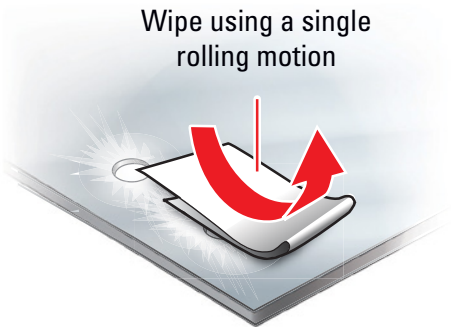
Safety First
When using solvents and adhesives, follow appropriate safety precaustions. These include use of personal protection equipment (gloves & protective eye wear) and adequate ventilation. Refer to MSDS/SDS for complete information. Read all instructions before starting work.

Preparing the Substrate

1 Solvent wipe substrate

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.



2 Abrade substrate

Abrade substrate where part is to be installed:

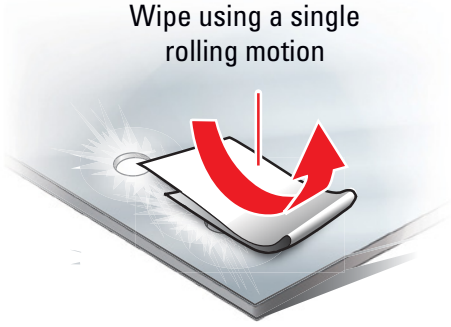
- Use appropriate abrasive, and method (36 grit aluminum oxide disc or A24R abrasive wheel). See figure 1 on reverse side.
  Caution: If installing on composite substrate, do not damage fibers during abrading.
- Remove surface oxides, top coat, and primer to expose bare material.
  Tip: Use random motion to abrade substrate.



3 Solvent wipe substrate again

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.



Preparing and Installing the Part

1 Prepare Part

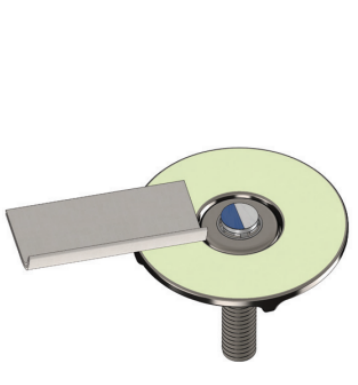
- Solvent wipe base of part with single rolling motion.
- Remove backing tab from fixture in center of part.
- Apply adhesive to part base as shown.
  Tip: Use enough adhesive to provide a small, uniform amount of squeeze-out when part is installed.

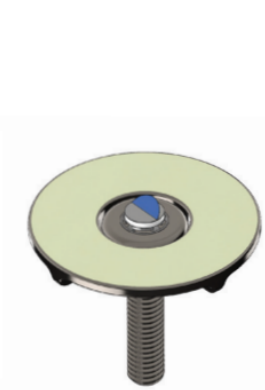
2 Locate and Bond

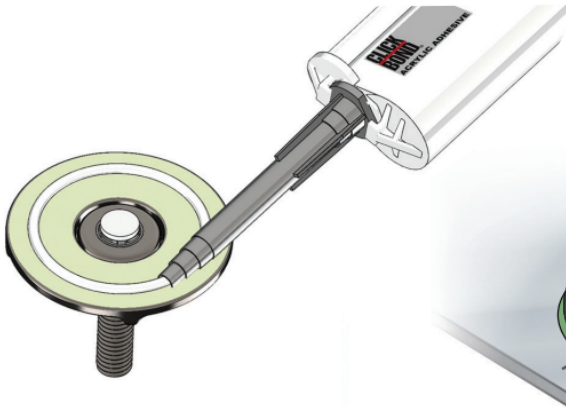
- Position and align part.
- Press lightly on center of part to adhere foam tape to substrate.
- Press firmly on center of stud and hold for three seconds to actuate the internal fixture and seat part against substrate.
- Once adhesive squeeze out is visible all the way around base of part, remove pressure.

