

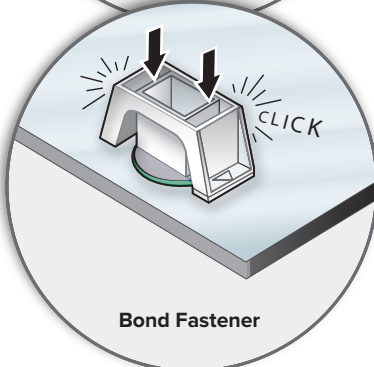


ADHESIVE-BONDED FASTENERS

No more welding or drilling on your expensive assets!

Click Bond Adhesive-Bonded Fastener Technology...

- > Enhances Structural Strength and Integrity
- > Streamlines Manufacturing
- > Facilitates Repair



Click Bond, Inc. is a pioneer in the research and development of adhesive-bonded fasteners. Click Bond fasteners are used extensively in aerospace, mining, military, agriculture, and construction and are now specifically designed for the marine and offshore industries. A collection of fastening solutions has received approval from the American Bureau of Shipping (ABS) and Lloyd's Register.

Click Bond fasteners are attached using structural adhesives resistant to salt water, fuel, oils, and hydraulic fluids. The adhesive provides a chemical barrier that inhibits galvanic corrosion.

Click Bond's product line sets the benchmark for high-performance, adhesive-bonded fasteners. Constructed of durable, marine-grade, 316 stainless steel, Click Bond fasteners provide strong, watertight, corrosion-resistant attachments that streamline production, increase safety, and enhance structural integrity by eliminating the need for welding or drilling.

All Click Bond adhesive-bonded fasteners are supplied with disposable installation fixtures. These fixtures clamp the fasteners in place under positive pressure while the adhesive cures. This ensures optimal joint strength and bond-line consistency.





Use Click Bond Fasteners to:

- Reduce costs by eliminating:
 - Hot work (welding)
 - Gas freeing of fuel and storage tanks
 - Fire watch
- Maximise design and work sequence flexibility
- Reduce subcontractor labour time for installations - 3 minutes for a bonded stud installation from initial prep to final stud installation
- Improve structural strength and integrity by eliminating welding
- Minimise corrosion and potential leak paths by reducing through-holes
- Facilitate and simplify field installations and system upgrades
- Reduce risk to sensitive electronic equipment



Click Bond Product Range

Mounts

Image	Part No. & Description	Performance
	TCM460VG5 Low-Profile Cable-Tie Mount	Exceeds MIL-STD-3367 50 lbs (23 kg) requirement
	TCM902 Miniature Cable-Tie Mount	Click Bond Ultimate Load: Exceeds MS3367 50 lbs (23 kg) requirement
	TCM905 Strap-Loop Mount	Click Bond Ultimate Load: 600 lbs (272 kg) Tension 600 lbs (272 kg) Shear
	TCM989 Fixed Tie-Down Ring 2.00" (50.8 mm) Diameter Base	Click Bond Ultimate Load: 5 000 lbs (2 268 kg) Tension 1 000 lbs (454 kg) Lateral Pull

