

KS HATCH RIMS

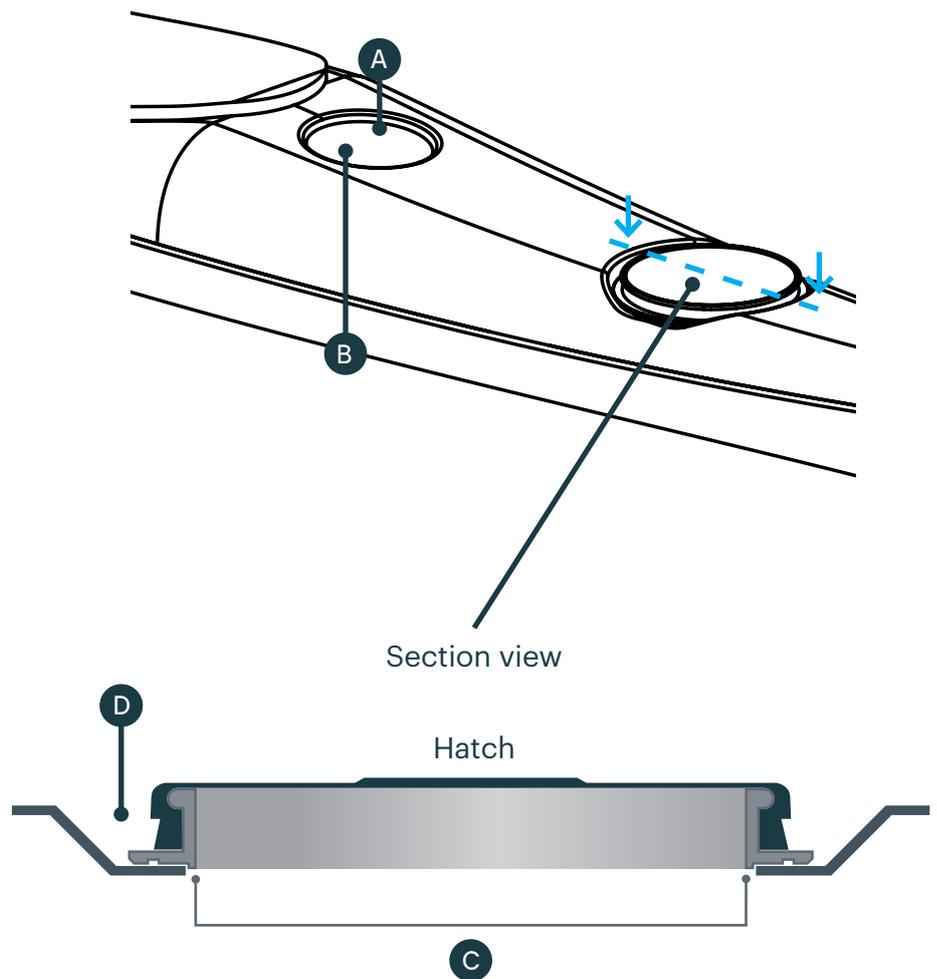
GENERAL INSTALLATION INSTRUCTION FOR
KAJAK SPORT HATCH RIMS



INSTALLATION INSTRUCTIONS

Designing and building a proper recess for hatch rim

- A. Make sure that the kayak platform for hatch rim is properly made (straight & large enough). Platform can be recessed or unrecessed.
- B. Measure the rim on its place and cut the whole to the deck of the kayak. Roughen and clean carefully the gluing surface.
- C. Measure the required hole size from this short vertical flange
- D. Make sure there is enough free space around the hatch rim that the deck won't disturb the usage of the hatch cover. Cover needs to be able to stretch and bend over the rim outer edge. User needs to get good grip with fingers around the cover. Recess needs to have proper emptying channel that water will not stay on the recess.



Attaching KS Hatch Rim to a kayak

There are two optional types of adhesives which you can use attaching the KS Hatch Rim to the kayak. If you use another sealant, please check the manufacturers instructions and make sure the sealant is suitable for ABS-plastic.

Methacrylate glue

Methacrylate glue can be used to attach the rim to the kayak. With this adhesive there is no need to use primer, roughen lightly the rim surface and clean well.

Adhesives: **ACRALOCK SA-10-5 LV** is available in multiple packaging sizes such as small 10 ml (1-2 rims), 50 ml and 490 ml. **SCIGRIP SG300** or **PLEXUS MA420** are also suitable methacrylate glues and you may use similar adhesive from other producers as well.

Sika

Using Sika Primer (e.g. 215 or 290DC) with ABS material is highly recommended to assure perfect bonding with Sika polyurethane adhesive/sealant. Apply primer to a clean ABS rim, wipe once the orange surface of the rim (shown in right). Let the primer dry at least 30 min before gluing but not more than 20 hours.

Use polyurethane adhesive/sealant, e.g. Sikaflex-221 for gluing. Spread the glue to the glueable surface of the kayak deck. Press the rim to its place and let it dry.

To strengthen the joint between the deck and the rim, you can use



rivets (particularly with bigger hatches). These will help the rim to stay in place if kayak needs to be moved on curing time. **Be careful with the rivets in order to prevent the rim from breaking!** Make sure the rim is not budged during the drying.

More information about Sikaflex glues and primers can be found from <http://www.sika.com>

Polyethylene Kayaks

If you install the rim to a PE-kayak, flame the surface of the kayak from the gluing area carefully with a torch to make sure of a better binding of the sealant. It's not recommended to flame the hatch rim at all, it may weaken the structure of ABS material.