

Installation instructions Europe and the rest of the world except the USA and Australasia

Traditional installation



REQUIRED TOOLS

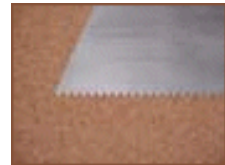
Before you start, check to see you if you have all the required tools.

What you need for the installation of MARINEDECK 2000®

- Pencil
- Tape measure
- Square
- Triangle of 45°
- Stanley knife
- Hand saw and/or jig saw
- Belt sander 16 cm or 6 1/2"
- Sanding paper grit 80 and grit 120.
- Putty knife
- Kit/caulking gun, either hand or electrical
- Glue spreader 3 mm teeth (1/8"). Please see picture A
- Towel
- 10 kilo roller
- Brush
- Plastic gloves
- SIMSON CA or BC
- SIMSON DC
- SIMSON degreaser and primers

For professionals:

- Hand router
- Vertical sanding machine



Picture A



SIMSON BC + CA
(bedding compound + construction adhesive)



SIMSON DC
(deck caulk)
+
SIMSON degreaser and primers Prep P + M

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CAUTION

Preparing the planks before final installation

MARINEDECK 2000® is manufactured of natural cork. Cork is highly homogenous, consisting almost entirely of cellular membranes through which no channels run. The cork tissue is formed from dead cells. Each cork cell consists of a minimal quantity of solid materials and a maximum of gaseous materials, essentially atmospheric air but also containing carbon dioxide. One cubic centimeter contains about 40 million cells. These cells may expand or shrink by high temperatures or low temperatures. MARINEDECK 2000® is produced in an acclimatized environment at 16-18° (60-64°Fahrenheit). It is recommendable to acclimatize the planks before installation, preferably 24 hours, in a constant temperature.

Planks and sheets are available in the following sizes:

Planks

Length : 1880 mm ($\pm 88"$)
 Width : 36 mm ($1\frac{1}{2}"$), 50 mm (2"), 75 mm (3") and 125 mm (5")
 Thickness : 9 mm ($\pm 1/3"$)

Sheets

Length : 1880 mm ($\pm 88"$)
 Width : 500 mm (20") or 420 mm ($16\frac{1}{2}"$)
 Thickness : 9 mm ($\pm 1/3"$) and 6 mm ($1/4"$)

Our advise

In most cases we don't advise to do the traditional installation (by planks) on board of the yacht. Climbing up and down the yacht demands quite some energy. We advise to make templates of all surfaces to enable a remote production of the deck(parts). Please find our extended and clear instructions of the "remote traditional single installation of MARINEDECK 2000®" on the installation instructions below

As easy as it can be.....



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Single off PreFab production and installation



Applying the template on a flat board. All requirements of the principal are applied on the template, such as width of the margin planks and so on.



The installation of the margin planks and the filling in of the planks along the circumferences of the template. Rings and so on are made out of sheet.

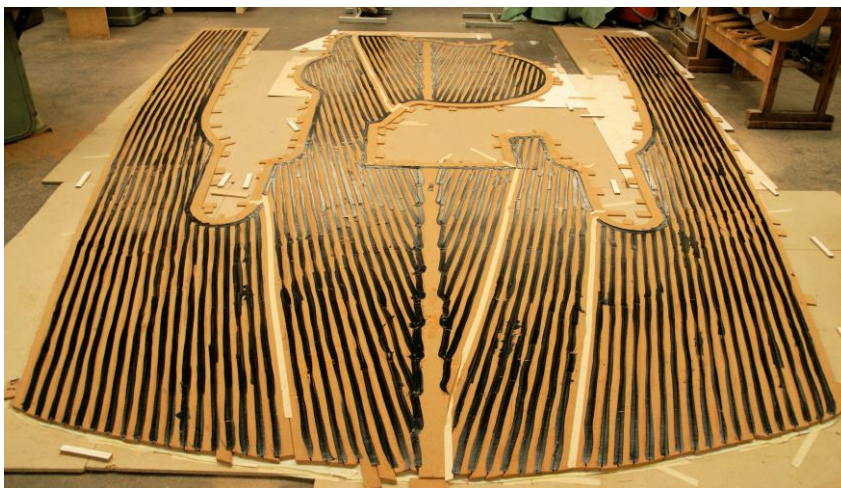


An almost finished single off MARINEDECK® exterior PreFab

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Primering of the seams but only if requested by the manufacturer of the deck caulk. Please carefully read the product instructions. Watch the white tape! Here the PreFab is divided for easier handling and installation on board of the yacht.



A caulked MARINEDECK®**exterior** PreFab



A finished MARINEDECK®**exterior** PreFab. The deck has been carefully sanded by a belt sander with sanding paper grit 80 and 120.

