



INSTALLING A FLEXITEEK DECK

FLEXITEEK TESTED ADHESIVES

We have conducted extensive in-house evaluations, as well as independent third-party testing, on a wide range of adhesives to ensure compatibility, performance, and long-term durability. Based on these results, we are confident in recommending the following products for use in conjunction with Flexiteek 3. These adhesives have been rigorously assessed to meet the highest standards of quality, reliability, and application efficiency, ensuring optimal results for your project.

Product	Available Colours
Bostik Adhesives	
Marocol 480	NEUTRAL
Bostik MSR CA Xtreme (for finishing only)	BLACK / WHITE / GREY
Chemworld Adhesives	
Chemworld 1 Part Glue	BLACK / WHITE / GREY / ULTRA WHITE / SCRUBBED
2K PU	NEUTRAL
Saba Adhesives	
Saba 720 / 750 XL / 780	BLACK/WHITE/GREY
Saba 950 Boost	BLACK

ACTIVATORS

Product	Information
Bostik Prep CS	Use as per Bostik install instructions
Saba Activator 9707	Use as per Saba install instructions

* Note only use the correct activator specified by each manufacturer.

GENERAL PREPARATION, ALL ADHESIVE BRANDS/MAKES

- Ensure all surfaces are as clean and dust free as possible.
- Although some products are moisture curing, it is important to keep all surfaces as dry as you can.
- Any loose material, such as paint or gel coat should be removed prior to application.
- Dry fit the panel to ensure a correct fit. At this stage, we recommend applying masking tape to the deck surrounding the panel to aid with removing any excess adhesive that may spread out during installation.

BOSTIK ADHESIVES

SURFACE PRETREATMENT

- For boat decks made from any material, clean the boat deck with Bostik Prep CS on the areas you will be bonding to that day.
- Going in one direction with Bostik Prep CS on a cloth and allow to hand dry for approximately 5 minutes.
- Clean the back of the Flexiteek 3 deck with Prep CS be sure to clean in one direction and allow to hand dry for approximately 5 minutes.
- Allow for approximately one 600 gram per square metre of decking.

GLUING WITH BOSTIK MAROCOL 480 - 2 COMPONENT ADHESIVE

Flexiteek can be bonded both indoors or outdoors, the following conditions apply:

- >> Do not bond in case of precipitation.
- >> Do not bond in case of high air humidity (> 90%).
- >> Avoid condensation on both the sheets and deck.
- >> Apply between +5°C and +35°C.

- Dry fit the panel to ensure a correct fit. At this stage we recommend applying masking tape to the deck surrounding the panel to aid with removing any excess adhesive that may spread during installation.
- Latex/nitrile gloves must be worn prior to starting to work with the adhesives.
- Open the 7kg can with Bostik Marocol PU 2D/480 A component and open the 1.17kg Hardner 4600 B-component. Pour the Hardener 4600 (B-Component) in the Marocol PU 2D/480 which will give a mixing ratio in weight: of 100:16.
- Mix A and B with a power drill and a standard paint mixer.
- When Marocol PU 2D/480 shows a homogeneous & consistent color it is ready to use. Please note that the adhesive has a pot life of 1.5 hours (23°C/50%RH) meaning that it needs to be applied on the deck before this time.
- Apply adhesive to deck and spread it with an adhesive spreader (using with triangle shaped teeth) giving a coverage of 0.8L/sqm, until the surface is fully covered with Marocol PU 2D/480.

Note: all adhesive grooves should run in the same direction but in the opposite direction to the caulking lines of the Flexiteek.

- Finally lay the Flexiteek into place and use a roller to bed the panel into the adhesive until flat and all air has been removed from under the panel.

Note: rolling must be carried out within the working time of the adhesive (2 hours @ 23°C/50%RH).

- Clean any excess adhesive from the panel edges using a scraper and remove masking tape.
- Apply vacuum bagging equipment (if required) to the deck, with full vacuum pressure being applied within the working time. Leave the vacuum and product to cure and do not disturb surfaces during this time (typically 8 hours).
- Caulking should not be added around the panel edges until at least 8 hours after the original installation of the panel.

Working Time Variations

Minimum Application Temperature for this adhesive is +5°C.

Temperature (°C)	Pot Life	Open Time	Cure Time
5	3 hours 30 min	6 hours	24 hours
15	2 hours 30 min	3 hours	15 hours
23	1 hour 30 min	2 hours	8 hours
30	1 hour	1 hour 30 min	6 hours
35	30 min	1 hour	4 hours

FINISHING WITH BOSTIK ADHESIVES

- BOSTIK MSR CA XTREME can be used as sealant around the outside perimeter of the deck. Clean surface (both Flexiteek as side wall of boat) with BOSTIK PREP CS and when dried (5 minutes) seal the perimeter.
- BOSTIK MSR CA XTREME comes in black, white, and grey, and can be used for perimeter caulking and sealing in a colour to complement the installed deck.

CHEMWORLD ADHESIVES

SURFACE PRETREATMENT

- For boat decks made from any material, clean the surface of the boat deck with Isopropyl Alcohol and allow to hand dry.
- Clean the back of the Flexiteek 3 deck with Isopropyl Alcohol be sure to clean in one direction and allow to hand dry.
- Allow for 1 part adhesive allow for approximately one 600ml foil per square meter of decking.
- Allow for 2K PU approximately 600gram per square meter of decking.