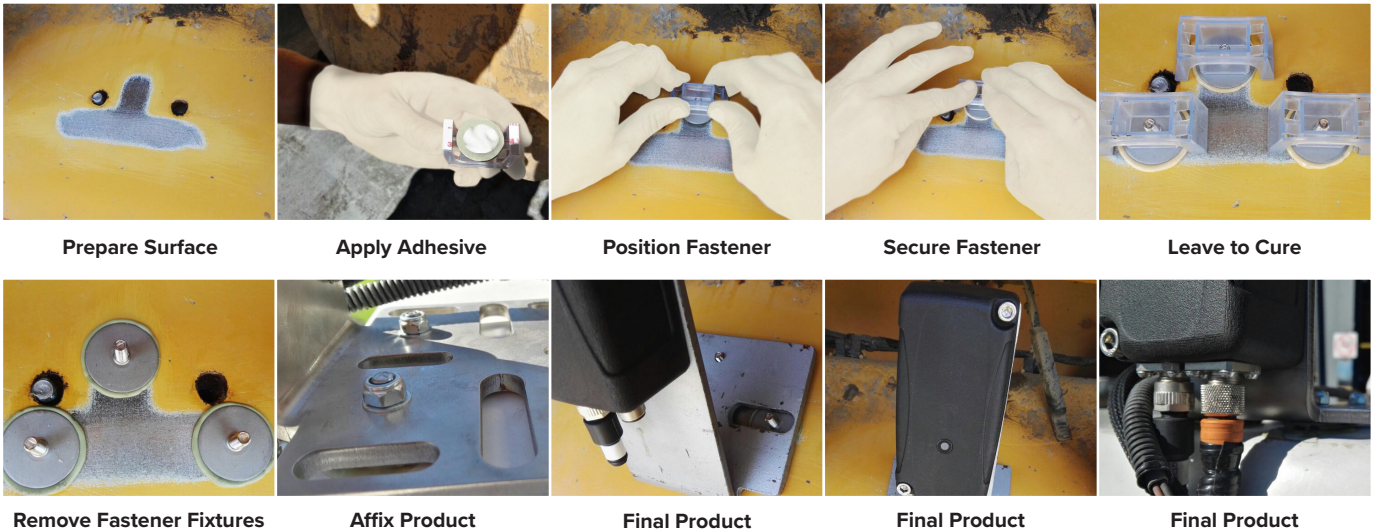
Studs

Image	Part No. & Description	Performance
	TCS125* Threaded Stud 1.25" (31.8 mm) Diameter Base	Design Load: 75 lbs (34 kg) Tension 150 lbs (68 kg) Shear Click Bond Ultimate Load: 1 000 lbs (454 kg) Tension 2 000 lbs (908 kg) Shear
	TCS200* Threaded Stud 2.00" (50.8 mm) Diameter Base	Design Load: 100 lbs (45 kg) Tension 450 lbs (204 kg) Shear Click Bond Ultimate Load: 1 700 lbs (771 kg) Tension 4 000 lbs (1 814 kg) Shear
	TCS922 High-Shock Deck Stud 2.63" (66.8 mm) Diameter Base	Design Load: 500 lbs (227 kg) Tension 900 lbs (408 kg) Shear Click Bond Ultimate Load: 6 000 lbs (2 722 kg) Tension 9 000 lbs (4 082 kg) Shear
	TCS915 Self-Fixturing Stud 2.63" (66.8 mm) Diameter Base	Click Bond Ultimate Load: 5 000 lbs (2 268 kg) Tension 3 000 lbs (1 361 kg) Shear
	TCB9784 Electrical Grounding Spacer Stud 2.00" (50.8 mm) Diameter Base	Click Bond Ultimate Load: 1 700 lbs (771 kg) Tension 4 000 lbs (1 814 kg) Shear



American Bureau of Shipping (ABS) Certified Approved Product.

Weld-Free Installation of a PPS Antenna Unit



Prepare Surface

Apply Adhesive

Position Fastener

Secure Fastener

Leave to Cure

Remove Fastener Fixtures

Affix Product

Final Product

Final Product

Final Product



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Click Bond Product Range

Adhesives

Part No.	Mix Ratio (Vol.)	Cure Properties (at room temp. 72 °F/22 °C)				
		Working Time	Handling Strength	75% Strength	90% Strength	Full Strength
 TCB420-50	10:1	4-6 min	18 min	15-18 min	--	24 hrs
 TCB200-40	8:1	5 min	20 min	--	2 hrs	24 hrs

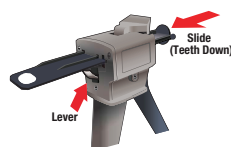
Dispensing

Image	Part No. & Description
	TCB100-81 Manual Dispenser and Slide
	TCB106 Mixing Tip

Click Bond products have been an integral part of commercial aerospace, military, and private watercraft for more than 30 years and continue to pioneer advanced solutions!

Manual Adhesive Dispenser Instructions

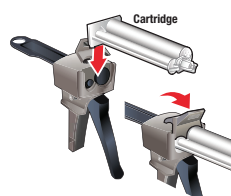
Safety First: When using solvents and adhesives, follow appropriate safety precautions. These include personal protection equipment (gloves & protective eye wear) and adequate ventilation. Refer to MSDS/SDS for complete information. Read all instructions before starting work.



