



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®-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















 208	Heavily soiled surfaces should first be cleaned off with a pure solvent, like Sika® Remover-208, to remove the worst of the soiling
	Lightly abrade the contact area with a very fine sanding pad
	Remove the dust with a vacuum cleaner
 SA 205	Pre-treat the substrate with Sika® Aktivator-205, using a clean, lint-free rag or a paper towel. Change the rag frequently!
	Flash-off: 10 minutes (min) to 2 hours (max)
 SMM	Apply a thin, continuous coat of Sika® MultiPrimer Marine, using a clean brush or a felt applicator
	Drying time: 30 minutes (min) to 24 hours (max)



Fig. 8 Sealing with Sikaflex®-295 UV

APPLICATION OF Sikaflex®-292i ADHESIVE

	Place 3 mm deep elastic spacers, of about 50 Shore A hardness, into position
 292i	Apply Sikaflex®-292i in an appropriate profile around the entire periphery of the flybridge. An additional bead may be required for heavier loads
	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

 208	Uncured Sika adhesives or sealants should be removed with Sika® Remover-208
 295 UV	For open joints, cover Sikaflex®-292i with a layer of Sikaflex®-295 UV
	Clamps and other fastening aids can be removed after 12 hours. Full service strength is attained after about 7 days

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

