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TELESCOPING TUBE ASSEMBLY INSTRUCTIONS

Step 1: Dry Fit and Sanding

Start by preparing tube end and threaded collet end by lightly sanding. Dry fit collet end and apply masking tape to protect all but the area to be bonded. Sand both tube end and inside of threaded collet ring. Use a rag to clean tube end and collet end.



Step 2: Mix Epoxy and Microspheres

Mix together epoxy adhesive (we recommend 3M Scotch-Weld 2216) according to manufacturer's instructions. Add microspheres to epoxy mix, 10% by weight (i.e. 0.3g microspheres per 3g of epoxy) and mix thoroughly.



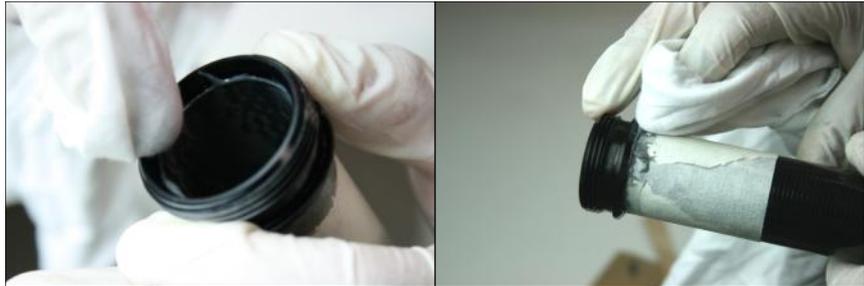
Step 3: Apply Epoxy

Evenly apply epoxy to both tube end and inside of collet ring and fit collet end over end of tube.



Step 4: Clean Up

Clean both inside and outside of collet ring using a rag lightly soaked with isopropyl alcohol, acetone, or MEK.



Step 5: Remove Tape & Cure

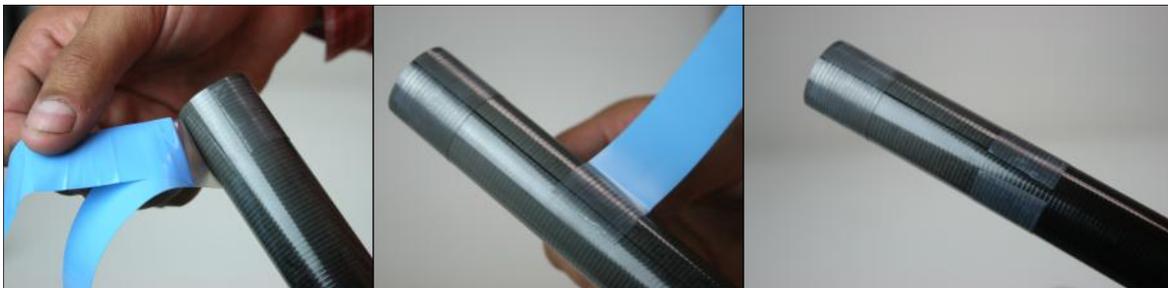
Remove masking tape and apply additional masking tape to securely hold collet ring to end of tube.

Allow bond to cure. At room temperature (75 degrees F), adhesive will cure overnight. Faster cures are obtained using elevated temperatures. Refer to the tech sheet for Scotch-weld epoxy 2216B/A Gray for further information.



Step 6: Apply End Stop Tape

Apply provided end stop tape to end of connecting tube. Tape will provide a "stop" so that when tubes are extended, they will not completely pull apart. Tape can be applied only to end of tube or two pieces can be applied (shown in picture) to provide maximum strength and stability of extended pole.



Step 7: Joint Assembly

To assemble joint, slide the collet nut and compression ring over tube with stop tape and insert into connecting tube as shown in picture. For maximum frictional hold, we recommend lightly sanding the carbon fiber tubes to remove the gloss finish and wrap lines.

