Bonding Lightweight Internal Partitions

Application Description

These lightweight panels are usually constructed of wood sandwiches with an internal polyurethane foam or honeycomb core. They are particularly suited as partitions for cabins and technical rooms as they are of lighter weight than wood-filled panels and have good sound-proofing properties.

Due to the low density core, lightweight panels cannot be mechanically fixed to the hull structures in the same way as traditional plywood panels. However, bonding with Sikaflex®-292 is an ideal replacement fixing method that also possesses the flexibility to respond to the movements and stresses of the assembly.

This process is also endorsed by the manufacturers of the lightweight panels.

Fig. 88 Applying Sikaflex®-292

Substrate Preparation

Fiberglass Hull

208	*Heavily soiled surfaces should first be cleaned off with 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
205 Aktivator	*Pretreat the substrate with Sika® Aktivator or Sika® Aktivator 205, using a clean, lint-free rag or a paper towel. Change the rag frequently! Sika® Aktivator must be applied with the wipe on/wipe off method.*
	Flash-off: 10 minutes (min) to 2 hours (max)
206 G+P 215	*Apply a thin, continuous coat of Sika® Primer-206 G+P or Sika® Primer-215, using a clean brush or a felt applicator*
	Drying time: 30 minutes (min) to 24 hours (max)

Wooden Hull and Partition Panels

	Abrade the contact area on the hull with sanding pad (80/100 grit)
	Remove the dust with a vacuum cleaner
215	*Apply a thin, continuous coat of Sika® Primer 215 using a clean brush or a felt applicator*
	Drying time: Sika® Primer-215 30 minutes (min) to 24 hours (max)

For the preparation of other substrates, please refer to the Primer Chart available at www.sikaindustry.com.

The Sikaflex®-292 should be applied along the perimeter of the partition and in vertical stripes as necessary.

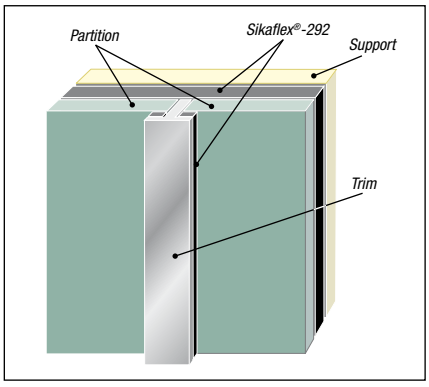

Fig. 89 Sikaflex®-292 bead application for bonding to the support

Fig. 90 High-quality lightweight panels finished in traditional high-gloss wood veneer and bonded using Sikaflex®-292

Fig. 91 Lightweight panels being fitted to an open hull

Applying Sikaflex®-292 Adhesive

	Dry fit the panels to ensure an accurate fit and correct dimensioning
	Once satisfied, place the spacers in position (thickness typically 1/8 mm, approximately 50 Shore A hardness)
292	*Apply Sikaflex®-292 to the appropriate bond face using an appropriate bead*
	Assemble the components within 20 minutes of applying the adhesive
	Panels can be held in place during cure by clamps or support brackets
	Clamps and other fastening aids can be removed after 24 hours
208	*Uncured Sika® adhesives or sealants may be removed with Sika® Remover-208 or mineral spirits*

Do not use Sika® Aktivator or Sika® Aktivator 205 or any other cleaning agent or solvent for cleaning purposes

Fig. 92 Sikaflex®-292 applied to a lightweight panel prior to fitting