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INSTRUCTIONS FOR DECK TO HULL AND FLYBRIDGE BONDING

PREPARATION OF ALUMINIUM SUBSTRATES

1. Heavily abrade the contact surface with a 60/100 grit sanding pad, ensuring to remove all dust.
2. Clean the surface using a clean, lint free rag or paper towelling with acetone or 100% methylated spirits.

PREPARATION OF GRP

It is not advisable to use Acetone on Polyester or Vinyl Ester resin, as this reactivates the resin

1. Heavily abrade the contact area with a fine sanding pad removing all dust.
2. Clean the surface with a clean, lint free rag or paper towelling with acetone or 100% methylated spirits.

APPLICATION OF MSP 190, (slow working time)

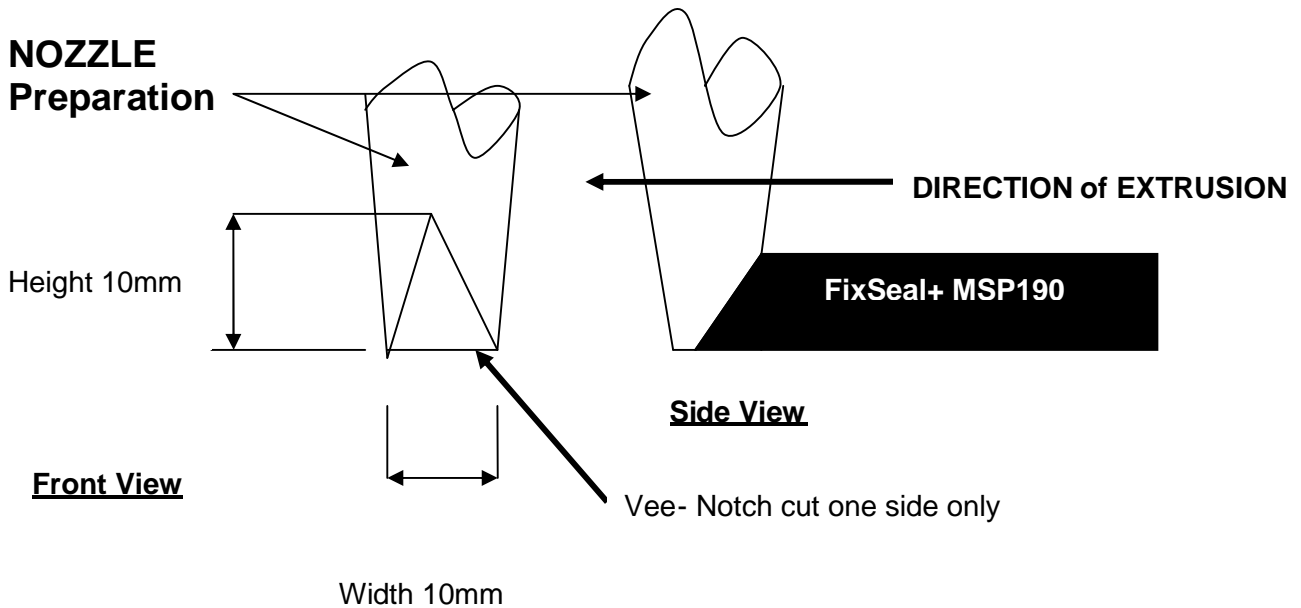
It is vital to check the accuracy of the fit, prior to applying the adhesive, so the parts do not have to be separated once brought together.

1. If a horizontal joint, place spacers in position, (thickness at least 4mm, approx. 50 Shore A hardness). These can be placed sideways into the adhesive, in order not to damage the continuity of the bead.
 - 1a. If a vertical joint, eg shoebox fix, there is no need for spacers.
2. **Hull:** Apply MSP 190 around the entire periphery of the hull, (depending on the width of the bond face, 2 or 3 beads of MSP 190 should be applied). The adhesive bead must be carried in a continual motion around any cut outs or clearance holes, in order to maintain the integrity of the water tight joint.

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.

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The recommended profile should be



Flybridge: Apply MSP 190 in a triangular profile 10mm x 10mm, around the entire flybridge. Depending on expected size of load, an additional bead may be required.

3. Assemble components within 30 minutes of applying adhesive.
4. Apply pressure with clamps or other fastening aids to compress the adhesive to the height of the spacers.
5. Clamps and other fastening aids can be removed after 3-8 days. Full service strength is attained after approximately 5-10 days. (Drying rate of 2-3 mm every 24 hours.)
6. Traces of uncured adhesive can be removed with methylated spirits or acetone. Traces of cured adhesive can be removed by mechanical removal.

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