Sika Pre-Treament Chart for Marine Applications

Precondition:
Surfaces have to be dry, free of oil, fat, dust and loose particles. Soiled non porous substrates can be cleaned with Sika® Remover-208. According to the nature of soiling, water based cleaners or steam washer etc may be used. For soiled porous substrates, grind surface down to sound material. It is recommended to verify compatibility with the cleaning products.

Substrates \ Products	Sikaflex®-291i Sikaflex®-298	Sikaflex®-295 UV	Sikaflex®-292i Sikaflex®-296	Sikasil® WS-605 S Sikasil® SG-20 Sika® Firesil Marine N
Aluminium [1]	205 → SMM	AP → 205 → SMM	AP → 205 → SMM	AP → 205
Aluminium anodised [1]	SA → 205	SA → 205 → SMM	SA → 205 → SMM	205
Steel [2]	AP → 205 → SMM	AP → 205 → SMM	AP → 205 → SMM	AP → 205
Stainless steel [3]	AP → 205	AP → 205 → SMM	AP → 205 → SMM	AP → 205
Brass	205 → SMM			205
Metal with shop primer	SA	AP③ → SA → SMM	AP③ → SA → SMM	205
Metal with 2C Ac/PU-paint [9]	SA	SA	SA	205
FRP (UP,EP,PU) lay up side [5] [8]	GR-V → SMM	GR-V → 205 → SMM	GR-V → 205 → SMM	205
FRP (UP,EP,PU) gel coat side [5] [8]	205	AP → 205 → SMM	AP → 205 → SMM	205 → SMM
PVC hard, opaque [6]	205 → SMM		205 → SMM	205
ABS [6]	SMM	SMM	SMM	205
PMMA [7] [8]		AP-V → 209D		AP → 205
SikaTransfloor®-352	GR-V④			
Antislip deck covering	SA			
Teak	SMM	SMM		
Wood and wood derivates	SMM	SMM	SMM	SMM
Phenolic Plywood [10]	GR-V⑤ → SMM		GR-V⑤ → SMM	GR-V⑤ → SMM
Ceramic screen print			SA → 206GP	205
Glass [8]			SA⑥ → 206GP	205
Polycarbonate		AP-V → 209N		AP → 205

Substrates \ Products	Sikaflex®-290 DC
Aluminium [1]	
Steel [3]	
Metal with shop primer	
SikaTransfloor®-352	
Teak	SMM
Wood and wood derivates	SMM

[1] to [10] *see last page „Explanatory Notes on Substrate Preparation“*

1st Process = Recommendation
2nd Process = Alternative

Abbreviation	Product/Explanation
	Not applicable
GR-V	Grinding (60 -80 grit) and vacuum cleaning
AP	Abrasive Pad very fine
AP-V	Abrasive Pad very fine and vacuum cleaning
205	Sika® Aktivator-205 *
SA	Sika® Aktivator
SMM	Sika® MultiPrimer Marine
206 GP	Sika® Primer-206 G+P
209 D	Sika® Primer-209 D
ZP	Sika® Cor ZP-Primer

* Note: Product name was changed from Sika® Cleaner-205 to Sika® Aktivator-205

① *Alternative: Grit-blasting with aluminium oxide*
② *Alternative: Sandbalsting*
③ *If shop primer is detoriated it has to be grinded instead of scuffed (AP)*
④ *Do not clean with solvents*
⑤ *Grind off phenolic layer to bare wood where adhesive or sealant have to be applied*
⑥ *Only Sikaflex®-296 to be used (ensure proper UV protection)*