

P.O. Box 568, Southport, QLD 4215
PH 1300 887 077, Fax 1300 887219, Mob 0403 570499

INSTRUCTIONS FOR BONDING ACRYLIC TYPE GLAZING PANELS TO FIBREGLASS VESSELS

PREPARATION OF ACRYLIC OR PERSPEX GLAZING PANEL

Note: Some Acrylic and Perspex Glazing Panels are supplied wrapped in paper/plastic protective wrap that has had a surface treatment to ensure the paper wrap protects the panel during transport. At the early stages of preparation only locally remove protection film from the internal face bonding area, once this wrap is removed from the proposed bonding area, the following steps are recommended,

1. Mask with appropriate tape around the inside of the bonding zone on the Acrylic or Perspex panel,
2. Light sand using extra fine grit paper over this internal bonding area only to create a mechanical interlocking interface.
3. Clean the Acrylic and Perspex glazing panel with **Fixtech Gun Foam Cleaner (Spray) or a good quality Wax and Grease Remover or Acetone** ensuring to rotate the cloth regularly, as it picks up the surface oils and debris.

Note: due to the wide variety of synthetic glazing panels, it is advisable to perform preliminary cleaning and adhesion testing, before proceeding with the project.

PREPARATION OF GELCOAT SUPPORT

1. **Lightly Sand** the proposed substrate bonding area and eliminate dust with brush and vacuum cleaner.
2. Carefully Mask with Tape the area of the substrate you do not wish to have the adhesive sealant adhere to,
3. Wipe bonding area with Methylated Spirits or White Spirits.

APPLICATION OF ADHESIVE/SEALANT AND POSITIONING

WITH DOUBLE SIDED TAPE:

1. Position spacers and window locator marks after dry fitting to ensure when the window is rotated into position very little if any adjustment is required (the choice is a function of dimension and type of panel to apply). **PLANNING IS BEST FOR A NEAT JOB.**
2. Apply the Double Sided Glazing Tape onto the Synthetic glazing Panel using the inner line of the window/port-hole this will form the dam to which the sealant is built up to. Ensure you keep the tape seal cover on until all sealant has been applied.
3. Open the **FixSil FS200** cartridge by cutting off the tip, screw on the applicator nozzle.
4. Apply the **FixSil FS200** to the panel and spread with a sponge or plastic spatula so as not to scratch the panel, wipe up to the dam tape edge. Ensure complete blackout is obtained, for best finish.
5. Cut the nozzle with a triangular opening on one side, this will mean a triangular bead will be extruded.
6. Apply **FixSil FS200** liberally in both a ziz-zag format but also a continuous line around the perimeter of the panel (Higher than the dam tape)
7. Peel off the cover to the Double Sided Glazing Tape.

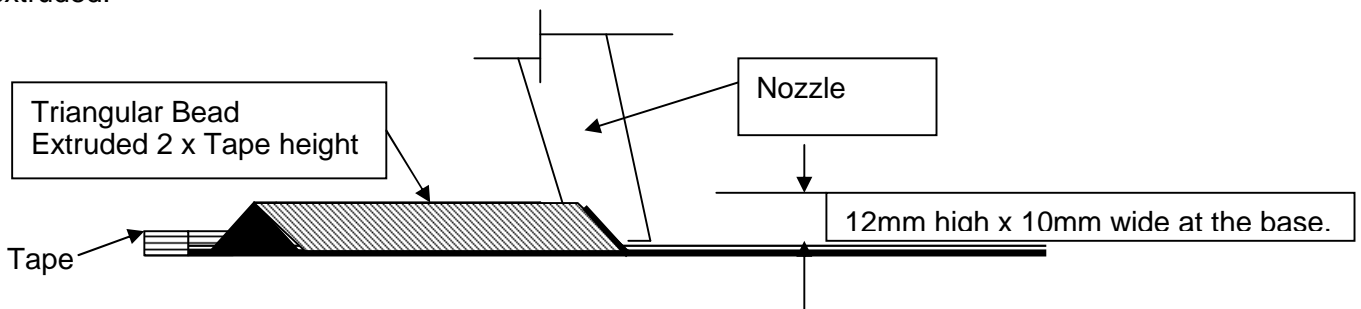
This information has been given in good faith and with the knowledge best known at the time of documentation. It is recommended that due to the differences found in glass that a sample be made before proceeding with the entire job.

