Bonding Decorative Panels and Work Surfaces

Application Description

The interiors of many boats are based on a variety of traditional and modern materials including mirrored glass, Avonite® and Corian®. 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 Primer Chart available at www.sikaindustry.com for the most suitable surface preparation method.

If one of the substrates is unknown, it is vital that preliminary trials are carried out to check adhesion using the correct preparation.

Please consult your local Sika Company for technical advice.
Bonding Decorative Panels

Applying Sikaflex® Adhesive to Vertical Panels

- Place 1/8” thick spacer in position.
- Apply parallel beads of Sikaflex®-292, each with an 8 mm x 10 mm triangular bead shape.
- Assemble the components within 20 minutes of applying the adhesive.
- Panels can be held in place by clamps or support brackets while the adhesive is curing.
- Clamps and other fastening aids can be removed after 24 hours.
- Full service strength is attained after approximately 7 days.
- Uncured Sika adhesives or sealants may be removed with Sika® Remover-208 or mineral spirits.

Always refer to the current Sika Product Data Sheets and Material Safety Data Sheets obtainable through your local Sika Company.

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

Applying Sikaflex® Adhesive to Horizontal Panels

- Apply Sikaflex®-291 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 (10 g/m²) onto the Sikaflex®-291 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. Alternatively, the vacuum press method can be used.
- After about 24 hours the panels can carry their full service load and the temporary fastenings can be removed.

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