

WORK INSTRUCTIONS

HATCH SEALING

Before starting the work

SAFETY AND TOOLS



- Wear personal protective equipment and prepare the products and tools needed

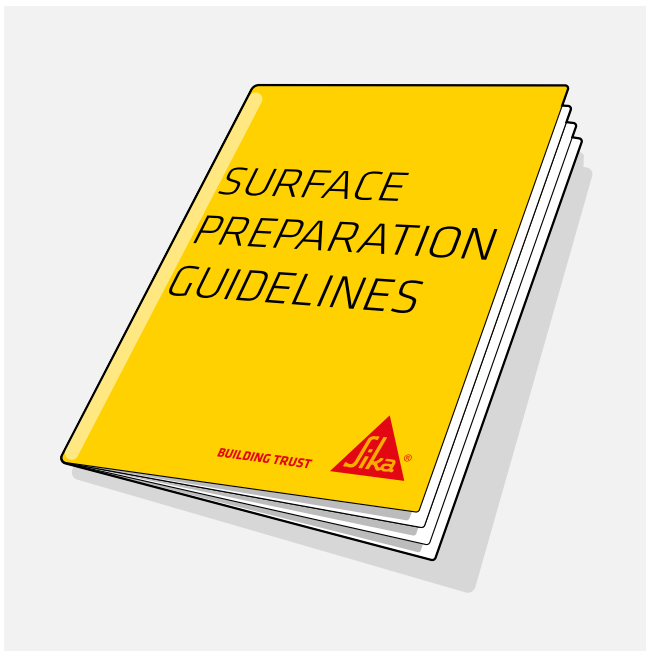
PROTECTION WITH MASKING TAPE



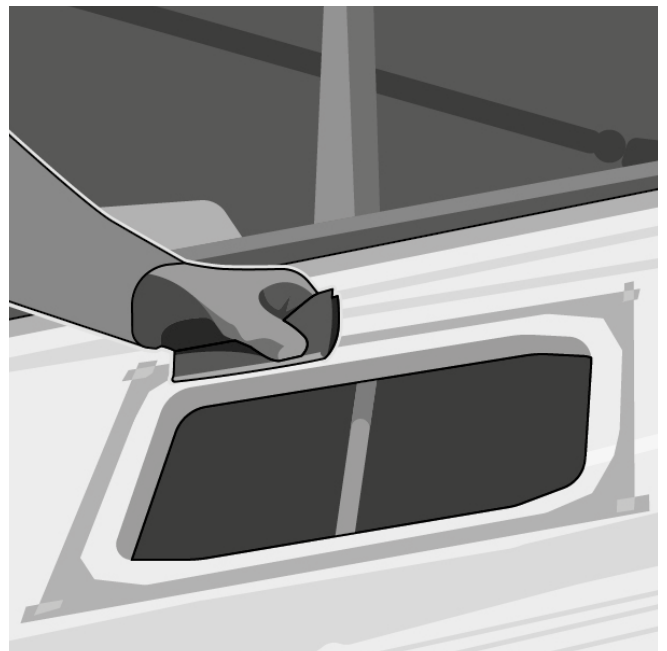
- Around the opening on the boat hull
- On the hatch

