



MARQUESA MARINE THREADED DECK BOLT INSTALLATION GUIDE

Threaded Deck Bolt – Tools/Materials Needed

- Pencil or Sharpie
- Painter's tape
- Nitrile or latex gloves
- Power drill
 - 1/8-inch drill bit (or another similar sized small bit)
 - 3/8-inch drill bit
- 11/16-inch socket and driver
- 5 mm hex key (allen wrench)
- 3M 4000 UV adhesive sealant, 3M 4200 adhesive sealant, or 3M 5200 adhesive sealant (select the best adhesive sealant for your application, each product listed has unique strengths, more information on these products is available directly through 3M)
- Angle grinder or hacksaw (optional)

Threaded Deck Bolt – Installation

1. Determine the ideal mounting location on your deck for the threaded deck bolt. Ensure that there is adequate access on the underside of the deck (if there is no access, the Marquesa Marine threaded deck plate may be used). Place painter's tape over the chosen mounting location (this will help to reduce gel-coat chipping when drilling).
2. Mark the mounting location on the painter's tape with a pencil.
3. Drill a hole through the deck at the marked location with the 1/8-inch drill bit being sure to keep the drill properly positioned so that the hole is straight.
4. Using the 1/8-inch hole as a guide, run the 3/8-inch drill bit in reverse, using very light pressure, (this will reduce gel-coat chipping) until you have made it through the gelcoat and fiberglass skin. Once the bit is in the core material, you can run it forward to remove the core. At this point you can either drill straight through (doing so may cause chipping on the underside) or go to the underside of the deck and run the bit in reverse until you have made it through the gelcoat and/or fiberglass laminate.



5. With the hole drilled, you can now insert the 3/8-inch threaded deck bolt and check fitment. For the cleanest installation: mark the excess threads of the bolt with a sharpie (accounting for the nut and washer), then take the bolt to a vise and cut off the excess threads with an angle grinder or hacksaw. Clean up the rough edges with a file if necessary.
6. Place painter's tape around the hole to keep excess adhesive from getting on the deck.
7. Wearing nitrile or latex gloves, apply 3M 4000 UV adhesive, 3M 4200 adhesive, or 3M 5200 adhesive to the threaded deck bolt, the hole, and one side of the washer.
8. Insert the threaded deck bolt into the hole and tighten into place using the 5mm hex key and the 11/16-inch socket until the bolt head and washer are snug to the deck. **DO NOT OVERTIGHTEN THE NUT OR YOU WILL COMPRESS THE CORE MATERIAL OF YOUR DECK.** Once cured, the adhesive sealant will be sufficient to hold the deck bolt in place. Overtightening the bolt will only weaken your deck.
9. Remove the painter's tape and clean up excess adhesive sealant using a cloth or paper towels with isopropyl alcohol or acetone. A small plastic scraper stick may be useful to remove most of the excess adhesive sealant.
10. Allow the adhesive sealant to fully cure according to the manufacturer's instructions before using the threaded deck bolt.