



321 Route 5 West · Elbridge · New York · 13060
315-252-2559 service@dragonplate.com

GUSSET ASSEMBLY INSTRUCTIONS

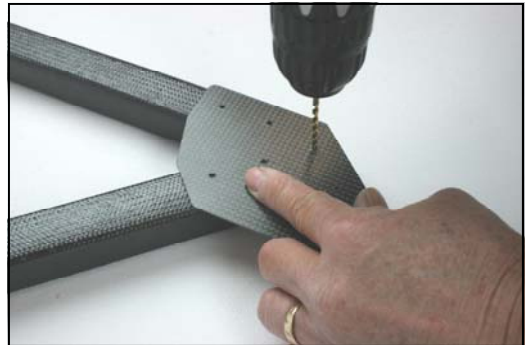
Step 1: Mock up Joint

Mock up the tubes and the gusset plates. Using the gusset plate, trace outside profile onto mocked up tubes.



Step 2: Match Drill

Using the gusset plate, match drill the 1/8" rivet holes into the carbon fiber tube. This will help locate and hold the gusset plate while the adhesive cures.



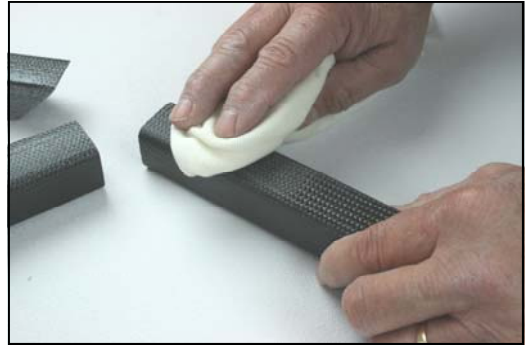
Step 3: Sand Bond Area

Scuff inside the marked profile using 150 grit sandpaper. Sand hard enough to break the top skin of the epoxy resin. Do NOT sand too deeply as the result may cut or damage underlying fibers of the tube!! This will compromise the integrity of the tube.



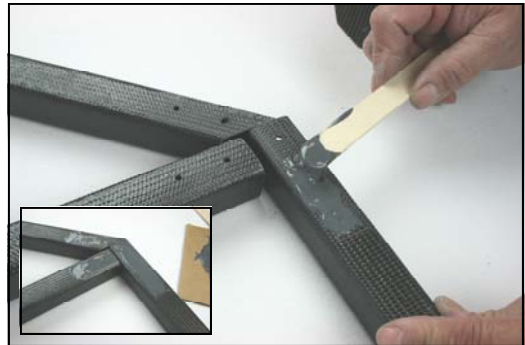
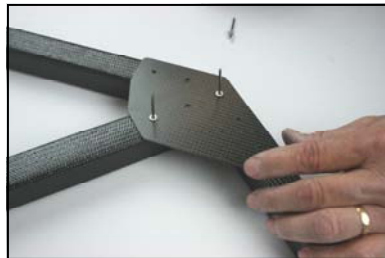
Step 4: Clean Surface

The pieces must be cleaned to remove any contaminants. Wipe with a solvent such as acetone or isopropyl alcohol to remove all dust, dirt and grease.



Step 5: Apply Scotch-weld Epoxy

Apply Scotch-weld Epoxy to a clean, dry surface on the Carbon Fiber tubes. Make sure to apply epoxy up to the marked line. Place gusset plate onto Scotch-weld epoxy using rivets to locate the gusset plate.



Step 6: Rivet Gusset to Tube

Use supplied pop rivets to hold plate in place while the Scotch-weld cures.



Step 7: Clean up

Remove unhardened excess materials with a cloth dampened with Isopropyl, Acetone, or MEK.

Repeat steps to attach gusset to opposite side of joint.

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