Step 1 - Insert Slide

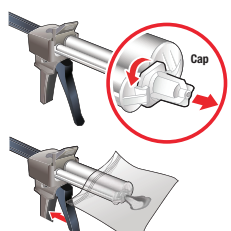
- Lift the slide release lever and push the dispenser slide completely into the handle (teeth facing down). Use the following adhesive cartridge and dispenser slide combinations:

Cartridge	Slide	Cartridge	Slide
TCB420-50	TCB81	TCB200-40	TCB81



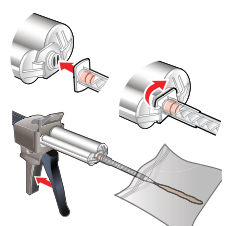
Step 2 - Insert Cartridge

- Check the adhesive expiration date - discard expired adhesive.
- Remove the black protective clip on the back of the cartridge, if present.
- Insert the adhesive cartridge into the slot and lower the retainer to lock it in place.



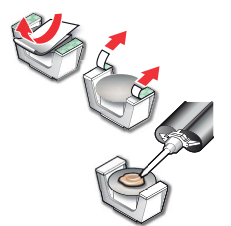
Step 3 - Remove the End Cap & Check

- Remove cap - turn counterclockwise.
- Squeeze the trigger slowly to dispense a small amount of adhesive into a plastic packaging bag. Check that both components flow from the cartridge.
- Knead components through the bag wall. Check that each component has an even colour and consistency.



Step 4 - Attach Mixing Tip & Check

- Attach the mixing tip and turn it clockwise to lock in place.
- Tip:** Only use the TCB106 mixing tip.
- Squeeze the trigger slowly to dispense a bead of adhesive, about the length of the mixing tip, into a plastic packaging bag. Check that the adhesive mixes consistently.



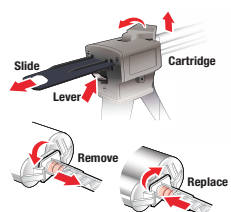
Step 5 - Apply

- Squeeze the trigger slowly to dispense the adhesive. Refer to appropriate fastener installation instructions for specific application details. See adhesive working, handling, and cure times below.
- Caution:** If working time is exceeded, purge partially cured adhesive from the mixing tip. Do not apply excessive force to dispense. If adhesive cures in the mixing tip, replace it with a new tip (do not cut).

Adhesive	Working Time	Handling Strength	Full Cure
TCB420-50	5 min	20 min	24 hrs
TCB200-40	5 min	30 min	24 hrs

*Accelerated Full Cure: 1 hr at 180 °F (82 °C).

Note: All times are measured at 75 °C (24 °C) and are significantly affected by temperature. Refer to the adhesive data sheet for more details.



Step 6 - Finish

- Lift the slide release lever and pull back the dispenser slide to relieve pressure on the cartridge.
- Lift the retainer and remove the cartridge from the dispenser - leave the mixing tip in place or replace the cap.
- To use the remaining adhesive, attach a new mixing tip.

Streamlining the Design and Manufacturing of Production Vehicles

Example of Fastener Solutions for Rigorous Environments



TCM319
Swivel Cable-Tie Mount



Bonded fasteners eliminate fastener holes, holes that both compromise the structural integrity of the vehicles and create leak paths that can result in corrosion or environmental intrusion.



TCS922
High-Shock Deck Stud



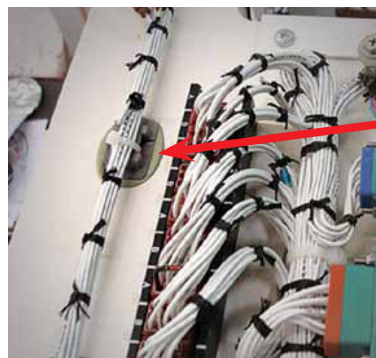
TCM988
Flush Tie-Down Ring



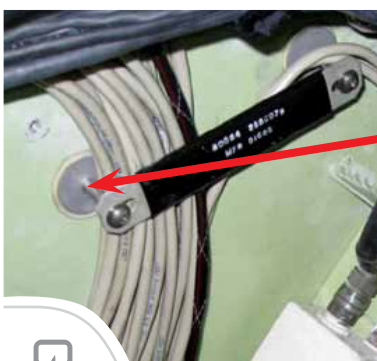
TCM905
Strap Loop Mount



TCS200
Threaded Stud



TCB460VG5
Low-Profile Cable-Tie Mount



TCN200
Threaded Standoff



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