

STRUCTURAL ADHESIVE RECOMMENDATION



PRODUCT ALL PRODUCTS

This Technical Bulletin is applicable for deck mount installations (Seakeeper 1 / 2 / 3) or Seakeeper Bond-In saddles (Seakeeper 5 / 6 / 9 / 18 / 26). For bond-in installations, 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, as working time, material compatibility (deck mount plate, deck mount grids, cast aluminum saddles, and hull structure), and surface preparation are three crucial factors to consider. Proper surface preparation following the adhesive manufacturer’s recommendations before installation is critically important. Information regarding pot-life, structural properties, and material compatibility can be found on the adhesive product’s technical data sheet (**TDS**). An etching/cleaning primer compatible with the adhesive should be used on all aluminum surfaces if recommended by the manufacturer. Review the relevant Seakeeper installation manual or relevant part drawings for additional guidance.

Below are examples of acceptable structural adhesives which meet the requirements for a bond-in Seakeeper installation:

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

All TDS’s 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.

The TDS for Plexus MA590, Sci-Grip SG300, and Pro-Set ADV 176/276 are attached to this Bulletin as appendices. The adhesive manufacturer or supplier should be contacted for additional information specific to each adhesive.

Seakeeper recommends the following sources for structural adhesives in the US:

- Plexus: Efrain Grillo, Technical Sales Representative | Composites One – Phone: 305-342-8277/
Email: efrain.grillo@compositesone.com
- Sci-Grip: John Canada, President | Torx Marine – Email: john@torxmarine.com

Attachments: Technical Date Sheets of three manufacturers

Revision	Description	Approval	Date
3	Seakeeper 16 and 35 models retired. Seakeeper 40 introduced.	A Patricio	19JUL2023