

Pressfit BB30 Bonding Instructions

Pressfit BB30 Bonding

The process described in this Tech Note can be used to install BB cups into Cannondale Pressfit 30 frames where irregular BB cup parts or frame shell surfaces are resulting in a partial press or slip fit (i.e., fitting without using a headset press). Loctite® 609 is a non-permanent bonding agent for cylindrical parts and has excellent gap filling qualities for either alloy or nylon BB cup parts. All surfaces must be cleaned thoroughly and the Loctite® 7649 activator applied as indicated for the bond to cure correctly.

Required Tools/Material:

1. Loctite® 609 - See also: (<http://tds.Loctite.com/tds5/docs/609-EN.PDF>)
2. Loctite® Primer 7649 - See also: (<http://tds.Loctite.com/tds5/docs/7649-EN.PDF>)
3. Isopropyl Alcohol 99% (anhydrous)
4. Clean, lint-free shop towels
5. Small nylon-brush
6. A headset press

Cannondale Kits:

CODE	DESCRIPTION
KP218/	KIT,LOCTITE 609 W/ACTIVATOR
KP197/	KIT, BB, PRESSFIT 30 68/73
KP 197/SRM	KIT, BB PRESSFIT 30, 68/73 SRM

NOTICE

1. **To prevent damage, these instructions should only be performed by a professional bike mechanic.** Damage caused by improper service or materials/parts is not covered by the Cannondale Limited Warranty.
2. **Be sure clean painted surfaces with an alcohol dampened towel immediately after application and after each of BB cup is pressed.** Prolonged contact with Loctite® (7649 or 609) contact may result in staining/discoloration of painted surfaces.
3. **Apply Loctite® products carefully to the BB parts to prevent contamination of the bearings.**
4. **Do not use any tool to clean (i.e., cut, file, machine, or sand inside of the frame shell).** Residual Loctite from a previous bonding installation can be removed with Loctite 768 (cleaning solvent).

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Bonding Instructions

STEP 1

Thoroughly clean the inside surface of BB shell with a clean lint-free shop towel dampened with isopropyl alcohol.

Make sure you press firmly during the wiping of the inside of the BB shell. Allow the inside surface of the BB to dry completely before continuing.



STEP 2

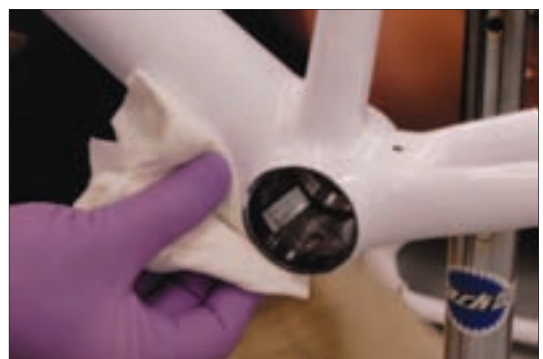
Apply the Loctite® Primer 7649 to the inside surface of the BB shell.

The Loctite® 7649 primer is available in different containers and can be applied in several ways (i.e., aerosol spray, pump spray, or brush).

When you apply it, you must make sure you cover all of the surface area within the BB shell that contacts the BB cups.

After application to both sides of the BB shell, the surfaces must be allowed to dry for 3 to 5 minutes.

Wipe off any overspray with clean towel dampened with isopropyl alcohol.



STEP 3

Separate the BB bearing cup parts.

Notice that the cup flanges are marked to identify drive vs. non-drive sides on some systems (SRAM, shown, has “R” for drive side, “L” for non-drive side).

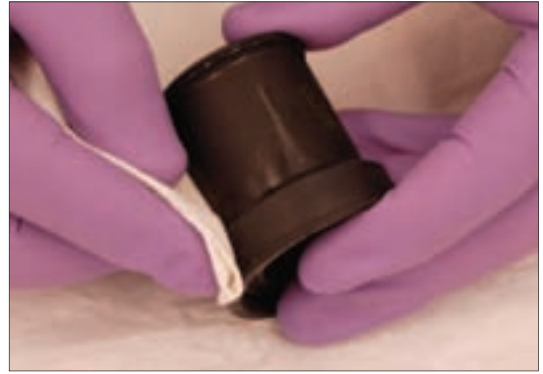


STEP 4

Use a clean lint-free shop towel dampened with isopropyl alcohol to clean the press surfaces of both BB cups.

Make sure you press firmly and do not touch the area following cleaning.

Allow the surfaces to dry completely before continuing.



STEP 5

Apply Loctite® Primer 7649 to the press surfaces of both BB cups.

Make sure the application is uniform and complete over the entire press surface area on the BB insert. This process is to be done to both BB cup parts.

Allow activator to dry for 3 to 5 minutes.



STEP 6

Apply Loctite® 609 to the bearing surfaces of both BB cups.

Make sure the application covers the entire frame contact surface.

Use a small brush to ensure good coverage.

IMPORTANT:

After the Loctite 609 is applied, install the cups into the prepared frame. Loctite 609 curing time is significantly reduced when used with the activator 7649. Therefore, your working time is reduced.

After using the brush, immediately clean it with isopropyl alcohol or the Loctite® will cure and the brush will no longer be useful.



STEP 7

Use a headset bearing press to press each BB cup individually.

To ensure bearing alignment, make sure that the cup flanges are both fully seated against the BB shell after installation. If the BB cups are loose enough, they might sag or be displaced once the headset tool is removed.



Wipe up any residual (displaced) Loctite®.

WAIT 24 HRS FOR THE BOND TO CURE BEFORE RIDING THE BIKE.



Removing a Bonded BB Cup System

Currently, the bearings of most Pressfit 30 BB cup systems are not replacable and are not intended to be removed from the cups. In order to replace bottom bracket bearings, the complete BB cups system (cup w/bearing installed by manufacturer) must be replaced as a new unit.

Residual Loctite (green in color) may or may not be visible around the cup edges as an indication that the cups Pressfit BB30 frame have been bonded. So, exercise patience when attempting to remove any cup system. The tools and methods for removal will vary by manufacturer, so be sure to follow instructions provided.

A nylon BB cup system by SRAM is shown throughout these instructions. With this system, when bonded, we have found that it is necessary to first carefully drive the bearing out of the BB cup. Then, the BB cup can be easily driven out with Park Tool RT-1.

NOTICE

Disassembly instructions for Loctite 609 product instructions indicate heatings parts prior to disassembly. We have found that heating is NOT necessary in this application and recommend that you do not do it. Excessive heat can damage the paint and destroy the carbon frame.