

**Industry**



# **Marine** Elastic Adhesive and Sealing Systems

**Sika**®

# Team Spirit is our Key to Success

## Globally present, locally based

The international Sika Group has subsidiaries in over 70 countries around the world, providing a full range of products and services to local customers in every continent. This global market presence enables the company to adapt its highly specialised knowledge to local market needs quickly and efficiently. Sika sees itself as a “multi-domestic” organisation, which places the local customer at the very centre of its business activities. So all of Sika’s products, systems and service packages are carefully tailored to the local market conditions. As the worldwide leading supplier of a specialised range of innovative products for the marine industry, we are the acknowledged experts in this field. We are the people that boatyards and shipyards turn to first when they need a high-strength, yet flexible adhesive or sealant for construction or repair work.

## High-tech, high-bond

When the marine industry specifies a product, durability and tenacity are high on the list of requirements. For the boat owner, durability is an essential prerequisite for the smooth running of his vessel, for the untroubled enjoyment of the passengers and for the sheer joy of sailing. Whether at the wheel of a power boat or at the tiller of a sailing yacht: there is nothing quite like that feeling of freedom when you are out there on your own, facing the elements or that feeling of total tranquillity with only the horizon ahead and blue skies above. Times like this make your boat a possession to cherish, and a valuable asset that you will want to protect against the elements for many years to come. Water leaks, in particular, can damage your prized possession, leaving unsightly marks along the hull, causing woodwork to rot, or metal components to corrode. To avoid expensive repair bills, watertight seals are absolutely essential. Sika helps you accomplishing this.

## Fantastically elastic, brilliantly resilient

Elasticity and persistence are key words in the construction and repair of boats and ships, which are constantly exposed to the buffeting of wind and waves. The elastic adhesive and sealing systems specially developed by Sika for the marine industry offer outstanding performance where it is needed, making them ideal for use in all marine craft – from skiffs and dinghies to luxury sailing yachts, from power boats to cruise liners and from tankers to fast ferries.

Equally suitable for all types of construction – timber, fibreglass, aluminium or steel – Sika’s extensive line of marine products covers all your caulking, levelling, bedding, sealing and bonding needs.



## ■ Deck caulking

For timber decks that need to be completely watertight and weather-resistant, Sika has developed Sikaflex®-290 DC. This extremely easy-to-use, Hi-UV-resistant, one-component polyurethane deck caulking compound can, when cured, be flush sanded with the deck to supply a beautifully neat, clean finish.

## ■ Sealing

Resistant to weathering and seawater, Sikaflex®-291 is the perfect all-rounder: an all-purpose flexible marine sealant that bonds extremely well to all standard materials used in boat construction. Its outstanding elasticity ensures a durable, long-lasting seal alike all other Sikaflex® Marine sealants and adhesives. Sikaflex®-291 features 1-C, easy to apply, high elastomeric characteristics.

## ■ Bonding

Joints that are subject to extreme dynamic stresses require a long-lasting high-strength elastic adhesive with good gap-filling capabilities. Sikaflex®-292, with its excellent shock-absorbing and vibration-damping properties, has been specially developed to meet these requirements in the punishing marine environment. When your safety may depend on it, only the best is good enough.

## ■ Bonding and backfilling of organic glazing panels

This is an application that calls for a UV-resistant adhesive with a high degree of elasticity. Sikaflex®-295 UV combines the necessary elasticity with exactly the right consistency to maintain the required bond line thickness, thus ensuring that thermal movements in plastic glazing panels are absorbed progressively, without undue build-up of stresses. The UV-absorbing properties warrant endurance of the system.

## ■ Bonding of safety-, laminated- and insulation glass windows

Sikaflex®-296 has been formulated for use on all types of mineral glass windows. The high-performance, yet elastic Sikaflex®-296 adhesive is especially designed for bridging tolerances enhancing high modular performance. UV resistance renders the product suitable as a back-filler simultaneously.

## ■ Bedding and bonding of panels and sheet materials

Sikaflex®-298 is a low-viscous, yet thixotropic full-bodied adhesive that has been specially formulated for the water-proof, flexible bonding of timber strip decking, deck planking, plastic deck coverings and prefabricated timber deck panels. The product is very easy to work with, and supplies professional results every time. The permanently elastic adhesive layer has a cushioning effect, absorbs shocks and minimises the transmission of impact sound.