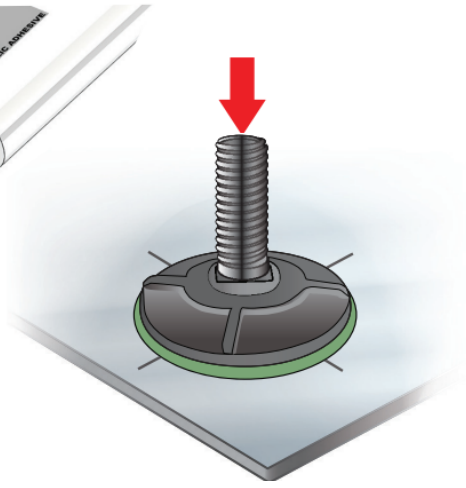
3 Cure and Complete

- 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.









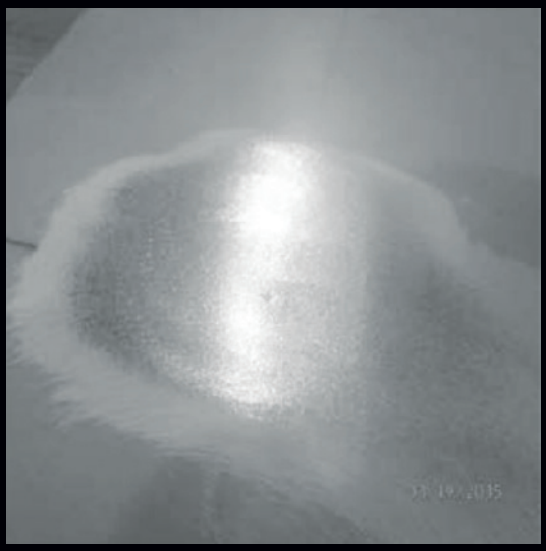
IMPORTANT: Have parts prepped before opening adhesive as working time is 5 minutes.

For more information including an instructional video, please scan this QR Code.

Figure 1. Using the correct aluminum oxide 36 grit pad achieves Surface Profile Finish (SPF11).

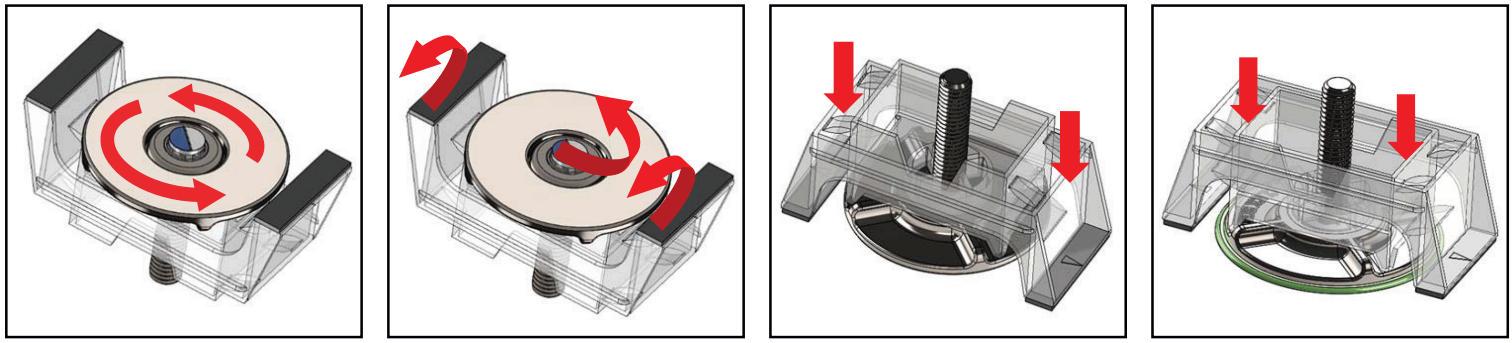


Good abrasion – rough surface



Bad abrasion – too polished a surface

For CB9715 studs longer than 3". Procedure for attachment of internally fixtured Click Bond fastener with external fixture. support.



ENFASCO

©2023 Click Bond, Inc. All rights reserved. Click Bond and the stylized logo are trademarks or registered trademarks, of Click Bond, Inc. Registered, U.S. Patent and Trademark Office.

CB7200302-A