

ROBERTSON AND CAINE (Pty) Ltd

Standard Operating Procedure



Title:- Windows and portlights installation

SOP No:A027

1. Purpose

To ensure the correct installation of windows and portlights.

2. Scope

Assembly Shop Production – Deck fitting.

3. Responsibility

Production Manager

QC Manager

4. Related Documents

DVO # 742

Drawing # L44 FA-108

5. Packing List

QTY	Description	Code
2	SIKA PRIMER-206 G+P 250ML BOTTLE	PRMSKA206G+P
2	SIKA PRIMER VP209 200ML BOTTLE	PRMSKA209
60	SIKAFLEX 295UV ADHESIVE	ADHСКА295UVBK
1	SIKA REMOVER 208 1LT CAN	CLNSKA208

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6. Procedure

6.1 Surface preparation 1 (GRP Core)

6.1.1 Lightly scrape deck bonding area with a polyester scouring pad as shown in Figure 1.1 and Figure 1.2. Remove dust with a clean rag.

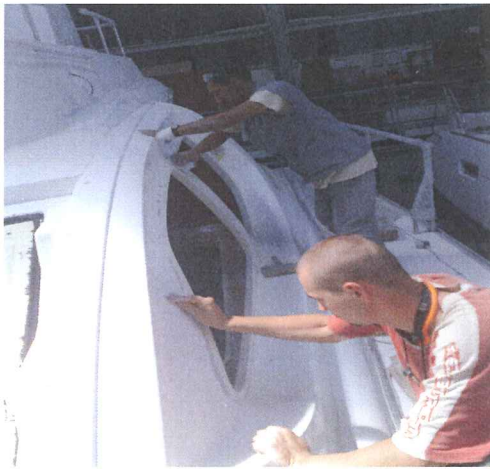


Figure 1.1



Figure 1.2

6.1.2 Clean bond area with Sika Remover 208 as shown in Figure 2.1 and Figure 2.2 and let it dry for a minimum time of 10 minutes. Do not allow waiting period to exceed 2hrs before next application, or this step will have to be repeated.



Figure 2.1



Figure 2.2

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6.1.3 Dry-fit the windows on the boat and mark off the view area.



Figure 3.1

6.1.4 Then place the self adhesive rubber sealing strip all around each edge of the window cut-outs as shown in Figure 4.1, Figure 4.2.



Figure 4.1



Figure 4.2

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6.1.5 Shake the can of Sika-Primer 206 G+P very thoroughly until paint mixing ball is heard to rattle freely. Apply a thin, but covering, coat of Sika-Primer 206 G+P; use a dry clean brush as shown in Figure 5.1, 5.2 & 4.2. DO NOT apply thick layers. Appearance should be a streaky gray colour – not black! Allow a minimum time of 30 minutes to dry. Do not allow waiting period to exceed 8hrs before next application or this step will have to be repeated. Do not touch with hands or fingers.

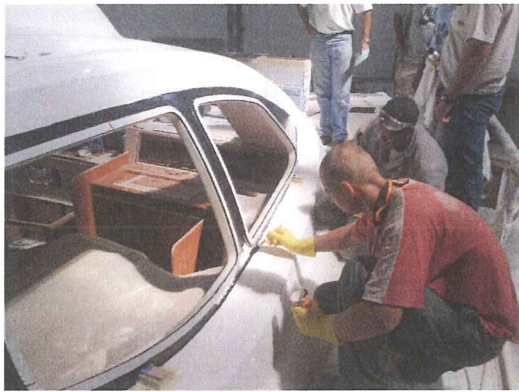


Figure 5.1



Figure 5.2

6.2 Surface preparation 2 (Polycarbonate Acrylic)

6.2.1 Lightly scrape the window's bonding area outside of the tape markings with a polyester scouring pad as shown in Figure 6 below. Remove dust with a clean rag.



Figure 6

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6.2.3 Clean bond area with Sika Remover 208 as shown in Figure 7 below and let it dry for a minimum time of 10 minutes. Do not allow waiting period to exceed 2hrs before next application or this step will have to be repeated.



Figure 7

6.2.4 Shake the can of Sika-Primer 209 very thoroughly until paint mixing ball is heard to rattle freely. Apply a thin, but covering, coat of Sika-Primer 209 with a dry clean brush as shown in Figure 8.1 and Figure 8.2. Let it dry for a minimum time of 30 minutes. Do not allow waiting period to exceed 8hrs before next application or this step will have to be repeated. Then carefully remove the masking tape.



Figure 8.1



Figure 8.2

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6.2.5 Apply Rubber Foam Seal 20mm inside of the window's edges; like in Figure 9. Then apply a thick bead of Sikaflex 295 UV Black on the window's edge.



