



SIKA
MARINE



THE
PROFESSIONAL'S
CHOICE

MARINE PRODUCT SOLUTIONS

BUILDING TRUST



SIKA MARINE

Providing a comprehensive solution and product offering to meet the demands of boat manufacturers. It is our unique ability to be an all-in-one supplier for the Marine Industry that makes Sika Marine the perfect choice. From design to final assembly within the manufacturing process, Sika Marine has a product solution.

- Deco Flooring
 - Direct Glazing
 - Epoxy Fairing Compound
 - Fire Retardant Resins & Fillers
 - Gelcoat Repair
- Epoxy Infusion Systems
 - Epoxy Lamination Systems
 - Mold Repair
 - Plug Building
 - Repair Fillers
- Structural Bonding
 - Sound Damping
 - Composite Tooling

POLYESTER FILLERS & FAIRING COMPOUNDS

Product (Formerly)	Hardener	Use Temp (°F)	Pot Life (min/g)	Resin Color	Shore D Hardness	Description
SikaBiresin® AP014 (P-14)	BPO	285	4 - 6/100	White	86	Versatile; fast-set, dimensionally stable; used for filling/fairing porosity & voids on composites' surfaces
SikaBiresin® AP017 (P-17)		400	5 - 7/102	White	80	High heat-resistant, quick setting, minimal shrinkage, high gloss finish with excellent bond strength
SikaBiresin® AP077 (P-77)		400	9 - 11/50	White	86	High heat-resistant, easily sandable; suitable for above & below the waterline applications
SikaBiresin® AP112 (P-11 Type II)		130	4 - 6/100	Dark Green	83	Fiber-filled fill/bonding paste for increased strength of repairs on broken marine or other FRP structures

EPOXY FILLERS & FAIRING COMPOUNDS

Product (Formerly)	Hardener	Speed	Cure to Sand Time (hours)	Pot Life (min/g)	Mixed Viscosity (cps)	Description
SikaBiresin® AP861 (Marine 861 UltraFair)	AP861-1	Fast	6 - 8	48/102	Non-sag paste	Trowelable filler for fairing large surface imperfections on aluminum, steel, fiberglass or wooden marine vessels; above & below the waterline
SikaBiresin® AP100 (ProSeal EZ)	AP100-1	Fast	4 - 6	15/200	7,000 - 10,000	White, sandable coating system used to fill and seal surface fabric textures in FRP reinforced structures
	AP100-3	Slow	16 - 24	61/200	7,000 - 10,000	

EXTRUDABLE EPOXY PASTE

Product	Tg (°F)	CTE (ppm/°F)	Density (lbs/ft³)	Shore D Hardness	Description
SC 175	181	39	39	60	Extrudable epoxy paste for models, tools, and plug production by extrusion process
SC 180	180	43	50	62	

EPOXY RESIN SYSTEMS

Product (Formerly)	Hardener	Speed	Tg (°F)	Mixed Viscosity (cps)	Pot Life (min)	Description
SikaBiresin® CR86 (ProInfusion)	CH86-2	Fast	171	200 - 400	20 - 30	High clarity epoxy infusion/laminating system for production of composite structures and marine applications
	CH86-3	Medium	178	200 - 400	80 - 100	
	CH86-6	Slow	183	200 - 400	145 - 175	
	CH138-10	High Temp	280	450 - 650	250 - 300	
SikaBiresin® CR72 (Marine 820)	CH72-1	Fast	154	650	30 - 40	UV-resistant, general purpose system for fabrication of laminated or infusion molded composite parts & structures
	CH72-2	Medium	163	350	40 - 50	
	CH72-3	Slow	159	425	50 - 60	
SikaBiresin® CR94 (L-140)	CH94-1	Fast	194	800 - 1,200	20 - 30	Epoxy lamination system used for building, repairing or restoring any type of marine vessel
	CH94-3	Medium	203	800 - 1,200	55 - 75	
	CH94-6	Slow	203	1,000 - 1,400	100 - 130	

