



MARQUESA MARINE TITANIUM THREADED DECK BOLT INSTALLATION GUIDE

Titanium Threaded Deck Bolt Installation – 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)
 - 1/2-inch drill bit
- 2x 1/2-inch crescent wrenches
- 3/4-inch crescent wrench or 3/4-inch socket
- 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)

Titanium 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.** 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 1/2-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 of your deck, you can run it forwards to remove the core. At this point you can either drill straight through (doing so may cause chipping or splintering 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 fiberglass laminate.
5. With the hole drilled, you can now insert the 1/2-inch threaded deck bolt and check fit. Adjust the hole as needed and remove the threaded deck bolt.

6. Prepare the threaded deck bolt for installation by threading the installation tool (small bolt and nut) into the threaded deck bolt to a depth of 3/8 inches. Use a 1/2-inch crescent wrench to hold the small bolt and tighten the nut with another 1/2-inch crescent wrench against the threaded deck bolt. (see image below for reference)



7. Place painter's tape around the hole to keep excess adhesive from getting on the deck.
8. 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.
9. Insert the threaded deck bolt into the hole and tighten into place using the 1/2-inch crescent wrench to hold the installation tool nut and the 3/4-inch socket to turn the large deck bolt nut until the bolt head and washer are snug to the deck. **DO NOT OVERTIGHTEN THE LARGE 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.
10. Remove the installation tool by holding the small bolt in place with one 1/2-inch crescent wrench and loosening the small nut with the other 1/2-inch crescent wrench. Once the nut is loose, the small bolt will come out easily.
11. 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.
12. Allow the adhesive sealant to fully cure according to the manufacturer's instructions before using the threaded deck bolt.