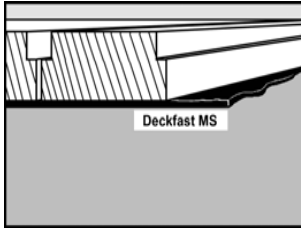
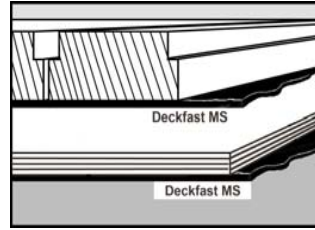


Laying the Deck

Generally speaking, teak decking is either laid directly onto the deck substrate (fibreglass, wood, aluminium or steel). When the surface is not smooth enough, an extra layer of plywood can be applied. The teak, and plywood if applicable, are both laid using either Deckfast MS or Sealtrack 750 Adhesives. Deckfast MS is available in 600cc sachets only, and is ideal for applying to larger areas by cutting the end of the sachets and then levelling out with a spreader. Sealtrack 750 is available in 290ml tubes and can be applied using a normal caulking gun. It is also an excellent general purpose adhesive ideal for all bonding applications in a marine environment.



Direct bonding of the teak parts onto the deck with Deckfast MS or Sealtrack 750.



Teak parts bonded on a levelling layer of plywood. Both bonded with Deckfast MS or Sealtrack 750.

Preparation

- Make sure the substrate and underside of the teak decking are free from dust, grease, oil and corrosion.
- Degrease the surfaces to be bonded using Cleaner 48. Make sure the Cleaner has completely evaporated (at least 15 minutes) before applying adhesive.
- If the deck is wood, primer is not required. If not, prime with Primer Marine S1.



Bonding:

- Apply Deckfast MS or Sealtrack 750 to the substrate and level with a spreader to a minimum thickness of 2mm and a maximum of 10mm.
- Lay the teak decking within 30 minutes of applying the adhesive.
- The decking should be 'agitated' into the adhesive to ensure a good surface contact. Alternatively, or in addition, the decking can be mechanically fixed (screwed), held down by pressure, or vacuumed onto the deck.
- The adhesive cures at the rate of approximately 2mm per 24 hours depending on temperature and humidity.
- It is important to leave the deck for **at least one week** before caulking the deck. This is to prevent the formation of air bubbles in the sealant.

Caulking

Once the adhesive has been left to cure, the deck can be caulked using Seal One HM which has superb UV resistance and will result in a long life and flexible sealer to your deck.

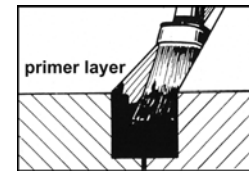
It is important the size of the seams are within the limits of the table below to allow for the natural movement of the teak. As a rule of thumb, seam width and depth must be approximately 10% of the plank width up to a maximum of 10mm.

Plank width	Min. Seam width	Min. Seam depth
35mm	5mm	5mm
45mm	5mm	5mm
50mm	6mm	6mm
75mm	8mm	8mm
100mm	10mm	10mm



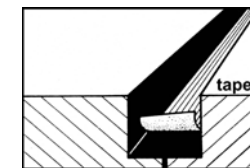
Preparation – Degreasing and Priming

- Remove all dust from the seams.
- Degrease using Cleaner 48. Make sure the cleaner has evaporated before applying the primer (at least 30 minutes).
- Apply Primer marine SM using a small brush, paying particular attention to the sides of the seams, and leave to dry for **at least 30 minutes**.



Apply the primer on the bonding zones.

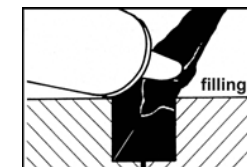
- Apply bond breaker tape to the bottom of the seams to prevent 3 sided adhesion



Apply separation tape at the bottom of the joint to avoid 3-side bonding.

Applying the Caulking

- Using an application gun (either air pressure or manual), cut the nozzle at an angle of 45° at a width that fit exactly in the seam.
- Apply the sealant from the bottom of the seam to avoid air bubbles forming.
- Fill the joint to approximately 2mm above the surface.

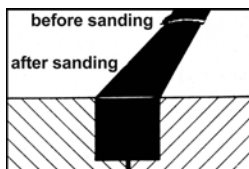


Fill the joints excessively with SABA Seal One HM from the bottom up to avoid locking in air bubbles. Use a spatula to slightly smoothen the sealant without applying any pressure.

- Use a spatula to slightly smoothen the seam, but do not apply any pressure.
- If you come back to caulking after a break, restart by applying 'sealant into sealant' to prevent air bubbles getting locked into your caulking.

Removing Excess Material and Sanding

- Leave Seal One HM to cure for **at least 6 days** before removing excess material
- Cut away excess material along the line of the seam using a sharp chisel (upside down).
- Sand the deck using an oscillating sander moving the machine along the teak planks, never across.



After curing: cut away excess material using a sharp spatula or chisel and then sand the deck using an oscillating sanding machine

Maintenance of your Deck

Clean the teak deck using fresh or sea water. Do not use high-pressure cleaning devices or rotating heads. Although a finish is not actually required for a teak deck, many owners prefer the aesthetic appearance of a varnish or lacquer. No subsequent deck treatment (eg varnish, paint etc) should be applied for at least 30 days after sealant application. We recommend **Epifanes Teak Oil Sealer** for an attractive finish that fully dries meaning it does not attract dirt like traditional teak oils which remain tacky.

Coverage Guidance:

The following table shows approximate coverage obtained. Please bear in mind coverage will vary according to conditions. Bonding quantities do not allow for deck levelling – If required reduce coverage accordingly.

Seam Size	Cleaning	Priming	Caulking	
	Metres per 1ltr Cleaner HM	Metres per 500ml Primer Marine	Metres per 290ml Seal One HM	Metres per 600ml Seal One HM
5 x 5mm	300	150	11	22
6 x 6mm	200	100	8	16
8 x 8mm	100	50	4.5	9
Bonding allowing 2mm thick serrated coverage				
Cleaning - sq metre per tin	Sealtack 750 290ml		Deckfast MS 600ml	
	No. required to cover 1 sq metre		No. required to cover 1 sq metre	
	10	3.5	1.6	

Contact Us!

For further guidance or more detailed information, please contact our marine department who will be happy to help. Trade and Stockist terms are available on all SABA products.

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Teak Deck Laying Guide

Introduction

Nothing can beat teak decks for beauty, life expectancy and anti-slip properties. In order to ensure a good working life for the deck, it is essential that great care is taken in both the preparation and application techniques. This guide covers the basic techniques of bonding and caulking using the SABA range of adhesives and caulking compounds. Epoxy also makes a superb caulking compound under certain conditions when a thin layer of teak is being laid, and WEST System produce an excellent guide to deck laying using epoxy which is available from us free of charge - please ask us for the WEST System technical guide or visit our website.



It is important that slow grown Burmese teak is used for decks ensuring consistent colour and durability. Robbins Classic Teak Decking is sourced from well managed forests where high quality is assured.

Working Conditions

Working conditions directly affect both the adhesive results and the overall workmanship of your job. To achieve best results, working temperatures should be between +5°C and +35°C, and moisture content of the materials to be bonded or caulked should not be above 14%. Over the installation period, temperature should either be constant, or ideally, gradually falling.

Both the primer and the caulking compound can be adversely affected by exposure to direct sunlight or water, particularly in the early stages of the application process. For best results, the entire area to be bonded should be sheltered for several hours before you begin.