

Sika Procedure for PLXL-M Roof

ZERO SILICONE to be used ON ROOF OF 2016 PLXL-M, ALL DEPARTMENTS

MUST USE SKIA ACTIVATOR ON ALL SURFACES, INCLUDING PLUMBING STACK VENTS & AWNING WIRE, use Sika 521 UV on these parts & Surfaces. This applies to all types of sealants and adhesives used

PREPPING FIBERGLASS PAINTED ROOF

- Position shower skylight bubble in place, mask off area around perimeter of skylight bubble, pre drill holes through roof.
- Clean surface using 208 Sika Remover. Always use a new clean rag for every swipe, never reuse rag. 1 swipe then throw away or find a new unused portion. Allow to flash off for 10 Mins before proceeding
- Rough up surface of roof using Red Scotch-Brite, blow off dust & wipe with clean dry rag. Apply Sika Activator using a clean rag, let Sika Activator sit for minimum 10 minutes and maximum 6 hours.

PREPPING OF SKYLIGHT BUBBLE

This process needs to be completed on BOTH sides of the flange on the Skylight bubble.

- Clean flange surface using Sika Glass Cleaner.
- Apply Sika Activator using a clean rag, let Sika Activator sit for minimum 10 minutes and maximum 6 hours.
- Shake 209N primer can thoroughly and apply Sika 209N using a clean foam brush applying in one direction. Do not brush back and forth. Flash Time is 15 mins and max 2 hrs. Primer should not be wet or stringy when touched with finger and pulled away. If so it must be allowed to flash longer. Dispose of unused 209N and do not return unused 209N to the can.
 - If Skylight bubble is installed **before 2 hr flash time is reached then Sika Activator is not required.**
 - If Skylight bubble is installed **AFTER 2 hr flash time has expired then Sika Activator is required, then let Sika Activator sit for minimum 10 minutes.**

PREPPING FIBERGLASS TRIM RING

- Clean surface using 208 Sika Remover. Always use a new clean rag for every swipe, never reuse rag. 1 swipe then throw away or find a new unused portion.

- Apply Sika Activator wiping in one direction with a clean lint free rag and let flash a minimum of 10 mins

- Shake 206 G+P primer can thoroughly and apply Sika 206 G+P using a clean foam brush applying in one direction. Do not brush back and forth. Flash time is 15 mins and max 2 hrs. Primer should not be wet or stringy when touched with finger and pulled away. If so it must be allowed to flash longer. Dispose of unused 206 G+P and do not return unused 206 G+N to the can.
- If Fiberglass Trim Ring is installed **before 2 hr flash time is reached** then Sika Activator is not required.
- If Fiberglass Trim Ring is installed **AFTER 2 hr flash time has expired** then Sika Activator is required, then let Sika Activator sit for minimum 10 minutes.

INSTALLATION OF SKYLIGHT BUBBLE

- Apply Sika Spacer Tape to bottom side of Skylight bubble around inner perimeter.
- Inject Sika 221 into every pre drilled hole on the fiberglass roof for the skylight bubble.
- Apply a bead of Sika 221 on the row of predrilled holes, **Use Notched applicator tip.**
- Fasten skylight bubble using "Wafer Head "screws. Do not overtighten.

INSTALLATION OF FIBERGLASS TRIM RING

- Clean clear area of skylight bubble that does not have 209N applied with Sika Glass Cleaner and inspect for damage prior to installation.
- Activate any 209N or 206 G+P that has dried more than 2 hours with Sika Activator and let flash for 15 Mins.
- Install Fiberglass Trim Ring using Sika 221. Hold down to roof with tape.

****WAIT 24HRS before next step****

- Remove tape that is holding down the Fiberglass Trim Ring
- Apply Sika Activator using a clean rag, let Sika Activator sit for minimum 10 minutes.
- Apply a "Finishing Bead" around the Fiberglass Trim Ring to the Roof using 521 UV

****WAIT 24HRS before next step****

- Wipe area to be sealed with Activator and allow to flash for 10 mins.
- Apply "Finishing Bead" around inside edge of Fiberglass Trim Ring to the Skylight Bubble using Sikasil-N Plus

Installation Timing

- Skylight Bubble to be installed on "Installer Day 1".
 - This allows 24hrs minimum until the shower Corian is installed (using silicone).
 - "Installer Day 2" = cure time for shower Corian.
- Fiberglass Trim Ring to be installed on "Installer Day 3".
 - This allows enough time for the Sika 221 to cure before the unit is on the Finish Line. The Finish Line is when the "Finishing Bead" around the Fiberglass Trim Ring to the Roof using 521 UV should be applied.