

# WORK INSTRUCTIONS

## TOE RAIL BONDING

Before starting the work

### SAFETY AND TOOLS



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

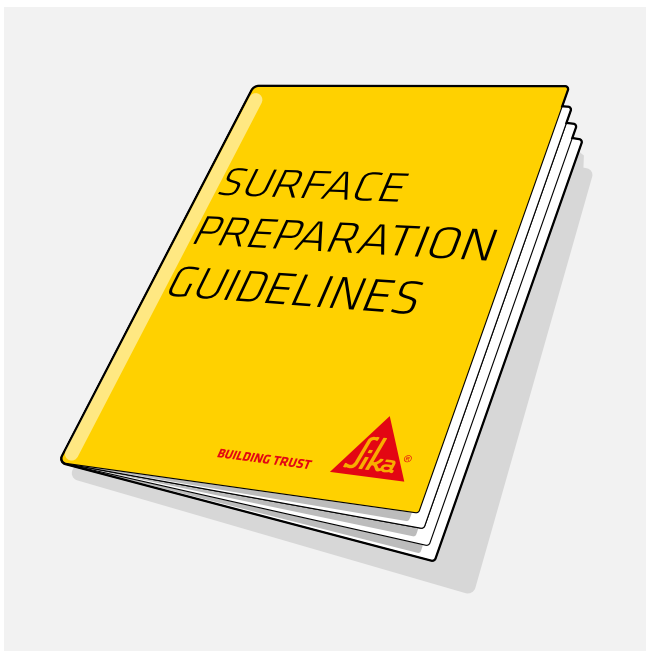
### PROTECTION WITH MASKING TAPE



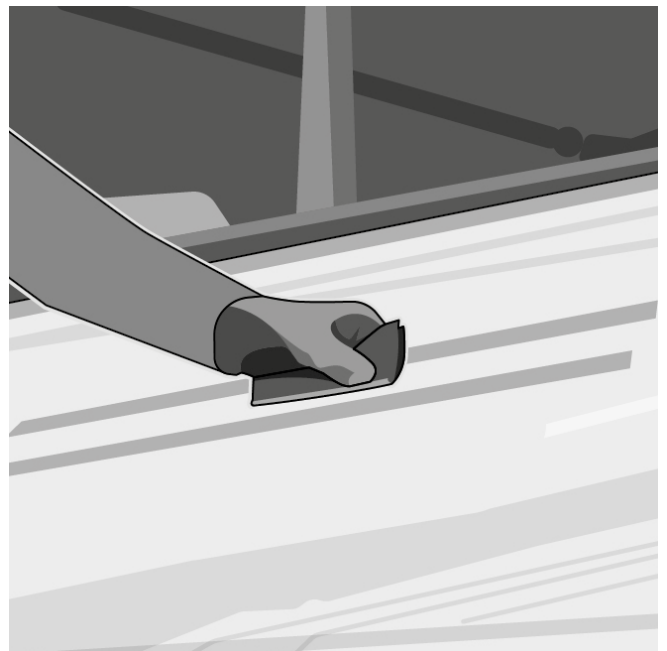
- Around the location of the sealing joint

Starting to work

### 1. SURFACE PREPARATION



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



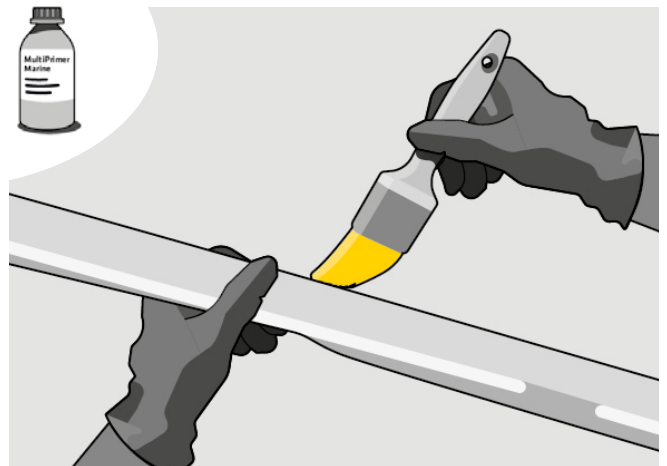
- Abrasive pad very fine (220-240) on GRP hull within the marked location
- Then use a dry wipe to remove the dust.