- A 1 Deck caulking
- A 2 Deck levelling and bedding



- B 1 Bilges
- B 2 Chain plates
- B 3 Hatches
- B 4 Deck-to-Hull
- B 5 Hull seams
- B 6 Keel joints
- B 7 Ports
- B 8 Rub rails and guards
- B 9 Toe rails
- B 10 Deck fittings and hardware
- B 11 Fly bridges
- B 12 Struts
- B 13 Through-hull fittings
- B 14 Vents



- C 1 Aluminium panels
- C 2 Bulkheads
- C 3 Cabinets/Cabin fitments
- C 4 Decks
- C 5 Deck-to-Hull
- C 6 Inner to outer hull
- C 7 Hatches
- C 8 Ports/Opening lights
- C 9 Radar mounts
- C 10 Seats
- C 11 Shower cabins fixtures
- C 12 Struts
- C 13 Partitions/ Supports
- C 14 Accommodation ladders/ swim platforms
- C 15 Transoms
- C 16 Cutwater plates
- C 17 Nameplates
- C 18 Cable ducts
- C 19 Draughtstops
- C 20 Fairings
- C 21 Anchor plates



- D 1 Windshields and lights
- G 1 Side glasses



- G 1 Windows and panoramic glass



- E 1 Decks (timber)
- E 2 Anti-slip deck coverings

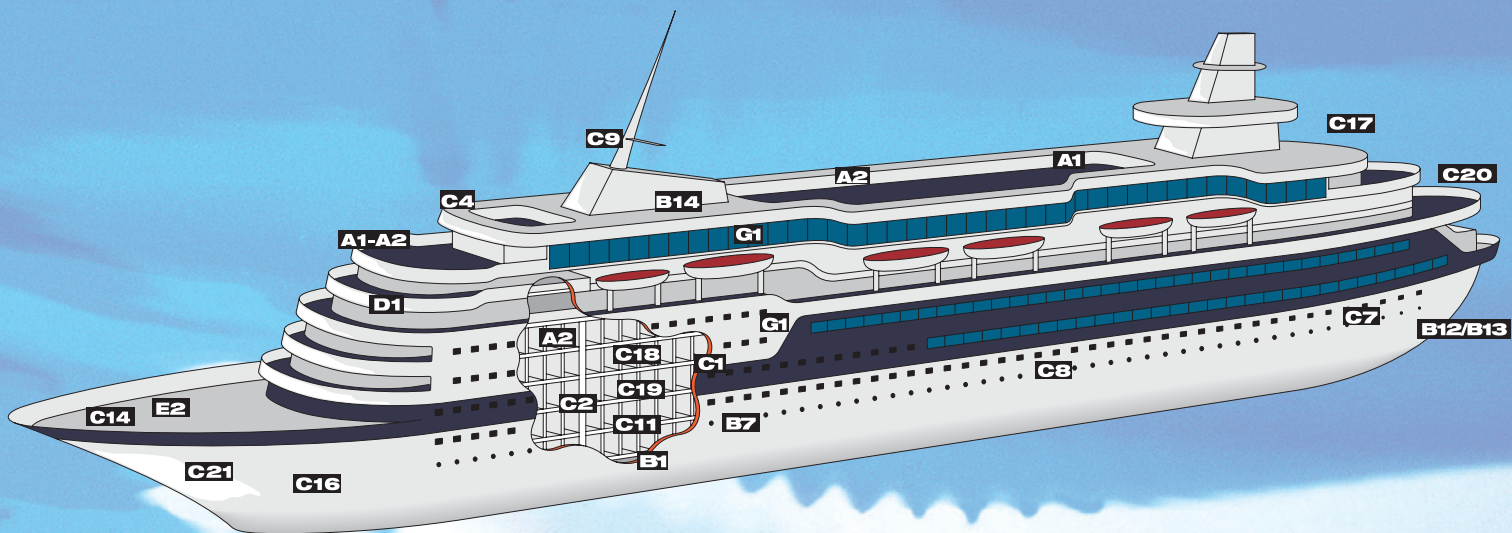
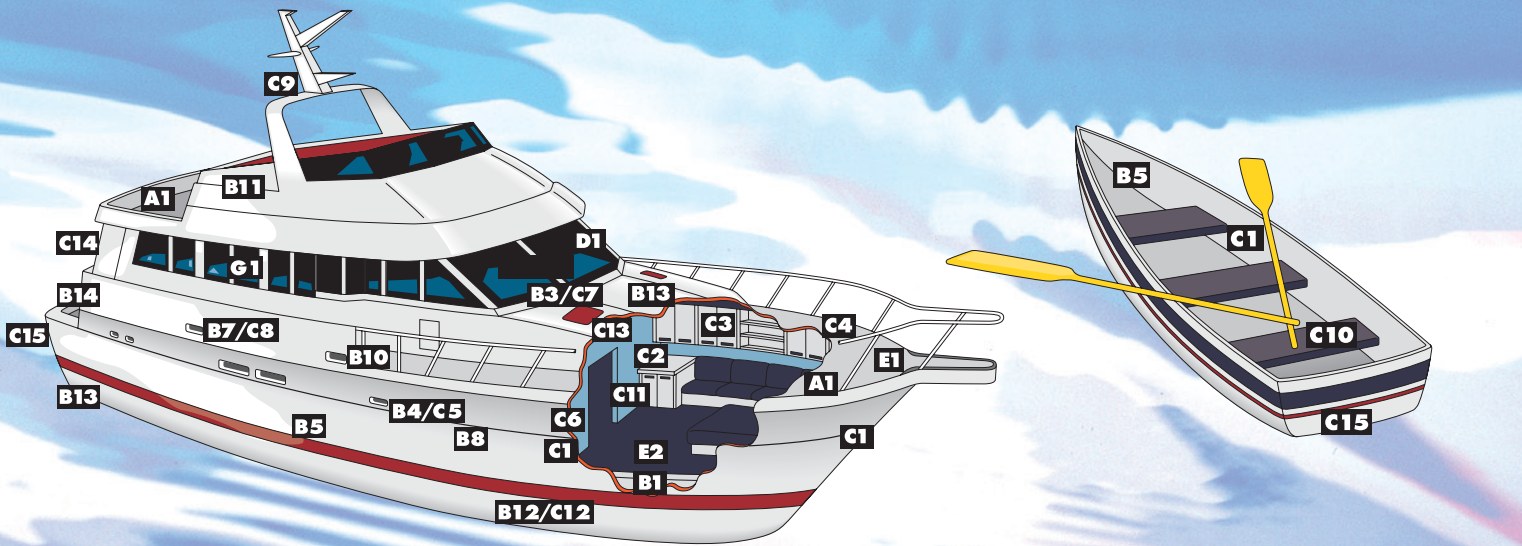


