

REQUIREMENTS FOR BONDING METAL INSERTS AND CARBON COMPOSITE

NECESSARY MATERIALS

Epoxy Glue: Araldite type 2031
(alternative: Sika Adegit A290)

HELP MATERIALS AND TOOLS

degreaser - acetone
cleaning cloth
glue gun for Araldite
tape measure and marker or pencil
sandpaper
crosscut saw with diamond blade
(column) drilling machine with 3 mm drill
tools for gluing: weights, templates, clamps

SAFETY AND HEALTH

We value your safety and health.
Provide the following safety features when you work with carbon and adhesive products.

- work in an area with good ventilation / exhaustion.
- always use safety glasses and gloves.
- wear a dust mask when cutting and gluing.
- wear a shirt with long sleeves.
- work with good and sharp tools.

PERSONAL PROTECTIVE EQUIPMENT



safety glasses, dust cover, silicone gloves

WORK INSTRUCTION

Provide a clean and tidy workplace.
This benefits your end result!

1. Thoroughly degrease the adhesive surface and tools with acetone, use a clean cloth.
2. Lightly roughen the surface to be glued with fine sandpaper.
3. Thoroughly degrease the adhesive surface with acetone, use a clean cloth.
4. Protect the surrounding areas by covering them with tape. This prevents any damage and annoying adhesive residues.
5. Degrease the surfaces to be glued again with acetone. make sure you work with a new clean cloth.
6. Place the 2-component glue cartridge in the glue gun

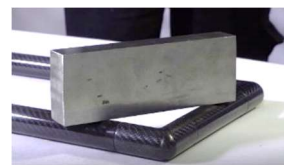


according to the supplied instructions and remove the screw cap. **Test on** a cloth to see if glue and hardener flows from both openings.

7. Wipe

off residual glue with cloth, **place the Mixing tube** and squeeze the glue through the mixing tube to the end. You are now ready to start gluing.

8. Apply enough glue gently to the entire surface and bring the parts together.
9. Immediately wipe off excess glue with a cloth and some acetone.
10. Let the glue harden, place the products on a flat table or in an auxiliary mold. Stop moving the parts.
11. The adhesive is dry after approx. 8 - 10 hours but not yet fully cured. Only after 24 hours is the adhesive fully cured and resilient. (at 20 degrees ambient temperature). Adegit A290 is a fast curing alternative.



12. Carefully remove any adhesive residue with a utility knife.

Good luck! on behalf of the Carbonwebshop team

Araldite 2031 information table curing times at different temperatures.

Times to minimum shear strength				
Temperature	°C	15	23	40
Cure time to reach	hours	7	4	2
LSS > 1N/mm ²	minutes	-	-	-
Cure time to reach	hours	22	10	4
LSS > 10N/mm ²	minutes	-	-	-

LSS = Lap shear strength.