1-COMPONENT POLYURETHANE ADHESIVES & SEALANTS

Product (Formerly)	Application Temp (°F)	Tack Free Time (mins)	Elongation at Break (%)	Tensile Strength (psi)	Shore Hardness	Description
Sikaflex®-290 DC PRO	41 - 95	90	600	400	40 A	Adhesive designed for caulking of joints in traditional timber decking for boat, yacht and commercial ship constructions
Sikaflex®-291 LOT	41 - 110	180 - 300	700	120	40 to 45 A	General all-purpose marine sealant, which may be used for light duty bonding. Longer open time for projects that require more time for workability.
Sikaflex®-291	41 - 104	60	500	260	40 A	General all-purpose marine sealant, which may be used for light duty bonding.
Sikaflex®-292i	50 - 95	40	300	435	50 A	Thixotropic adhesive suitable for structural joints in marine constructions which will be subjected to high dynamic stresses.
Sikaflex®-295 UV	50 - 95	60	500	160	35 A	Adhesive/sealant specifically formulated for bonding acrylic and polycarbonate windows and hatches. It is also an excellent color stable, non-chalking sealant for general marine sealing. UV-resistant.
Sikaflex®-296	50 - 95	45	450	870	45 A	Adhesive that exhibits high strength and outstanding working characteristics. Specifically designed for bonding windows to marine vessel body shells (direct glazing).

1-COMPONENT SILICONE

Product	Skin Time (mins)	Tensile Strength (psi)	Shore Hardness	Elongation at Break (%)	Description
Sikasil®-GP	13	220	20 A	500	General purpose, one-component, non-sag, elastomeric, RTV acetoxy silicone sealant with good adhesion characteristics.
Sikasil®-GP HT		200			General purpose, one-component, non-sag, elastomeric, RTV acetoxy silicone sealant with good adhesion characteristics. Maintains elastomeric properties up to 500° F continuous, 550°F intermittent.
Sikasil® N-Plus	15 (Pigmented)	300 (Pigmented)	30 A ± 5 (Pigmented)	430	General purpose, one-component, non-sag, elastomeric, 100% RTV neutral cure silicone sealant.
	20 (Translucent)	190 (Translucent)	15 A ± 5 (Translucent)		
SikaFiresil®-N	25	85	25 A	300	Fire retardant, one-component, fast curing silicone sealant, based on a non-corrosive curing system.

2-COMPONENT MMA

Product (Formerly)	Open Time (mins)	Tensile Strength (psi)	Peak Exotherm Time/Temperature	Description
SikaFast®-3121	5	1300	10 min 88°C (190°F)	Fast-curing, flexible adhesive for applications requiring quick fixturing for higher throughput.
SikaFast®-3131S	7	1300	17 min 88°C (190°F)	Fast-curing, flexible adhesive for applications requiring quick fixturing for higher throughput. Incorporated spacer shims (0.027 - 0.033 inch) to maintain uniform bondline thickness.
SikaFast®-3161	50	1450	90 minutes 100°C (212°F)	Long open time, flexible adhesive designed to substitute welding, riveting and other mechanical fastening.
SikaFast®-3551	45	2300	200 minutes 40°C (105°F)	

2-COMPONENT POLYURETHANE

Product	Open Time (mins)	Tensile Strength (psi)	Shore Hardness	Elongation at Break (%)	Application
Adekit A236-25	25	1,740	55 D	60	Large composite parts bonding; used for deck bonding, hull bonding and interior design
Adekit A236-120	120				
SikaForce®-315	1	2,850	70 D	170	Good adhesion to a wide variety of substrates, fast curing, non running or dripping adhesive designed for bonding small plastic and metal components.
SikaForce®-7720/L45	60	1,740	80 D	33	Thixotropic, gap filling, low VOC adhesive used for assembling profiles and sandwich constructions of, e.g., glass fiber reinforced polyester, wood, metal, ceramic materials and pre-treated plastic materials.
Spartite® 2000	12 - 15	4,000	62 D	200	Pourable resilient mast chock that seals and supports the mast at the partners.

GLOBAL BUT LOCAL PARTNERSHIP



Sika is a globally active company supplying the specialty chemicals markets. It is a leader in processing materials used in sealing, bonding, damping, reinforcing and protecting load-bearing structures in construction (buildings and infrastructure construction) and in industry (vehicle, building components, equipment production, solar and wind power).

Sika's product lines feature high-quality concrete admixtures, specialty mortars, sealants and adhesives, damping and reinforcing materials, structural strengthening systems, industrial flooring and membranes. Subsidiaries in more than 101 countries worldwide and approximately 20,000 employees link customers directly to Sika.

North American Plant Locations

Eaton Rapids, Michigan
Lakewood, New Jersey
Lyndhurst, New Jersey
Marion, Ohio
Grandview, Missouri
Montreal, Quebec

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Technical Service

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SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. **NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS.** Sale of Sika products are subject Sika's Terms and Conditions of Sale available at <http://usa.sika.com/> or by calling 201-933-8800.