, use clean dry cloth to remove any solvent left on substrate.

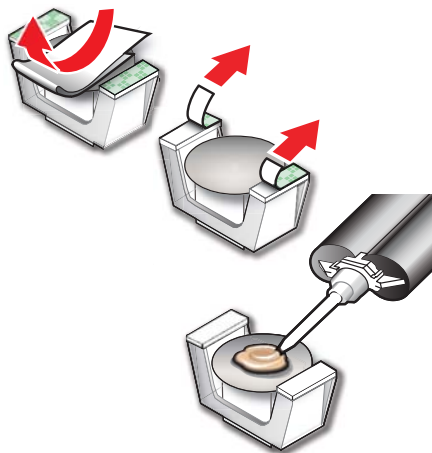
Wipe using a single rolling motion.



Step 2 Prepare Part

- Solvent wipe base of part with single rolling motion.
- Remove backing paper from feet of fixture.
- Apply adhesive to center of part base as shown.

Tip: Use enough adhesive to provide a small, uniform amount of squeeze-out when part is installed.

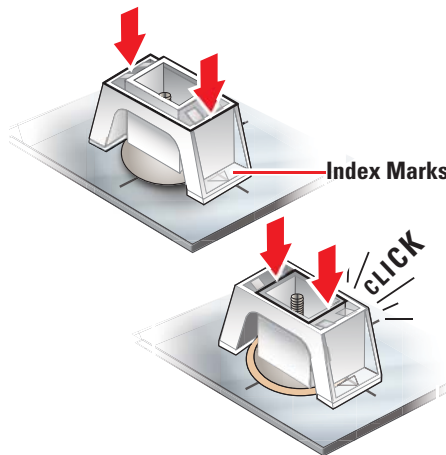


Step 3 Locate & Bond

- Position and align part.
 - Tip:** Use index marks on sides of fixture to aid proper placement.
- Press down firmly on **outer** body of fixture to adhere foam tape to substrate.
- Apply pressure to **inner** body of fixture until it clicks. Once fixture clicks down, no additional pressure is needed.

Caution: Do not press down on the part itself.

- Make sure adhesive squeeze out is visible all the way around base of part.



Step 4 Cure & Complete

- Allow adhesive to cure.
 - Do not wipe away adhesive squeeze out.
 - Do not disturb part or fixture during cure.
 - Refer to appropriate adhesive data sheet for cure times.
- Once adhesive is cured, remove installation fixture and discard.
- If necessary, touch up coatings.

