

**Using AT-8040 No Slide High Strength Metal and Composites Bonding Adhesive**

AT-8040 is a two-part acrylic adhesive, which was specifically developed with high viscosity for bonding and holding in place our Weld Mount System fasteners to most metals, plastics, and composite surfaces. AT-8040 is a 1 to 1 adhesive which is packaged in a 50 ML cartridge for use in conjunction with our AT-300 dispensing gun and NEW AT-850 mixing tip. It is also available as AT-8040M which is a 30 ML side by side cartridge with manual plunger for hand mixing of the two components. Proper mixing is important. AT-8040 sets in approximately 10-12 minutes, develops working strength in 25 minutes and dries to a gold color. Please note the following before use:

1. **AT-8040 Adhesive** has a shelf life of one year when properly refrigerated. We recommend that the adhesive be refrigerated when not in use to obtain the maximum shelf life. Do not leave adhesive in high temperature locations as this will severely reduce the shelf life. Expiration dates on the adhesive are approximate as we can not control storage conditions.
2. If there is any doubt that the adhesive is still good test a small amount first before you begin the installation project. Dispense and mix a small amount of product by hand and make sure it gets completely hard. If the adhesive is bad it will not completely harden and you can push your finger nail into it.
3. When using a new tube of adhesive put the cartridge in the gun and remove the protective cap. Save the cap to reseal it later. As air voids or uneven cartridge filling may be possible it is advisable to discard the first bit of material which comes out of the cartridge before affixing the AT-850 mixing tip. Check to insure both cartridges are dispensing material uniformly.
4. AT-8040 is a high viscosity material so **all of our parts can be mounted on vertical or overhead surfaces without sliding.**
5. When mounting apply enough adhesive to the center of the base that when pressure is applied the adhesive is visible 360 degrees around the base.
6. Then rotate the stud clockwise slightly while pressing downwards until the stud will not turn. This allows the adhesive to grab onto the substrate and prevents it from sliding. The adhesive will kick in 12 minutes and you can begin to work with the parts after 35 minutes.
7. If you use too much adhesive or locate the part in the wrong location remove it immediately and wipe all surfaces with solvent and reapply. After some practice you will quickly learn how much adhesive to apply.
8. AT-8040 is temperature sensitive. For every 10 degrees drop in temperature below 72 degrees the kick time doubles. 50 degrees is the lowest temperature limit. Below this temperature it will not set. The normal bond strength for this adhesive is 3500 lbs. (Tensile). Full bond strength is achieved after 24 hours. AT-8040 can be used on irregular surfaces as this adhesive is gap filling to ¼”.
9. One 50 ML cartridge is sufficient for approximately 75 parts (continuous bonding).
10. If you stop dispensing the adhesive will set up in the mixing tube within roughly 4 minutes. Do not try to force the adhesive out of the nozzle as this may cause the cartridge to leak or you will strip the plunger on the gun. We recommend you purchase 5 mixing tips with each cartridge of adhesive.
11. Do not store the adhesive cartridge with the mixing tip attached. After use, remove the mixing tip, wipe the opening, and place the cap back on the cartridge as soon as possible. You will notice the cap has a “V notch” in it that only allows replacement one way. Before reuse check to make sure that both sides of the cartridge are flowing freely before installing a new tip.
12. While specifically designed for bonding to most substrates, AT-8040 will not bond well to soft rubber, low energy plastics such as polypropylene and starboard, leather, brass or bronze. It is the user's responsibility to test this product for the intended application.
13. While extensive surface preparation is not required excess dust can interfere with the bond strength of the adhesive. We recommend you solvent wipe both surfaces to remove excessive dust, or any grease and oil to achieve the best results. While AT-8040 bonds to most painted surfaces your bond will only be as strong as the paint bond is to the substrate so testing should be carried out to see if the paint needs to be removed.
14. Please review the warning information on the cartridge label.