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HOW TO PREPARE DECKS

TO PREPARE DECKS OF GRP (fibre glass)

- Degrease the deck with SIMSON degreaser E, with a saturated cloth.
- Do not sand down non-skid surfaces but clean these surfaces thoroughly with a disposable brush.
- After a half hour apply SIMSON primer Prep M by using a brush. Apply the primer as thin as possible by spreading the primer with the brush
- Let the primer cure for about 10 minutes (but no longer than 24 hrs.).

You now have the right surface to continue the installation on fibreglass.

TO PREPARE METAL DECKS

- Check the surface for corrosion and damages to the coating.
- Now sand off all corrosion and damages to the coating.
- If the deck is not flat, the deck needs to be levelled with for instance an epoxy putty.
- Now clean the whole surface with SIMSON degreaser E, with a saturated cloth.
- After a half hour apply the SIMSON primer Prep M by a brush. Apply the primer as thin as possible.
- Let the primer cure for about 10 minutes (but no longer than 24 hrs.).

You now have the right surface to continue the installation on metal

TO PREPARE WOODEN DECKS

- Make sure the deck is fair MARINEDECK 2000® planks are flexible and follow the surface below.
- In case the deck is not flat, the deck needs to be levelled with fairing compound.
- Now proceed to clean the entire deck with SIMSON degreaser E, with a saturated cloth.
- After a half hour apply the SIMSON primer Prep P (for porous surfaces) with a disposable brush, as thin as possible
- Let the primer cure for about one hour (but no longer than 24 hours)

You now have the right surface to continue with the installation on wood.

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THE INSTALLATION OF MARINEDECK® exterior PLANKS

Important remark:

The differences in working temperature of one day and the next day might change the lengths of the individual planks slightly. Please take your precautions (see page 2) when preparing the individual planks. At the moment the planks are bonded at the deck, this phenomenon has no effect any longer.

Picture 1: Prepare the margin planks for each surface accurately. Make sure the mitre joints are equal to the seams in the MARINEDECK 2000® planks, or use the binder to create invisible joints.



Picture 1

Now apply the SIMSON BC or CA adhesive with the spreader. Only apply adhesive to the surface covering the width of the plank(s).

Install the MARINEDECK 2000® planks by rolling them down to push the air out from underneath the plank(s).

Now put some weights on the margin planks in order to keep the margin planks in the right shape (in case of a curved installation). You could use bottles filled with water or other weights. Now wait for about 8 hours before you continue.

Picture 2: Now prepare the rest of the planks

Prepare the whole rest of the surface without bonding the planks. Always work from the outside to the centre. One right and one left towards the visual centre of the craft.



Picture 2

By installing from the outside to the centre, always one right and one left, you will end up at the visual centre. You can hide the non-symmetrical centre of the craft by working on this way.

Finally you will end up in the centre of your craft or deck surface with a space larger than a plank but smaller than 125 mm.



Picture 3: Make sure the seam at both sides will be 4 mm. You can also mill the seams. It is no problem at all when the seam goes right through to the deck. In this case always use 4 mm wooden spacers

Picture 3

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Picture 4: Now your MARINEDECK 2000® has been installed without adhesive, you can remove all planks from the centre after you have numbered each individual plank: right 1, 2 and so on and left 1, 2 and so on.



Picture 4



picture 5

Picture 5: You can pile the planks right and left of the deck surface(s) so that the plank furthest to the left is at the top of the left pile and the plank furthest to the right is at the top of the right pile. This makes life much easier when bringing them back to the right place when bonding

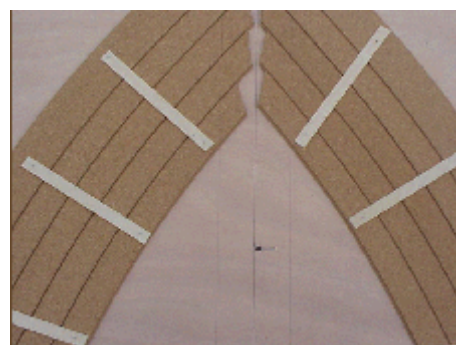
HOW TO MAKE A FISHING / KING PLANK

Important remark:

The differences between the working temperature of one day and the next might change the lengths of the individual planks slightly. Please take your precautions when preparing the individual planks. At the moment the planks are bonded on the deck this phenomenon has no effect

Prepare the margin planks for each surface (see installation in general)

Picture 6: Bring all planks back at their correct position as the picture shows. Always work from the outside to the centre. One right and one left. Force the planks into their right shape.



