

Safety First

When using solvents and adhesives, follow appropriate safety precautions. These include use of personal protection equipment (gloves & protective eye wear) and adequate ventilation. Refer to 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.

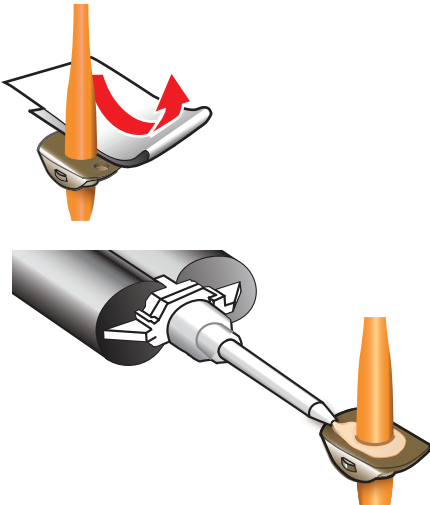
**Step 2 Prepare Part**

- Solvent wipe nutplate base with single rolling motion to remove residue.

Note: Unprimed parts should be abraded prior to solvent wipe.

- Apply adhesive evenly to nutplate base as shown.

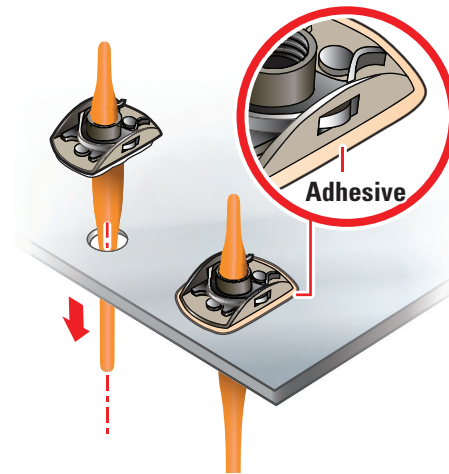
Tip: Use enough adhesive to give a small, uniform amount of "squeeze-out" when nutplate is pulled into place.

**Step 3 Locate & Bond**

- Align nutplate and use installation fixture to gently pull nutplate into place.

Caution: Take care not to pull too hard on installation fixture. It is important for installation fixture to remain with nutplate while adhesive cures.

- Make sure nutplate is seated securely against surface, and 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.

