

WORK INSTRUCTIONS

FAST BONDING OF SMALL ELEMENTS

Before starting the work

SAFETY AND TOOLS



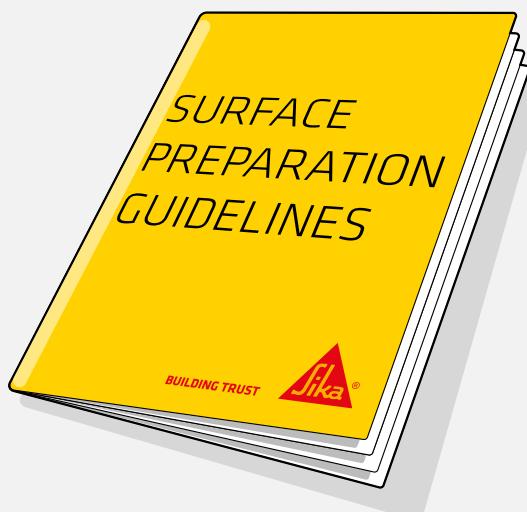
- Wear personal protective equipment and prepare the products and tools needed



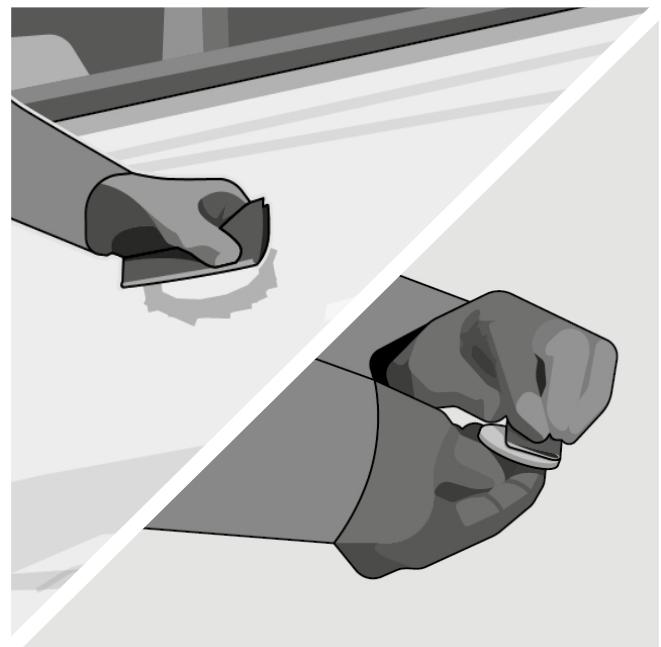
- Mark the location where to bond the padeye - either with masking tape or with a maker

Starting to work

1. SURFACE PREPARATION



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



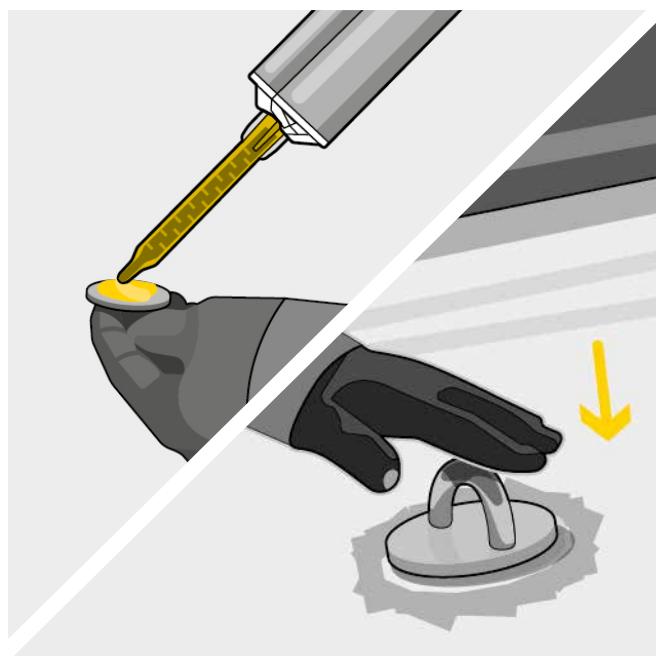
- Abrasive pad 80/100 on GRP hull at the installation spot
- Abrasive pad 80/100 on padeye

2. SURFACE PREPARATION



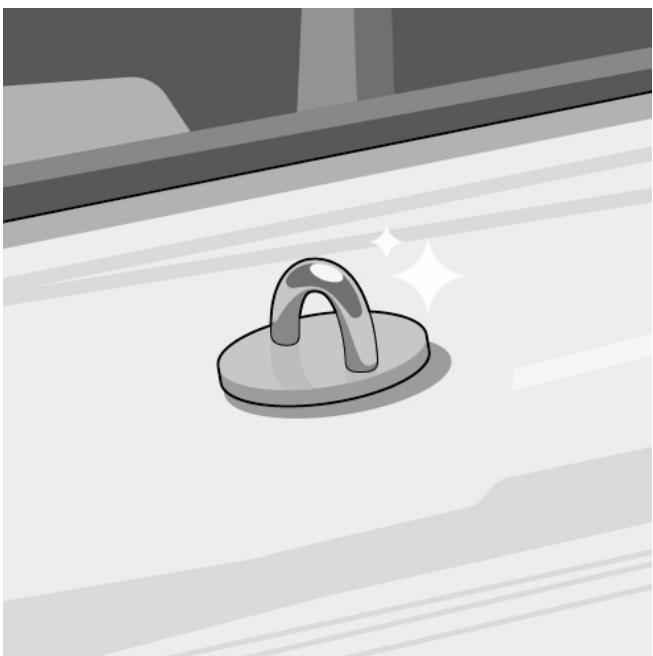
- Clean the GRP hull with Sika® Cleaner P on lint-free paper
- Clean the padeye with Sika® Cleaner P on lint-free paper

3. APPLICATION OF SIKAFAST®-555



- Purge the tube
- Install the mixing nozzle and purge
- Apply SikaFast®-555 on the padeye and place on chosen location (Min 2mm layer should remain after pressing the padeye)
- Wait 15' before loading

4.



- Remove excess material, then remove masking tape (if applicable)

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.