picture 6

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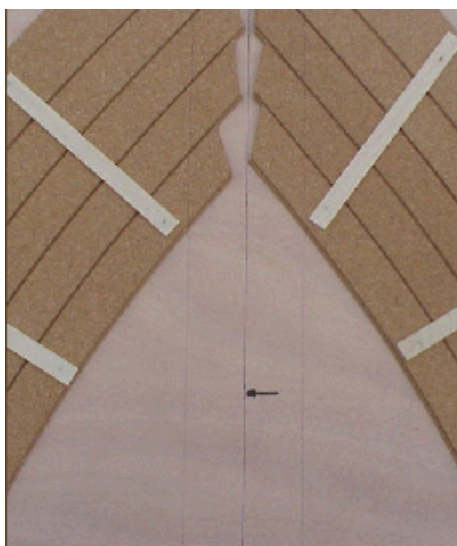


Picture 7: To achieve this, nail one, two or more thin planks at the margin plank to the centre side of the surface or craft.

Now force the first plank exactly up against the margin plank. Now apply a nail into the seam of the MARINEDECK 2000® plank. Repeat this at more places if required. Always make sure that the complete length is exactly up against the margin plank or another plank. Repeat this with all other planks.

Picture 7

Always make sure that the complete length is exactly up against the margin plank or another plank. Repeat this with all other planks. Mark the planks left 1 till...and right 1 till...



Picture 8: When reaching the centre of the surface of the craft, draw a straight line at the centre for the complete length of the surface.

Picture 9: Now take a king plank or fish plank and mark the exact middle of this plank at both ends.



Picture 8

Picture 9

Picture 10: Put the middle of the plank at the line you have drawn at the centre of the surface of the craft.

Now draw a line with a pencil along both sides of the king plank.



Picture 10

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Picture 11: Also draw a line with a pencil from plank to plank across the king plank.

Picture 11

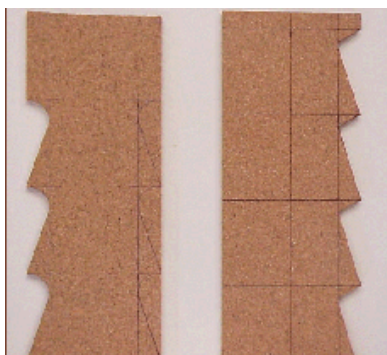
Picture 12 + 13: Now place a radius pattern of 25 mm (1") at the intersections you just have drawn. Proceed drawing a line from the place the radius line hits the vertical line to the horizontal line below. You also might prefer square teeth like the above picture 13 at the right is showing.



Picture 12



Picture 13



Picture 14



Picture 15

Picture 14 + 15: Now cut and / or sand and / or saw the radius into the king plank. A fishing or a king plank can have different shapes. The picture shows two most used types of fishing or king plank.

After you have finished shaping the king plank, put it back into position. Make sure the intersections and the middle lines at the fishing plank and the deck are corresponding again. Now draw the teeth from the king plank on to the planks underneath.

Now cut and sand the plank ends into the right form or shape. Then mill the seams of 4 x 4 mm into the planks ends using a router with a distance holder. If you don't own a router, just simply make the planks 4 mm smaller on the inside.

When all planks are prepared, number the planks (left) 1, 2, 3 and so on and (right) 1, 2, 3 and so on. By stacking the planks into the correct order, it will make things easier when gluing.

BUTT JOINTS

How to make butt joints?

We recommend two ways to make butt joints:

1. A traditional 4 mm black caulking seam at the end of each plank or joint.
2. The use of MARINEDECK 2000® binder to make matching butt joints.

Ad. 1

Make sure the seam between the two planks is exactly 4 mm (1/6").

To guarantee a 4mm (1/6") seam, use a 4mm (1/6") spacer between planks.

Fill with caulking to the bottom of the seam (deck surface).

Before caulking, please go to the chapter about caulking on this web site.

Ad. 2

Prepare a small volume of binder (A+B components). The correct amount (weight) of binder (A) and catalyst hardener (B) is specified on the pack. Mix the A and B component properly. Always exactly prepare the binder in accordance to the ratio at the pack. Stir each component thoroughly before mixing together. Mix the exact volume together and stir the blend thoroughly.

Proceed dipping the ends of the planks into the prepared blend or apply the blend with a brush.

Now push both ends firmly together till the binder between both planks comes up. Now make sure both ends cannot move by nailing a strip of plywood to connect both planks.

Let the binder cure properly (48 hours) before removing plywood strips. Sand the excess binder off when finishing the entire deck (after caulking). In areas with extreme high UV radiation (sunlight) like for instance Florida and Australia, butt joints may require some maintenance. This involves mixing some binder and brushing into joint, then sanding off excess binder when cured.

The binder to make butt joints, as being prescribed above, is made of natural cork granules and a high-end synthetic material. The cork granules are added to help protect against UV radiation and reducing UV damage on the surface.