Starting to work

1. SURFACE PREPARATION

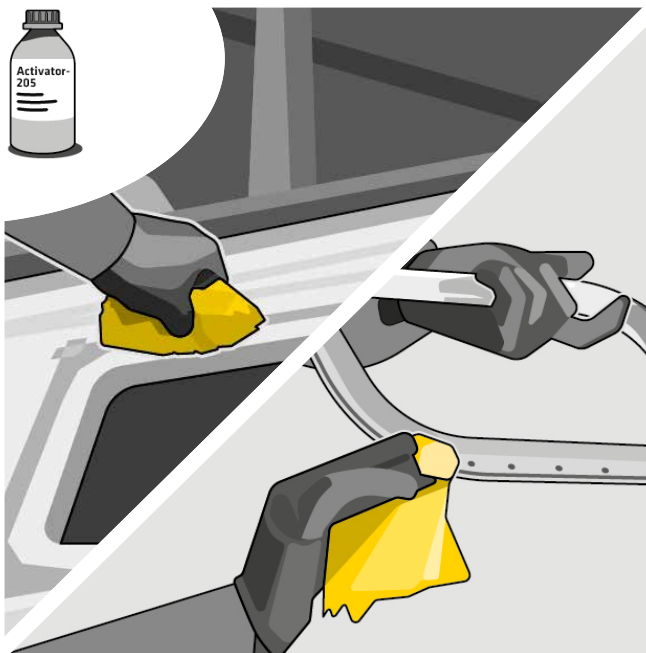


- Check the latest version of Sika's surface preparation guidelines



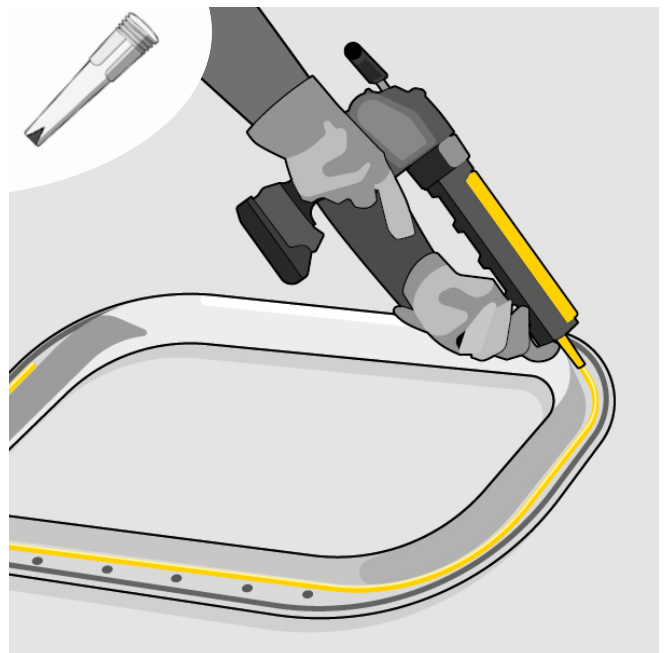
- Abrasive pad very fine (220-240) on GRP hull around the opening.
- Then use a dry wipe to remove the dust.

2. SURFACE PREPARATION



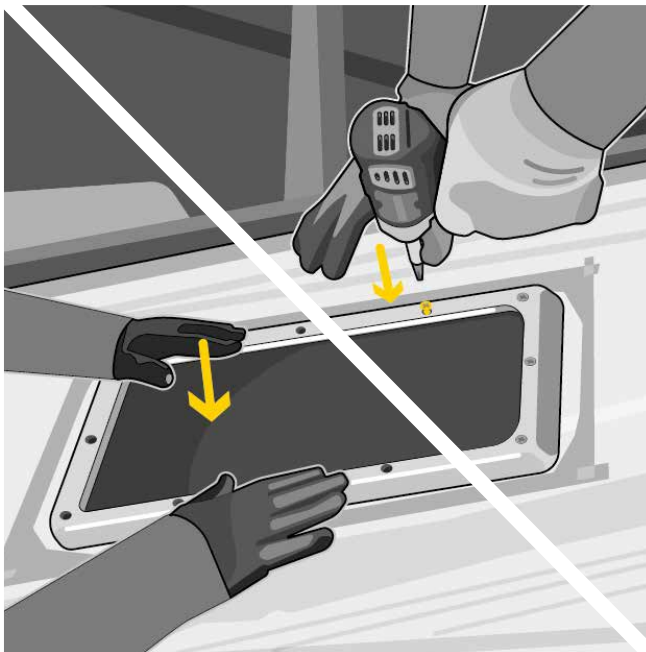
- Apply Sika® Aktivator-205 on GRP hull with lint-free paper, FOT min 10' max 120'
- Sika® Aktivator-205 on anodized aluminum hatch frame with lint-free paper, FOT min 10' max 120'

3. APPLICATION OF SIKAFLEX®-591



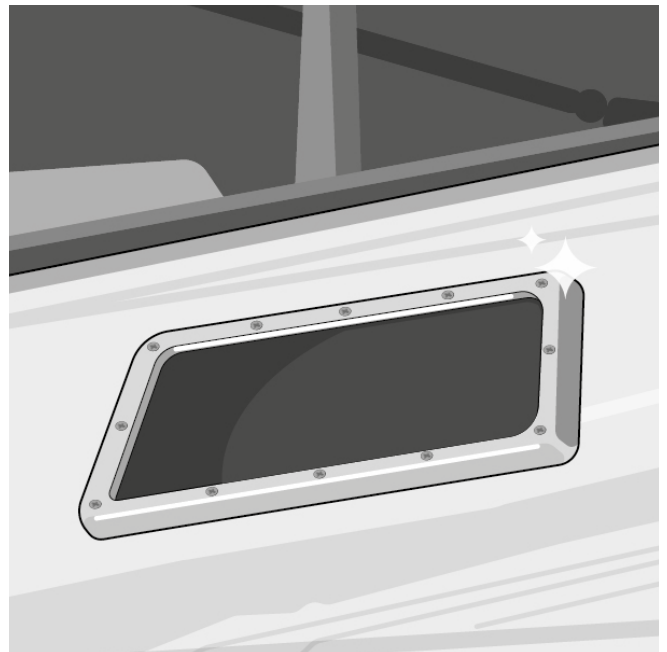
- Cut nozzle to the right size
- Apply Sikaflex®-591 around the opening

4.



- Position and press the hatch in the desired position
- Put the screws in place and tighten
(Wait for 24 hours, before tightening the screws completely)

5.



- Remove excess material that has flown around, then remove masking tape

① FOT = flash-off time (23 °C / 50% r.h.)

Tests with actual substrates and conditions have to be performed ensuring adhesion and material compatibility. Please consult the most current local Product Data Sheets prior to any use. Our most current General Sales Conditions shall apply.