



## 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
 SMM	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
 208	Uncured Sika adhesives or sealants can be removed with Sika® Remover-208

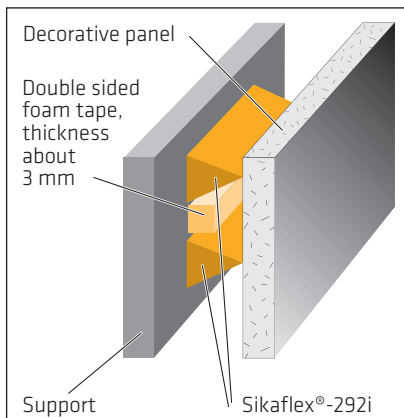









Fig. 6 Bonding a decorative panel vertically

### APPLICATION OF Sikaflex® ADHESIVE TO HORIZONTAL PANELS

 298	Horizontal surfaces: Sikaflex®-298. Inclined surfaces: Sikaflex®-291i
	Slightly abrade the surface with a abrasive pad very fine
 SA 205	Pre-treat the surface with Sika® Aktivator-205 with 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 / m <sup>2</sup> ) 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

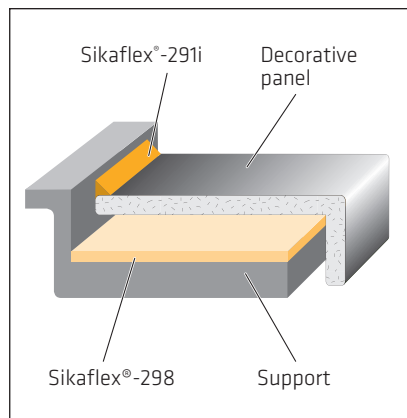


Fig. 7 Bonding a decorative panel vertically



Fig. 8 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



Fig. 9 Application of Sikaflex®-291i