

The below information is to be followed when using the Seakeeper Bond-in saddles to install a Seakeeper Gyro.

Seakeeper recommends using a structural adhesive with a lap shear strength of 2000 psi (13.8 MPa) or greater. Careful consideration should be exercised by the installer when selecting the appropriate adhesive. Compatibility with the Gyro's cast aluminum A356- T6 saddles, hull structure and pot life are three important factors to consider. Proper surface preparation in accordance with the adhesive manufacturer's recommendations prior to installation is very important. Information regarding pot-life, structural properties and material compatibility can be found on the adhesive's product data sheet. An etching/cleaning primer compatible with the adhesive should be used on all aluminum surfaces if recommended by the manufacturer. Review the Seakeeper Gyro installation manual for more guidance.

Below are examples of structural adhesives which meet the requirements to accomplish a bond-in installation of a Seakeeper Gyro.

- Plexus MA590 Structural Adhesive manufactured by ITW
- PRO-SET ADV-176/276 Super-Toughened Adhesive Epoxy manufactured by Gougeon Brothers Inc.
- SCI-GRIP SG300-40 Structural Adhesive

All technical data sheets and application instructions should be reviewed prior to the selection of any adhesive. There may be variables unique to your installation (such as gap filling properties or working time) that may require adhesives not listed above.