

Bonding decorative panels and work surfaces

GENERAL DESCRIPTION




The interiors of many boats are based on a variety of traditional and modern materials including mirrored glass. These panels can be used functionally as working surfaces (galley worktops, etc.) or cosmetically. Either way, elastic bonding provides an easy, durable method of fixing without visible and unsightly mechanical fixings.

As the variety of materials used for panels, surfaces and supporting substrates is so vast, please consult the local Technical Service of Sika Industry or proceed to preliminary trials.










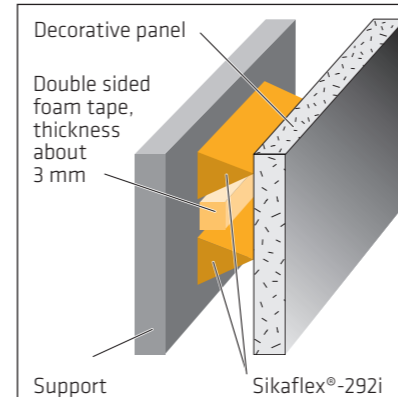
BONDING DECORATIVE PANELS AND TABLES

SURFACE PREPARATION

-  Lightly abrade the bonding area with a very fine abrasive pad
-  Apply a thin continuous coat of Sika® MultiPrimer Marine using a clean brush or felt applicator
-  Sika® MultiPrimer Marine 30 minutes (min) to 24 hours (max)









APPLICATION OF Sikaflex® ADHESIVE TO VERTICAL PANELS

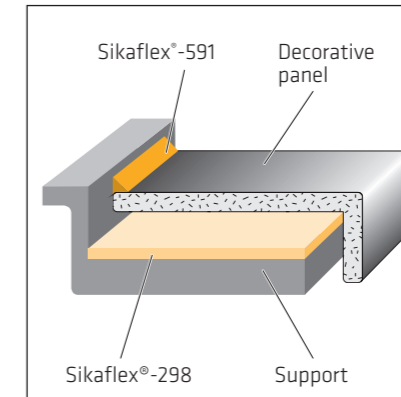
-  Prepare the substrate according to the Pre-Treatment Chart for Marine Application
-  Place spacers in position (thickness 2 mm, approximately 50 Shore A hardness). These can be pressed into the adhesive once applied
-  Apply appropriate beads of Sikaflex®-292i in an 8 mm x 10 mm triangular profile
-  Assemble the components within 20 minutes of applying the adhesive
-  Apply pressure with fastening aids to compress the adhesive to the height of the spacers
-  Wait at least 24 hours before walking on the bonded plates
-  Uncured Sika adhesives or sealants can be removed with Sika® Remover-208



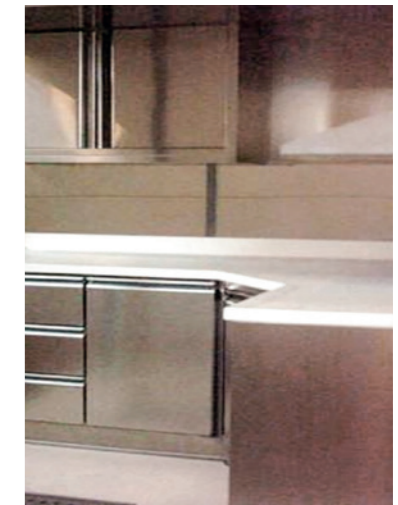
Bonding a decorative panel vertically

APPLICATION OF Sikaflex® ADHESIVE TO HORIZONTAL PANELS

-  Horizontal surfaces: Sikaflex®-298. Inclined surfaces: Sikaflex®-591
-  Slightly abrade the surface with an abrasive pad very fine
-  Pre-treat the surface with Sika® Aktivator-205 using a lint-free rag or paper towel. Change the rag frequently!
-  Flash-off time min. 10 min to max. 2 h
-  Apply adhesive to the previously prepared surface and spread over the area to be covered, using a spreader with 4 mm triangular notches. The bed thickness may vary depending on the thickness of any gaps that needs to be filled (normally 1–2 mm)
-  If vapour-tight substrates are used, spray a fine mist of water (1 g / m²) onto the Sikaflex®-298 surface for faster curing
-  The deck panel must be positioned accurately within the tack free time of the adhesive and pressed firmly into place to avoid air-entrapment
-  Clamps, weights or screws (removable once the adhesive has set) can be used to secure the panel while the adhesive sets. After about 24 hours the panels can carry their full service load and the temporary fastenings can be removed



Bonding a decorative panel vertically



A galley work surface fitted using Sikaflex®-292i

IMPORTANT: Always refer to the current Sika Product Datasheets and Safety Datasheets obtainable through your local Sika company



Application of Sikaflex®-591