# Powerful Connections

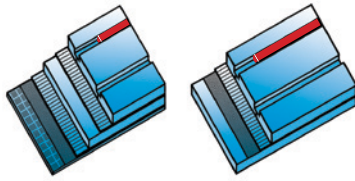
Leading manufacturers in the marine industry were quick to appreciate the unique properties and the outstanding quality of our innovative marine products many years ago – and have been using these systems ever since. The benefits are mutual: The feedback from our commercial collaboration with the builders of sailing yachts and power boats, ocean-going cruisers and cargo vessels also helps us to refine our technical know-how. Sika Marine engineers regularly visit their customers to discuss the needs and to develop new applications for Sika adhesive and sealing systems in collaboration with the end-user. Leading shipyards around the world use Sikaflex® Marine products.

Typical applications include:

- Bonding and sealing of observation windows
- Bonding and sealing of fly bridges
- Interior sealing of passenger cabins and other ship's accommodations
- Elastic bonding of components in preference to welding or the use of rivets and bolts
- Bonding of decorative wall panels and work surfaces
- Total teak deck constructions
- General sealing requiring fire, smoke and tox-approvals, e.g. cable penetrations
- Caulking of teak and other sorts of wooden planks or panels
- Bonding and sealing of fittings and hardware
- Direct glazing of mineral and organic "glass" panels

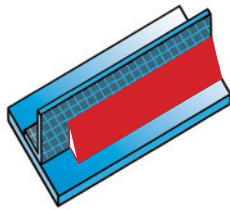


# Sikaflex® Marine Series for a Top Performance

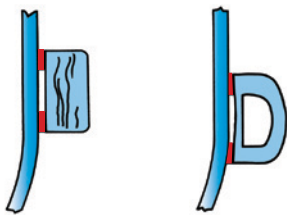


**Sikaflex®-290 DC**  
 Cartridge: 300 ml / black, cream-white  
 Unipack: 400 ml, 600 ml, 1000 ml / black  
 Hobcock: 27 kg / black  
 Drum: 195 kg / black