GLUING WITH CHEMWORLD 1 PART ADHESIVE

- Apply adhesive to the deck, ensuring a consistent bead and coverage is achieved. Use further adhesives to cover the entire area.
- Use a notched applicator to spread adhesive over the complete deck area giving a consistent adhesive bed of 1.4g/sqcm.
- Try to apply to the grooves in the same direction to the caulking lines of the Flexiteek 3 deck panel. Although, the opposite direction is also possible.
- Finally, lay the Flexiteek 3 deck panels into place and use a roller to bed the panel into the adhesive until flat and all air has been removed from under the panel.
- Rolling must be carried out within the working time of the adhesive. If skinning of the adhesive has started before the panel has been rolled onto the adhesive a bond failure may occur.

Note: Skin time is 15-20 mins.

- Leave product to cure and do not disturb surfaces during this time (can be walked on after a minimum of 4 hours).
- If the deck is flat, there is no need to apply weight. However, if there are tensions in the material that cannot be rolled out, it must be weighted down using weights or a vacuum to ensure consistent surface wetting. Vacuum may be used if there is sufficient moisture for the adhesive to cure.

GLUING WITH CHEMWORLD 2K PU 2 COMPONENT ADHESIVE

- Dry fit the panel to ensure a correct fit. At this stage we recommend applying masking tape to the deck surrounding the panel to aid with removing any excess adhesive that may spread during installation.
- Latex/nitrile gloves must be worn prior to starting to work with the adhesives.
- Apply adhesive to deck and spread it with an adhesive spreader (using with triangle shaped teeth) giving a coverage of 200g/sqm (300g/sqm for porous materials), until the surface is fully covered.

Note: all adhesive grooves should run in the same direction but in the opposite direction to the caulking lines of the Flexiteek.

- Finally lay the Flexiteek into place and use a roller to bed the panel into the adhesive until flat and all air has been removed from under the panel.

Note: rolling must be carried out within the working time of the adhesive.

- This adhesive cures through pressure – weighting or vacuum installation is required.
- Clean any excess adhesive from the panel edges using a scraper and remove masking tape.
- Apply vacuum bagging equipment (if required) to the deck, with full vacuum pressure being applied within the working time. Leave the vacuum and product to cure and do not disturb surfaces during this time.
- Caulking should not be added around the panel edges until at least 8 hours after the original installation of the panel.

FINISHING WITH CHEMWORLD ADHESIVES

- The Chemworld 1 part glue comes in a variety of colours and can be used for perimeter caulking and sealing in a colour to complement the installed deck.

SABA ADHESIVES

SURFACE PRETREATMENT

- The underside of the Flexiteek decking must be prepped with SABA Activator 9707*
- Apply using either a lint free cloth or melamine sponge wiping in one direction then allowing to air dry.
- It is important not to wipe the same area twice.
- Activator 9707 has an open window of 3 hours. If this window has been missed simply reapply to the surface.
- Allow for approximately one 600ml foil per square meter of decking
- For the second bonding surface i.e. the boats deck, please follow the pre-treatment chart below:

Surface	Surface	Possible Alternative
Gel coat	Cleaning only - Sabaclean 46 or similar	Activator 9707
GRP laminate	Cleaning only - Sabaclean 46 or similar	Activator 9707
Painted surfaces	Cleaning only - Sabaclean 46 or similar	Activator 9707
Wood	Cleaning only - Acetone for oily wood	Activator 9707
Steel	Activator 9707	
Aluminium	Activator 9707	
Powder Coat	Activator 9707	

*Only SABA Activator 9707 is approved, do not use alternatives.

SABA ADHESIVE APPLICATION

- Sabatack 720, 750 XL, 780, and 950 Boost can both be applied using a manual, pneumatic, or battery caulking gun.
- For 950 Boost, the supplied adaptor and mixer nozzle must be used for an even mix and efficient application.
- Take note of working times for each product.
- For best results, apply even pressure to the decking to ensure consistent surface wetting.
- The surface should be fully wetted, and after 2–3 minutes, it should become touch dry.

SABA GLUING DOWN THE DECK

- Using the roller, remove any trapped air.
- Rolling must be carried out within the working time of the adhesive. If skinning of the adhesive has started before the panel has been rolled onto the adhesive, a bond failure may occur.
- If the deck is flat, there is no need to apply weight. However, if there are tensions in the material that cannot be rolled out, it must be weighted down using weights or a vacuum to ensure the adhesive wets properly.
- Vacuum can only be used if there is sufficient moisture for the adhesive to cure.

FINISHING WITH SABA ADHESIVES

- SABA Sabatck 720, 750 XL, and 780 comes in black, white, and grey, and can be used for perimeter caulking and sealing in a colour to complement the installed deck.

AFTERCARE & CLEANING

Flexiteek 3 is best maintained following the 5 step cleaning process already used with Flexiteek 2G.

The properties of Flexiteek 3 mean that most stains can be removed by water alone, especially if cleaned immediately.





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and marine products.

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