



**Fig. 1.** Drill oversize holes using the hardware to be mounted or a template. To drill the hole true, one can use a custom drilling guide made from 1.5" piece of Starboard™. **Always "dry fit" the hardware.** If using bedding material (as opposed to a rubber washer) cut a countersink at the top of the hole. When the bedding material is applied this creates an O-ring effect. Partially fill the hole with epoxy thickened to "Ketchup" consistency. It is a good idea to wet out the hole first with un-thickened epoxy.

**Fig 2.** Stick the screw or bolt down the hole with a nut at the very end. The epoxy will squeeze around the flats of the nut. Make sure the screw or bolt goes in a little deep to allow room to tighten the screw. The upper part needs to be stabilized, either with the hardware itself, a template, or another waxed nut. The lower nut gets bonded in. The epoxy hardens around the threads of the screw so that threads are cast into the epoxy. Within a couple of hours after hardening, back out the screw or bolt (it comes out easily if waxed thoroughly), remove the hardware or template or stabilizing bolt..

**Fig 3.** Re-insert the screw and, using a syringe, top off the hole with more thickened epoxy. When it has set up the screw is removable, and quite strongly held in place. Don't wait too long or the additional epoxy won't "key" into the epoxy already in the hole.

**Fig. 4.** Install the hardware. Tighten gently but firmly. Let cure a couple of days and then tighten to recommended torque for the particular bolt or screw.

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