Figure 9

6.2.6 Assemble components within 30 min as shown in Figure 10.1 and Figure 10.2.

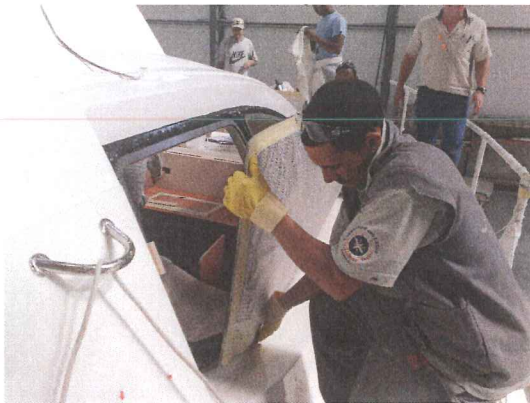


Figure 10.1

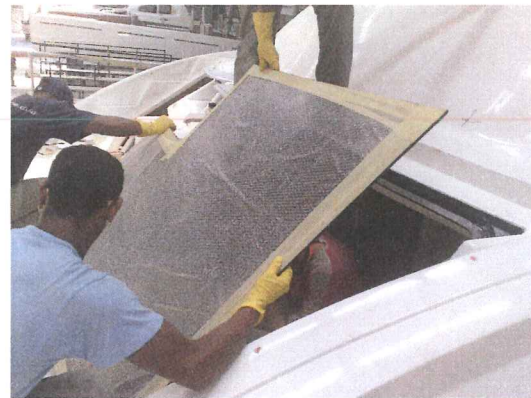


Figure 10.2

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6.2.7 Compress to required thickness and let it set for 24 hours as shown in Fig 11.1 & 11.2.

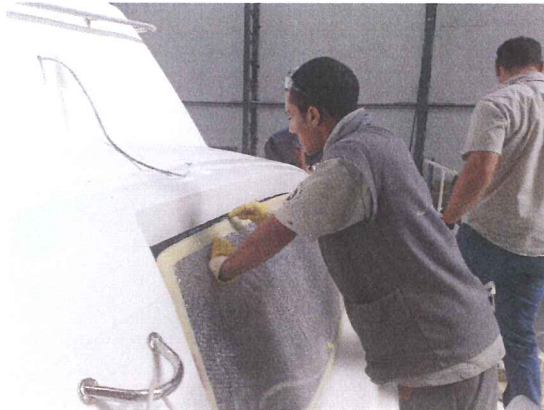


Figure 11.1



Figure 11.2

6.2.8 Mask joint area with masking tape as shown in Figure 12.1 and 12.2 below.



Figure 12.1



Figure 12.2

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6.2.9 Fill up joint completely with Sikaflex 295UV black as shown in Figure 13.1 & 13.2. Smooth the edge accordingly.

NOTE: Avoid any air entrapment as this will hamper curing results.

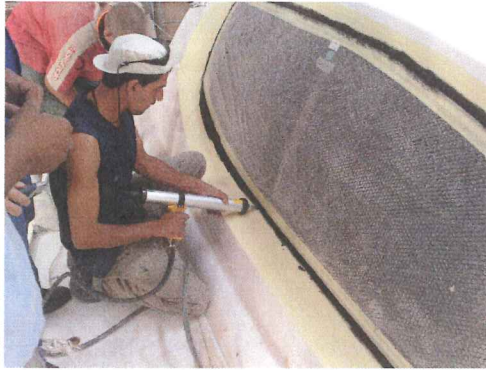


Figure 13.1



Figure 13.2

6.2.10 Carefully remove masking tape immediately as shown in Figure 14.

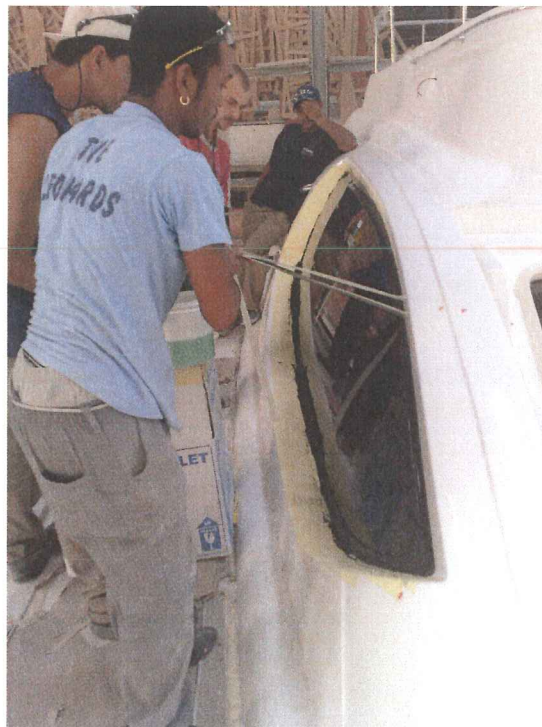


Figure 14

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6.2.11 Remove spots of Sikaflex 295UV black using Sika Remover 208 as shown in Figure 15.1. Mask off the area (Fig 15.2) and allow curing time of 24hrs.



Figure 15.1



Figure 15.2

NOTE:

DRYING AND CURING TIME DEPEND ON AN AMBIENT TEMPERATURE OF 23°C AND A RELATIVE HUMIDITY OF 50%.

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