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MODULAR CONNECTOR ASSEMBLY INSTRUCTIONS

Modular Connector Kit

Each Modular Connector Kit comes with an aluminum connector, foam plug (already inserted into the connector) and enough microspheres to ensure proper bond fit.

You will also need a two-part epoxy (we recommend 3M Scotchweld 2216) sold separately.



Step 1: Sand Bonding Area

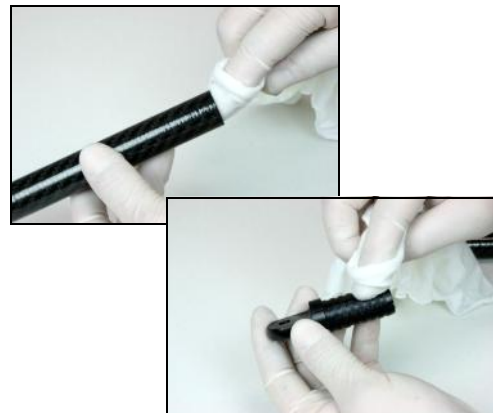
Wrap 150 grit sandpaper around the included foam sanding tool and insert into end of tube. Scuff inside of tube to the appropriate depth. Sand hard enough to break the skin of epoxy resin. Do not sand too deeply as the result may cut or damage underlying fibers. This will compromise the integrity of the carbon fiber tube.

Also scuff outside of connector with sandpaper.



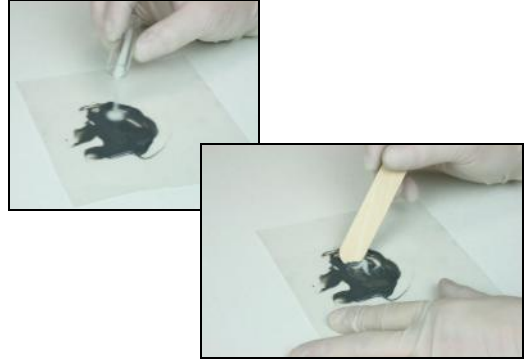
Step 2: Clean Surfaces

The pieces must be cleaned to remove any contaminants. Wipe components to be bonded (inside of tube, and connector) with a solvent such as acetone or isopropyl alcohol to remove all dust, dirt, and grease.



Step 3: Mixing Epoxy & Microspheres

Mix epoxy according to manufactures instructions and add supplied microspheres. Mix ratio of microspheres is 10% by weight. For example, 0.3 grams of microspheres per 3 grams of epoxy.



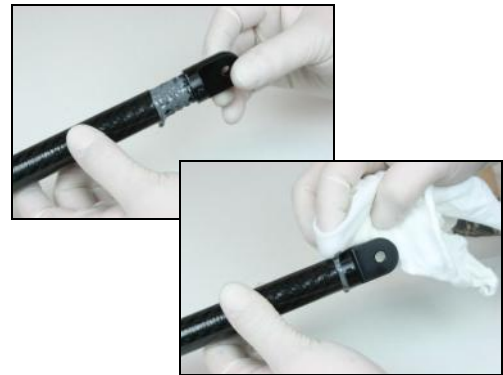
Step 4: Apply Epoxy

First apply epoxy to the inside of the tube, making sure to get equal coverage to a sufficient depth. Next evenly spread the epoxy on the connector legs.



Step 5: Insert Connector

Insert connector into tube and remove excess epoxy with a cloth dampened with isopropyl alcohol, acetone, or MEK.



Step 6: Allow to Cure

Apply masking tape over connector to secure until epoxy has fully cured.

Allow connector to cure overnight at room temperature (75 degrees F). Faster cures are obtained using elevated temperatures. Refer to the tech sheet for your epoxy for further information on cure times.

