

Sikaflex® – A NAME BOAT-OWNERS AND BUILDERS TRUST ALL AROUND THE WORLD

Product Selection Guide for the Sika Canada Inc. Sikaflex® Marine Product Offering

The most trusted name in marine adhesives world-wide...

Sika Product	Description	Application	Advantages
Sikaflex®-290i DC	Weather-proof deck caulking sealant.	Used exclusively for the caulking of joints in traditional timber-strip decking in boat and yacht building.	<ul style="list-style-type: none"> • Non-corrosive; • Resistant to UV light and weathering; • Sea water- and fresh water-resistant.
Sikaflex®-291	Multi-functional adhesive sealant for marine applications.	Used for sealing and light-duty bonding of all hull and structural members.	<ul style="list-style-type: none"> • Cures rapidly; • Permanently elastic; • Excellent cut- and tear- resistance; • Salt water-resistant; • Adheres to a wide range of substrates, in many cases without primer.
Sikaflex®-291 LOT (Long Open Time)	All-purpose marine adhesive, sealant and bedding compound.	Used for sealing and light-duty bonding; also suitable for bedding of deck hardware, hatches, port lights and other items identified for future removal.	<ul style="list-style-type: none"> • Long assembly time; • Permanently elastic; • Salt water-resistant; • High strength.
Sikaflex®-292i	Structural adhesive for marine applications.	Used for applications requiring structural bonding and sealing as well as for sealing large-dimension joints.	<ul style="list-style-type: none"> • Fast cure-rate and strength build-up; • Bonds and seals in one step; • Provides a high-strength bond with elasticity for joints; • Eliminates need for mechanical fasteners.
Sikaflex®-295 UV	UV-resistant direct-glazing adhesive for plastic glass.	Used for sealing and direct-glazing applications for organic glass such as PMMA where resistance to direct sunlight is required.	<ul style="list-style-type: none"> • Fast cure-rate and strength build-up; • Bonds and seals in one step; • Provides a high-strength bond with elasticity for joints; • Eliminates need for mechanical fasteners; • Primer is mandatory.
Sikaflex®-296	Direct-glazing adhesive for safety-, laminated- and insulation-glass windows in the shipbuilding industry.	Non-solvent formula used for direct-glazing applications involving inorganic glass, such as mineral-glass-based windows.	<ul style="list-style-type: none"> • Excellent working characteristics; • Fast cure-rate; • Resistant to ageing and weathering; • Solvent- and PVC-free; • Primerless application possible.

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Technical Data

Product	Colour(s)	Tensile Strength	Sandable	Paintable	Tack-Free Time	Non-Sag Rating	Use Below Water-line	Application Temperature
Sikaflex®- 290i DC	Black	1.3 N/mm ²	Yes	n/a	70 minutes	Good	No	5 - 25°C
Sikaflex®- 291	Black White Grey	1.8 N/mm ²	Yes	Yes	60 minutes	Good	Yes	5 - 40°C
Sikaflex®- 291 LOT	Black White Mahogany	1.4 N/mm ²	Yes	Yes	3 to 4 hours	Good	Yes	4 - 43°C
Sikaflex®- 292i	White	4 N/mm ²	Yes	Yes	40 minutes	Very Good	Yes	10 - 35°C
Sikaflex®- 295 UV	Black White	1.1 N/mm ²	n/a	n/a	60 minutes	Good	n/a	10 - 35°C
Sikaflex®- 296	Black	6 N/mm ²	n/a	n/a	45 minutes	Very Good	n/a	10 - 35°C

Suitable Surfaces: Providing proper surface preparation is first carried out, all products can be applied to: Wood, Stainless Steel, PVC, ABS, Aluminium, Plastics, Glass, Painted Surfaces and Iron/Steel.

Surface Preparation: Refer to the table below and select the appropriate surface preparation method depending upon the substrate.

Surface Preparation Guidelines

Product	Substrates	Applicator	Drying Time	Uses
Sika® Aktivator-205	Metals, plastics, glazed ceramics, painted surfaces.	Clean, lint-free tissue or paper towel.	10 minutes to 2 hours.	To clean all surfaces prior to priming or urethane application.
Sika® Aktivator	Glass, ceramic-coated glass, cut face of old polyurethane adhesive beads, polyurethane-coated window glass and paint.	Clean, lint-free tissue or paper towel.	30 minutes to 2 hours.	As a cleaning and activating agent specifically formulated to treat bond faces in direct-glazing work prior to the application of various Sika polyurethane adhesives.
Sika® Primer-206 G+P	Glass, metal and plastics.	Brush or felt pad.	10 minutes to 24 hours.	On bright metal scratches; as a black-out primer when a frit is scratched or absent; on bare metal to inhibit rust.
Sika® Primer-209 N	Paints: acrylics, alkyds/melamines, baked ena-mels, powder coatings; Plastics: acrylic (PMMA), polycarbonate, poly-styrene, etc.	Brush or felt pad.	30 minutes to 24 hours.	To prime painted surfaces and plastic substrates prior to bonding with Sikaflex® products.
Sika® Primer-210	Many metals, plastics and paint-primed substrates.	Brush or clean cloth.	30 minutes to 24 hours	On aluminium, galvanized steel sheet and some plastics prior to bonding or sealing with Sikaflex® products.
Sika® Primer-215	Plastics such as GRP, epoxy resins, PVC, ABS and timber.	Brush or felt pad.	30 minutes to 24 hours.	To prime various plastics, timber and other porous materials prior to bonding with Sikaflex® products.
Sika® Primer-290 DC	Teak, Mahogany, Oregon Pine, Iroko.	Brush.	60 minutes to 7 days.	To prime timber decking prior to caulking with Sikaflex®-290i DC.

NOTE: Always pre-test substrates for proper choice of sealant/adhesive.
For detailed product and application information, please refer to the Product Data Sheet for each product.
For detailed technical issues, please contact your local Sika distributor.

The information, and in particular, the recommendations relating to the application and end-use of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions, within their shelf life. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any recommendations, or from any other advice offered. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users should always refer to the most recent issue of the Product Data Sheet for the product concerned, copies of which will be supplied on request or can be accessed in the Internet under www.sika.ca.

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