## 2. SURFACE PREPARATION



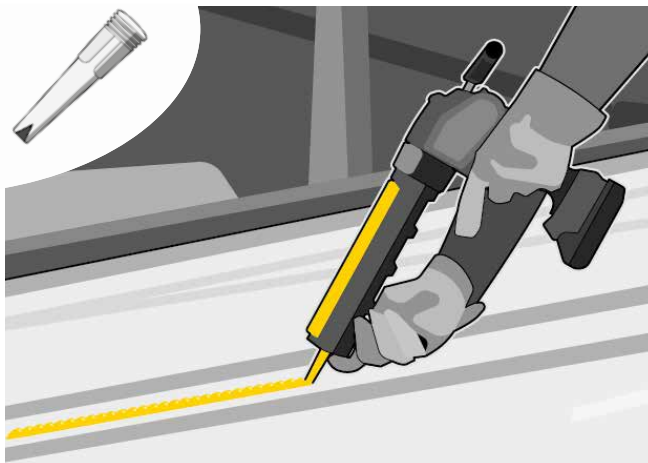
- Apply Sika® Aktivator-205 on GRP hull with lint-free paper, FOT min 10' max 120'

## 3.



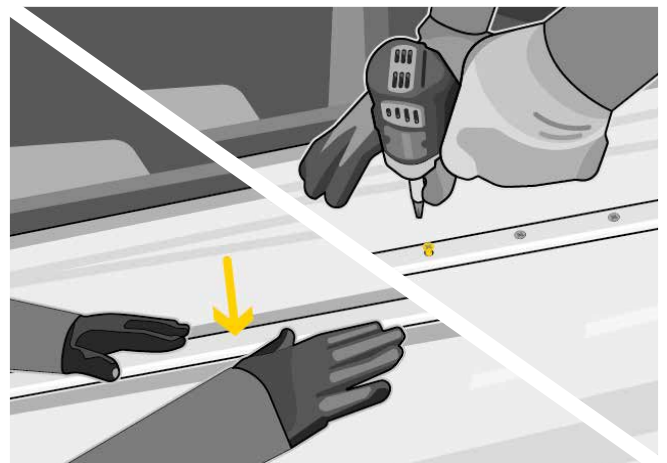
- Sika® MultiPrimer Marine on wooden toe rail with brush, FOT min 30' and max 24h

## 4. APPLICATION OF SIKAFLEX®-592



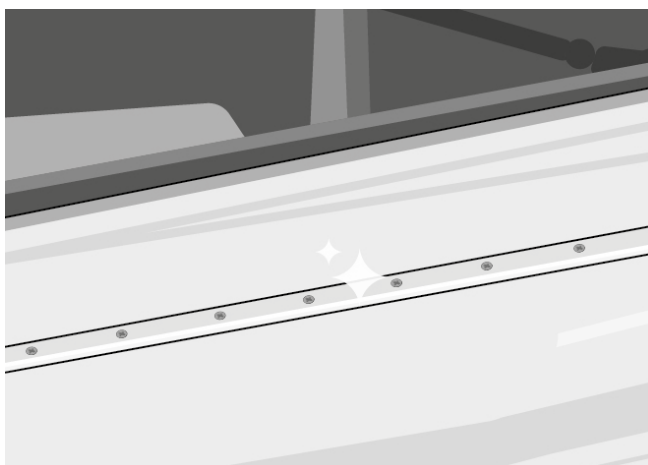
- Cut nozzle to the right size
- Apply Sikaflex®-592 along the marked surface on the boat hull

## 5.



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

## 6.



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

ⓘ 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.