

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.

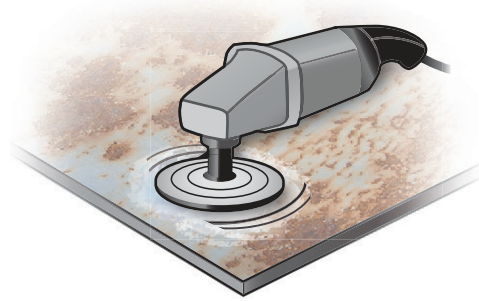


Abrade

Abrade substrate where part is to be installed:

- Use an A24R grinding disk to abrade substrate.
- 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.

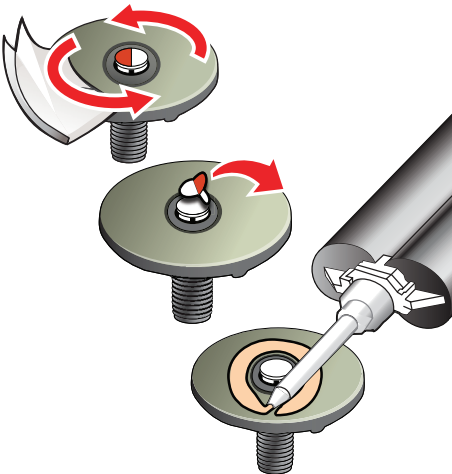
Wipe using a single rolling motion.



Step 2 Prepare Part

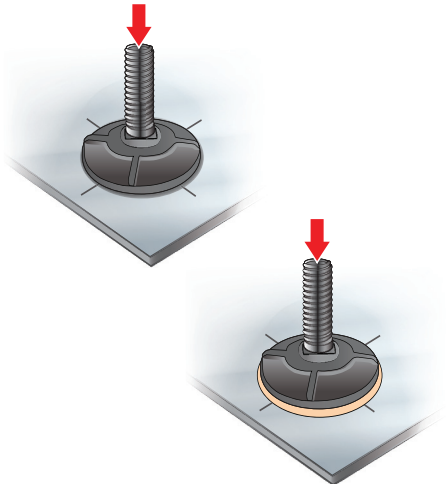
- Solvent wipe base of part with single circular motion.
- Remove backing tab from fixture in center of part.
- Apply adhesive to part base as shown.

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.
- Press lightly on center of part to adhere foam tape to substrate.
- Press firmly on center of part to actuate the internal fixture and seat part against substrate.
- Once adhesive squeeze out is visible all the way around base of part, remove pressure.



Step 4 Cure & Complete

- Allow adhesive to cure. Do not wipe away adhesive squeeze out. Do not disturb part during cure. Refer to appropriate adhesive data sheet for cure times.
- Installation is complete. If necessary, touch up coatings.