P.O. Box 568, Southport, QLD 4215
PH 1300 887 077, Fax 1300 887219, Mob 0403 570499

8. Within 20 minutes the polymer window panel must be positioned and pressed on to the structure to the spacer distance. The panel must be mechanically held in place at regular intervals for at least 7 days (Best 14 days), and protected by a sun proof cover from direct sunlight exposure for this time.
9. After this period of time or more the mechanical fixings can be removed and the panel made ready for the finishing sealing cove/fill with **FixSil FS200**.

WITH SPACER ONLY (NO DOUBLE SIDED TAPE):

1. Position spacers and window locator marks after dry fitting to ensure when the window is rotated into position very little if any post fit adjustment is required. (The size of the spacer and perimeter gap between window and rebated substrate is a function of window dimension and type of panel will give you the expansion and contraction limits). **PLANNING IS BEST FOR A NEAT JOB.**
2. Apply the Masking Tape onto the synthetic glazing Panel using the inner line of the window/port-hole this will form the internal line to which the blackout silicone will be pasted too.
3. Open the **FixSil FS200** cartridge by cutting off the tip, screw on the applicator nozzle.
4. Apply the **FixSil FS200** to the panel and spread with a sponge or plastic spatula so as not to scratch the panel, wipe up to the masking tape edge. Ensure complete blackout is obtained, for best finish.
5. Cut the nozzle with a triangular opening on one side, this will mean a triangular bead will be extruded.



6. Apply **FixSil FS200** liberally in both a ziz-zag format but also a continuous line around the perimeter of the panel (Higher than the spacer x 2)
7. Within 20 minutes the polymer window panel must be positioned and pressed on to the structure to the spacer distance. The panel must be mechanically held in place at regular intervals for at least 7 days (Best 14 days), and protected by a sun proof cover from direct sunlight exposure for this time.
8. The masking tape can be removed after installation carefully after installation of the panels.
9. After this period of time or more the mechanical fixings can be removed and the panel made ready for the finishing sealing cove/fill with **FixSil FS200**.

NOTE:

In This method you are applying everthing to the acrylic galzing panel and lifting it into position, therefore pre planning is important to ensure success of the job. Acrylic Glazing chocks are advisable to set the panel on a rotate it into position, ensure you have at least 5mm clearance away from the boat structure.

This information has been given in good faith and with the knowledge best known at the time of documentation. It is recommended that due to the differences found in glass that a sample be made before proceeding with the entire job.

P.O. Box 568, Southport, QLD 4215
PH 1300 887 077, Fax 1300 887219, Mob 0403 570499

FINISHING AND SEALING OF THE ACRYLIC TYPE GLAZING PANEL

FINISHING PREPARATION

After 7 days the space between acrylic and vessel structure can be sealed

1. Remove mechanical fixings.
2. Wipe clean the fibreglass and the end of the Acrylic panel with **Methylated Spirits** as previously specified
3. Tape the outside face perimeter of the glass panel and the vessel structure to form the position of the finishing sealant.

FINISHING APPLICATION

Equipment required: smooth trowel or coving tool, (soapy water diluted in a spray bottle, only if you have to, best to use dish washing liquid soap diluted).

1. Cut the top seal off the cartridge of **FixSil FS200** silicone, and screw on nozzle, cut tip to required diameter.
2. Apply the **FixSil FS200** into the space.
3. With the clean finishing tool or coving tool, tool off the area as quickly as possible squeezing the sealant to the glass panel edge and vessel structure mask taped edge. Try not to spray soapy water onto the sealant if possible use the tool to obtain the best finish.
4. Immediately peel away the mask tape from the glass and vessel structure back on itself and away from the sealant, this will reduce string effect.
5. It is best to leave the sealant alone at this stage and ensure no airborne dust is present until the sealant has cured.
6. If the sealant needs touching up in small areas, apply lots of soapy water on this area before touching it for localised smoothing, if you have too.
7. Do not touch the sealant for at least 1 day; try to keep the area free from dust and debris, the longer you leave the window panel and sealant out of direct sunlight the less movement in the panels whilst the sealant is curing. We therefore recommend protecting the new window systems for up to a minimum of up to 7 - 14days where possible (the longer the better).



Colours:
Black and White

Part numbers:
FS200WH White 310mL cartridge
FS200BK Black 310mL cartridge

This information has been given in good faith and with the knowledge best known at the time of documentation. It is recommended that due to the differences found in glass that a sample be made before proceeding with the entire job.