

## 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](http://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

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

Prepare all substrates in accordance with the Primer Chart available at [www.sikaindustry.com](http://www.sikaindustry.com) or seek advice from your local technical service group

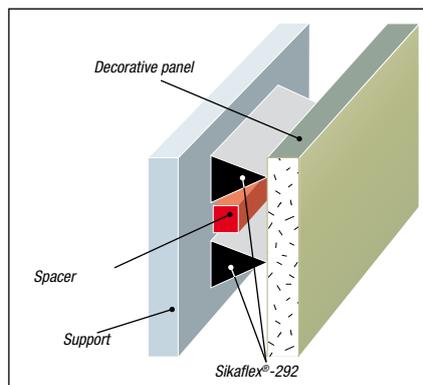


Fig. 85 Bonding a decorative panel vertically

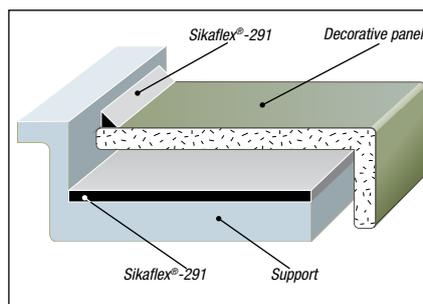


Fig. 86 Bonding a decorative panel horizontally

### 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/m <sup>2</sup> ) 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.



Fig. 84 A galley work surface fitted using Sikaflex®

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



Fig. 87 Metal table legs are bonded and sealed to a metal table-top using Sikaflex®-292