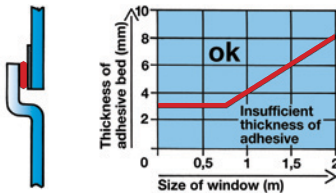
**Sikaflex®-290 DC SL**  
 Hobcock: 27 kg / black  
 Drum: 195 kg / black



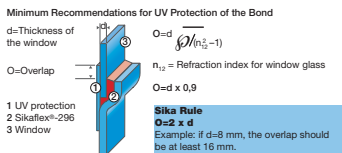
**Sikaflex®-291**  
 Tube: 100 ml / white, black  
 Cartridge: 300 ml / black, white, grey, wood  
 Unipack: 400 ml, 600 ml / black, white, grey  
 Drum: 195 kg / white



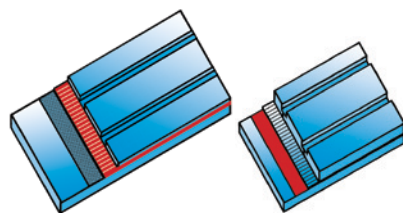
**Sikaflex®-292**  
 Cartridge: 300 ml / white  
 Unipack: 600 ml / white, brown, beige  
 Hobcock: 23 l / white



**Sikaflex®-295 UV**  
 Cartridge: 300 ml / black, white  
 Unipack: 400 ml, 600 ml / black, white  
 Hobcock: 23 l / black



**Sikaflex®-296**  
 Unipack: 600 ml / black



**Sikaflex®-298**  
 Unipack: 600 ml / black, brown  
 Pail: 10 l / black, brown

**Sikaflex®-298 FC**  
 Unipack: 600 ml, 1800 ml / black  
 Pail: 10 l / black

**Sikaflex®-298 SL**  
 Unipack: 600 ml / brown



## Different applications. Different products. Same benefits.

Sika pioneered the development of one-component polyurethanes for marine use. Our global technical resources have enabled us to develop and produce a wide range of products, each aimed at a specific marine application. Although the individual product characteristics vary, they all share the following features:

- One component – no mixing necessary
- Excellent gap-filling capabilities
- Permanently elastic
- Can be sanded and overpainted
- Excellent non-sag properties
- High solids content, low V.O.C.
- Non-corrosive
- For use above or below the waterline
- All products are specifically designed for marine use
- All products are Wheelmark approved by the leading European Certification Societies



# High Performance, High Yield

## Coverage data for Sika® Primers and Cleaners

Product	Pack size	Coverage (approx.)	Coverage per can	Coverage in linear metres, based on a bond face 3 cm wide
Sika® Cleaner-205	30 ml	40 ml/m <sup>2</sup>	0.75 m <sup>2</sup>	
	250 ml		6.25 m <sup>2</sup>	
	1000 ml		25.00 m <sup>2</sup>	
Sika® Primer-209	30 ml	150 ml/m <sup>2</sup>	0.20 m <sup>2</sup>	6 m
	250 ml		1.60 m <sup>2</sup>	50 m
Sika® Primer-210-T	250 ml	150 ml/m <sup>2</sup>	1.60 m <sup>2</sup>	50 m
	1000 ml		6.60 m <sup>2</sup>	200 m
Sika® Primer-290 DC	250 ml	150 ml/m <sup>2</sup>	1.60 m <sup>2</sup>	50 m
	1000 ml		6.60 m <sup>2</sup>	200 m

**Note:** Coverage data for Sika® Primers and Cleaners are given for guidance only, and will vary according to the nature and condition of the substrate.

## Coverage data for marine adhesives and sealants

### Sikaflex®-290 DC/-291/-292/-295 UV/-296

Width x height of triangular bead	Width x height of adhesive bead when compressed	Coverage in linear metres per 300 ml cartridge	Coverage in linear metres per 600 ml unipack
5 x 5 mm	5 x 2.5 mm	25	48
8 x 10 mm	8 x 5 mm	8	15
10 x 10 mm	10 x 5 mm	6	12
10 x 15 mm	10 x 7.5 mm	4	8

## Coverage data for Sikaflex®-298 bedding compound

Applied thickness (with notched spreader)	Consumption (approx.) per m <sup>2</sup>	Coverage (approx.) per 600 ml unipack
2 x 2 mm	600 ml	0.50 – 0.75 m <sup>2</sup>
4 x 4 mm	2000 ml	0.30 – 0.40 m <sup>2</sup>

Please consult our Marine Application Guide and Technical Data Sheets or your local Sika Company prior to any use or processing.



[www.sika.com](http://www.sika.com)