The maintenance of the butt joints is easy. Just fill the small gaps with the binder and sand it down again to the level of the deck after curing. The colour of the butt joint will match the colour of the deck after a few weeks of exposure to direct sunlight.

The binder is specifically excluded from any warranty.

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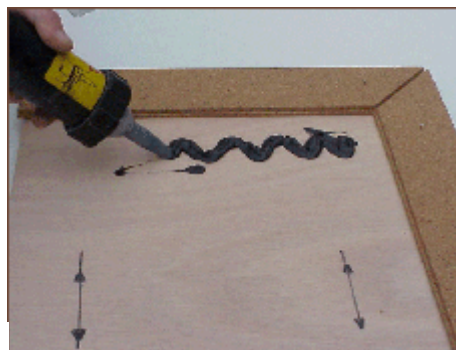
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HOW TO APPLY THE ADHESIVE AND MARINEDECK 2000® PLANKS

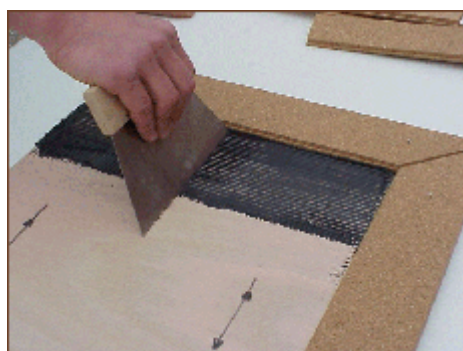
Before starting, carefully read the instructions and information at the concerning product data sheet.

Picture 16: All margin planks are considered to be installed. Place the SIMSON CA or BC cartridge into your kit gun. Cut off the nozzle to obtain an opening of 6mm or ¼". By pulling the trigger you will push the adhesive out of the cartridge.

Now apply the adhesive to the primed surface.



Picture 16



Picture 17

Picture 17: Spread the SIMSON CA or SIMSON BC adhesive with the spreader supplied.

Always apply one or two planks left and then one or 2 planks right.

Apply the planks by pushing out the air in front of you. Attach the planks by pushing them firmly to the surface below.

Force the bended planks into the right form or shape as described above (fishing / king planks). Continue till the whole surface or craft has been finished.

Now wait for about 16 hours before you continue working on the same surface.

TO APPLY THE DECK CAULK

Picture 18: Remove all dust and possible dirt from the seams. Apply the SIMSON primer Prep P into the seams by using a brush.



Picture 18

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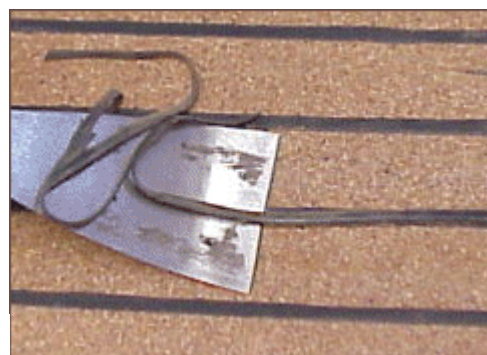


Picture 19

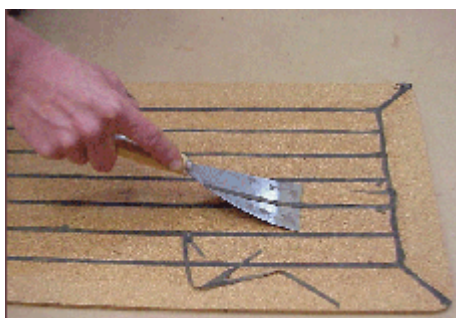
Picture 19: Place the SIMSON DC (deck caulk) cartridge into your kit gun. Now cut the nozzle till you have an opening of about 6 mm or a ¼ inch. By pulling the trigger you will push the caulking out of the cartridge. Now lay the nozzle into the seam and repeat, pulling the nozzle through the seam. Also make sure there is a sufficient volume of deck caulk in the seam to fill the seam completely. Avoid air bubbles.

FINISHING THE MARINEDECK 2000®

Picture 20: Take a putty knife. Place the putty knife flat on top of a seam and make a start.



Picture 20



Picture 21

Picture 21: Remove all excess deck caulk that is above the planks by cutting the caulk down to the MARINEDECK® exterior level.

Picture 22: Now sand the entire deck by an oscillating sanding machine with grit 80 sanding paper. When using a belt sander, be very careful.



Picture 22

Congratulations with your new MARINEDECK® exterior. You have finished the installation.

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NO COATING REQUIRED.

Do not coat MARINEDECK 2000®

Some brief advantages of uncoated MARINEDECK 2000®

- does not take the outside temperature.
- no maintenance required
- much better non-skid properties
- easy to clean with water and soap
- does not age
- does not absorb any liquid

Please feel free to contact us any time when there would be any question left:
info@stazo.nl



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