Fastener/ Composite Inserts

Aluminum Washer and Mating Nut
Pre-treated for Enhanced Composite Bonding
Sizes  2-56, 4-40, 6-32

Handling Instructions
DO NOT sand, prime, or otherwise prep before gluing. Parts are ready for direct bonding using standard epoxy systems. The bonding surface of the insert is compatible with epoxy system that require heat cure, heating will not damage the bonding surface. Handle with gloves or tweezers as oils from your hand will contaminate the pre-prepped bonding surface. If cleaning is required, use compressed dry air or acetone only. Wash with acetone and then allow it to dry completely. Once dry, you may bond using a standard epoxy system. Do not remove the inserts from the sealed bag until ready for cleaning and bonding.

Warning
Parts are pretreated with a bonded resin. Exposed surface is reactive and can cause skin irritation. Do not allow the surface of the insert to come in contact with skin. Always wear gloves.

Bonding Directions
Pre-drill and prep the bonding area of the composite you wish to laminate an insert to. The inserts can be used to pre-check the drilled hole for good-fit before bonding. It is important to clean the area beforehand so the insert does not become contaminated with dust or debris. After preparing the composite surface for bonding, place a small amount of premixed two-part epoxy on the insert, composite, or both. Do not overuse the amount of adhesive as it will run in the threads of the insert. Press the insert into place carefully. Again, do not to allow epoxy into the threaded or thru-hole areas. Clamping can be used if necessary to ensure proper fit and location.

The bonding surface of the insert is compatible with two-part epoxy system. If your epoxy requires heat curing, rest assured that heating will not damage the bonding surface.

Note
Some epoxy systems may cure faster when they come into contact with the inserts pre-treated surface. Any external surface of the insert not used to bond to the composite may be sealed with a thin coating of two part epoxy.

Functionality
- Parts are made from 6061-T6 Aluminum
- Aluminum Washer and Mating Nut, Pre treated for Composite Bonding
- All parts have Vindicoat CTXPTT coatings, greatly increasing adhesion to standard epoxy systems.
- This product is manufactured and sold by LumaDyne.
- Includes three pairs of the designated size of inserts and fasteners, bag will contain three washers and three nuts.

Pre-Treatment Technology
This product contains CTXPTT treatment by Vindicoat, LLC, Patent Pending. For more information regarding the latest advancements in conversion coating visit Vindicoat.com.
Fastener/ Composite Insert Directions

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**Step 1**

Pre-drill and prep the bonding area of the composite you wish to laminate an insert to. It is important to clean the area beforehand so the insert does not become contaminated with dust or debris.

**Step 2**

After preparing the composite surface for bonding, place a small amount of premixed two-part epoxy on the insert, composite, or both.

**Step 3**

Do not overuse the amount of adhesive as it will run in the threads of the insert, but ensure that a thin layer of the epoxy is covering all surfaces that will be in contact with the inserts.

**Step 4**

Handle with gloves or tweezers as oils from your hand will contaminate the pre-prepped bonding surface and inserts. Press the insert into place carefully.

**Step 5**

Once insert is placed, reapply a thin layer of epoxy. Make sure not to get any access epoxy in the insert, just apply to where it comes into contact with surrounding area.

**Step 6**

Let the epoxy set and cure.