# Flybridge bonding

### **APPLICATION DESCRIPTION**

Many modern motor yachts have flybridges. Conventional fixing methods such as mechanical fixings or rigid adhesives have concentrations of peak stresses which lead to breaching of the substrate allowing access to moisture. Bonding of flybridges using flexible adhesive systems evens the distribution of stresses and optimises resistance to impact and fatigue effects.

In service, flybridges are subjected to substantial stress on the joints at high speeds. The main reason that makes Sikaflex<sup>®</sup>-292i perfect for this application is the high modulus characteristic that ensure the integrity of the joint under stress.

A perfect cosmetic finish is obtained with the weather resistance Sikaflex®-295 UV in white colour.



## **FLYBRIDGE BONDING** PROCEDURE

## PREPARING THE SUBSTRATE GRP

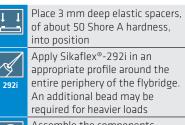
#### Heavily soiled surfaces should first be cleaned off with a pure solvent, like Sika® Remover-208, to remove 208 the worst of the soiling Lightly abrade the contact area with a very fine sanding pad Remove the dust with a vacuum cleaner Pre-treat the substrate with Sika® Aktivator-205, using a clean, lintfree rag or a paper towel. Change 205 the rag frequently! Flash-off: 10 minutes (min) to 2 hours (max) Apply a thin, continuous coat of 4 Sika® MultiPrimer Marine, using a clean brush or a felt applicator SMM Drying time: 30 minutes (min) to



24 hours (max)

Sealing with Sikaflex®-295 UV

## **APPLICATION OF** Sikaflex®-292i ADHESIVE



Assemble the components within 20 minutes of applying adhesive

Apply pressure with clamps or other fastening aids to compress the adhesive to the height of the spacers

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Uncured Sika adhesives or sealants should be removed with Sika® Remover-208 For open joints, cover

Sikaflex<sup>®</sup>-292i with a layer of Sikaflex®-295 UV 295 UV

Clamps and other fastening aids  $\bigcirc$ can be removed after 12 hours Full service strength is attained after about 7 days

#### **IMPORTANT:**

