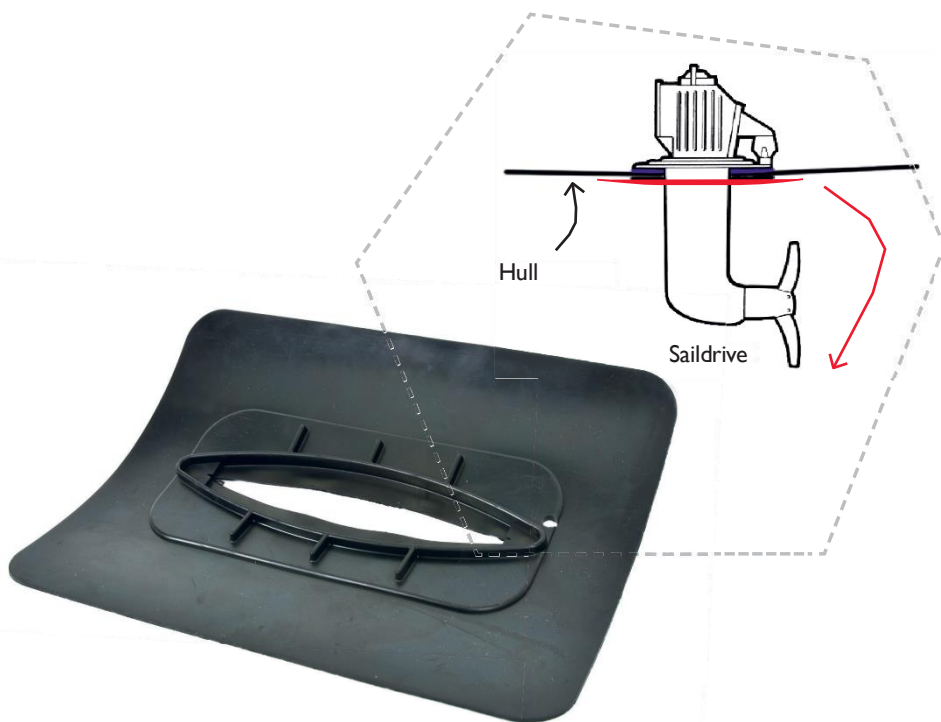


Saildrive Cover Plate Installation Guide

for VOLVO Penta Saildrives on a GRP hull



www.svb.de

INSTALLATION INSTRUCTIONS

This guide is a recommendation for installing a **VOLVO Penta Saildrive cover plate on a GRP hull.**

Prior to installation, the user is strongly advised to familiarise himself/herself with the local conditions and material requirements and to make adjustments as required.

The user must ensure that necessary work safety precautions (e.g., wearing eye protection, skin protection, hand protection, etc.) and safety measures for using the suggested items (e.g., correct temperature, sufficient ventilation of the workplace, air humidity values, etc.) are followed while performing the work at hand.



Step 1:

Remove the old cover plate and clean the hull of all existing glue residue (do not sand). To do this, carefully remove the old adhesive with a blade and then use a paper towel soaked in **PANTASOL** (SVB itm. no. [19359/24459](#)) or **PANTASOL Light** no. [19362/24460](#)) to remove any further residues.



Step 2:

Dry fit the new cover plate. Generously mask the hull surface around the new cover plate with tape (e.g. masking tape SVB itm. no. [62223](#)). Then fit the cover plate and follow the edges with a cutter. Peel off the adhesive tape on the surface to be covered.



Step 3:

Clean the bonding side of the new cover plate very carefully with **PANTASOL Cleaner** (SVB itm. no. [19359/24459](#)) and a paper towel (at least 2 - 4x) to remove any production coating.



Step 4:

Apply **PANTERA Activator** (SVB itm. no. [25894](#)) with a paper towel in one direction to the side of the cover plate and the surface of the hull to be bonded and allow to air dry for at least 20 minutes (see technical data sheet, TDB).

After the airing time, the adhesive must be applied within 8 hours.



Step 5:

Apply the adhesive you will be using to the bonding surface of the cover panel in an even layer thickness (min. 3 mm).

The following adhesives are suitable:

IK Marine Sealant MS3000/60 V2

(SVB itm. no. [19349/19351/](#)

[19353/19354](#)) - whereby there is an open working time of approx.

5 - 10 minutes, a fixing time of 6 -12 hours

and a complete drying time of

approx. 24 - 48 hours (depending on temperature and humidity).



Or: **Marine Sealant MSP3000 V2** (SVB itm. no. [19357](#)) - in this case there is an open working time of approx. 30 minutes and high initial adhesion. Fixing time is approx. 15 minutes up to 6 hours and the complete drying time approx. 24 - 48 hours (depending on temperature and air humidity).



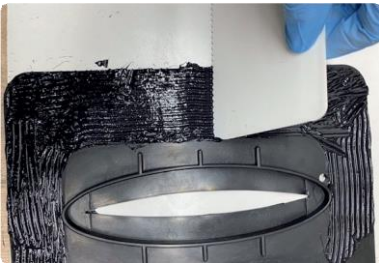
An excellent adhesive is:
2K Marine Sealant MS3000/60 V3 (SVB itm. no. [19358/25892](#)) - hereby there is an open working time of up to 30 minutes, a fixing time of approx. 1 hour and a 60% complete curing after 4 hours.



This adhesive can either be applied with a mixing nozzle, or mixed in a container and applied with a notched trowel.

See also www.panteraproduct.de Service / Kundentipps / Anwendung 2K

Mixing / Application:



Step 6:

Place the glue-coated panel under the hull and apply light pressure evenly, do not push too hard.

After applying pressure, there should be at least 2 mm of adhesive between the cover plate and the hull.



Step 7:

Smooth the visible glued seam with **PANTERA Smoothing Spray** (SVB itm. no. [25331](#)) and remove cleanly with a sealant joint tool (SVB itm. no. [61169](#)).



Step 8:

Immediately peel off the masking tape and use tape to hold the cover plate in place if necessary.



End of the installation:

A good result and clean work.

Tip: Rogue glue should not be removed with solvent such as Pantasol (solvent dissolves the glue again). Instead, let the glue harden and remove with a blade.

**NOTE:**

Antifouling should only be applied after the adhesive has fully cured, as antifouling usually contains high amounts of solvent.

Level of difficulty: easy. The time required: approx. 2-3 hours (not including dismantling the old panel).

Good luck with your installation.

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