



# Bonding and caulking of teak decks

APPLICATION MANUAL



# Teak, resistant to all weather types

It has been tried and proven many times: the worse the conditions, the more important the quality of the marine adhesives and sealing products becomes. Everywhere ship builders and yacht builders agree. Therefore they choose the sustainable features of the Simson Marine Special Range (MSR).

Another major reason is the technical support offered by Bostik's nautical specialists. They know all about the specific problems involved in building and owning yachts and ships. They are familiar with all current safety requirements. When you choose for Simson MSR products, you also have access to this extensive Bostik know-how and experience.



**ONLY HIGH QUALITY TEAK PLANKS SHOULD BE USED FOR BONDING TEAK DECKS**



**A DARK BROWN TEAK DECK IS NOT ONLY BEAUTIFUL, IT IS ALSO EXTREMELY DURABLE**



### INTERESTING INFORMATION ON TEAK

Teak is the wood from the 4 species of teak trees, which are scattered mainly over South East Asia. However, teak nowadays is cultivated on plantations in many tropical regions. The full-grown teak trees reach an impressive height of up to 40 metres. Also their elliptically shaped leaves with a length of 50 cm are very impressive. Teak is mainly appreciated for its extraordinary resistance to wind and weather, properties which are of high importance in ship- and yacht building. It can even resist attacks from termites. People also appreciate the golden-brown colour which varies from light to dark tones. Being used for more than 2000 years in the ship- and yacht building, teak decks maintain their exclusive splendour even today. Under dry as well as wet conditions, teak guarantees anti slip properties and protects the subdeck underneath against weather influences and thus provides a lasting deck surface. However, the main arguments for use in marine applications are found in its exclusivity and functionality. With the construction of a teak deck the particular properties of teak must be considered. Like many other tropical woods, teak contains lots of oil depending on the origin and the age of the wood. Storage conditions like relative humidity and temperature and the age of the individual teak planks affect the content of oil and water in the wood.

This application manual will be of help in the construction process of a high-quality teak deck. A detailed planning as well as a conscientious and skilled realisation regarding the instructions have to be put first in order to obtain an optimal result.

### GENERAL CONDITIONS

Working in the right conditions during bonding and sealing of a teak deck is a basic requirement for a good result. The air temperature must be between +5°C and +35°C.

During the bonding and sealing of the teak planks the relative humidity should be between 40% and 75%. Working indoors or in conditioned areas gives more certainty of the quality than working outdoors. During the construction and the curing process of adhesives and sealants the deck has to be protected against direct sun light and rain, otherwise uncontrollable effects on the teakwood or the adhesives and sealants can occur.

### WOOD QUALITY

Only teak planks with standing (radial) year rings should be used. The humidity of the core of the wood must be between 9% and 12%. When the humidity level in the wood is too high during construction of the teak deck, drying of the wood later on will lead to shrinkage of the wood and subsequent permanent deformation of the sealants and adhesives. This will negatively affect the durability of the teak deck and should therefore be avoided. Ideally, the humidity of the wood during the construction of the deck should be equivalent to the humidity of the wood in service.

### CHOICE OF CAULKING

Bostik provides 2 technologies for deck caulking; **MSR Deck Caulk Advanced** which is a SMP based deck caulk and **MSR Deck Caulk S** which is a Silicone based deck caulk. Both products are specially developed for deck caulking and can withstand the harsh climate conditions a deck will face in its lifecycle. Each technology has its own advantages. For example MSR DC Advanced is fast curing and MSR Deck Caulk S can be applied without primer. The choice of the best technology is depending on its situation. The Bostik representatives are available to show the benefits of both technologies and find the solution for the best result.

# Teak deck bonding



Teak planks are supplied in different profile types e.g. T-profiles and L-profiles (see drawing above). The T-shaped profile with separation of the strokes in the middle is preferred over the L-shaped profile. Movements due to thermal and environmental conditions will be compensated optimally by Simson MSR Deck Caulk Advanced or Simson MSR Deck Caulk S.

## PREPARATION OF THE SUBSTRATES

### New GRP-decks

- All bonding areas have to be cleaned with Simson Cleaner I or Simson Cleaner E.
- Apply Simson Prep M to the substrate with a clean, colour- and lintfree cloth or tissue paper. Drying time: minimum 5 minutes, maximum 6 hours.

### Old GRP-decks

- Remove all old construction layers on the GRP-deck and clean with Simson Cleaner I or Simson Cleaner E.
- The total substrate has to be lightly sanded with a 80-grade or 100-grade sandpaper.
- The total substrate must be vacuumed thoroughly with a high-capacity vacuum cleaner, to remove dust particles that negatively affect adhesion.
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- Apply Prep M to the substrate with a clean, colour- and lintfree cloth or tissue paper. Drying time: minimum 5 minutes, maximum 6 hours.

### Wooden decks

All wooden substrates that will be in contact with adhesive and sealant, should be pretreated with Simson Prep P.

Apply Prep P with a suitable roller or brush in a thin but continuously closed coat. Drying time: minimum 1 hour, maximum 6 hours. Old surfaces have to be sanded first with a 80-grade or 100-grade sandpaper and must be vacuumed thoroughly with a high-capacity vacuum cleaner.

### Steel- and aluminium decks

There are many different surface coatings and surface levellers available for use on steel and aluminium decks. Because of this large variety of products, it is not possible to give a general recommendation for the application. We recommend to perform tests on adhesion and durability with our products on the concerning surface material or to contact Bostik.

## BONDING OF TEAK PLANKS

Apply Simson MSR Bedding Compound on the pretreated deck surface and spread with a spatula (5x6 mm teeth). The projected usage is approximately 1500-2000 ml/m<sup>2</sup>, depending on the height differences of the deck. The Bedding Compound should be applied over the full deck area, in order to protect the deck from moisture ingress. Do not apply more adhesive than can be handled within the skin forming time of the product. Apply Simson Prep P to the surfaces of the teak planks that have to be bonded (allow the Prep P to dry), place them in the adhesive and apply light pressure to make sure that the teak surface is wetted completely with the Bedding Compound. Fixate the teak planks by using clamping tools, dead weights or screws for at least 24 hours. After 24 hours the fixing devices can be removed and the surfaces can be loaded lightly, full loading is possible after 48 hours. Residues of uncured adhesive can be removed with Simson Liquid 1. Removal of cured adhesive should be done by mechanical means.



## CAULKING OF THE DECK

Durable seams can only be obtained when using the right seam dimensions. For reference in the following table, appropriate seam dimensions are given for different plank widths. The minimum seam dimensions ensure that the possible strains are within a reasonable range when the temperature and/or the humidity level in the wood changes. Contact Bostik in cases where the geometry differs from the values mentioned.

To obtain a good and durable adhesion of Simson MSR Deck Caulk Advanced or Simson MSR Deck Caulk S, proper pretreatment of the teak seams is necessary.

## CAULKING WITH MSR DECK CAULK ADVANCED

### PRE-TREATMENT

- Remove old sealant and other remaining material completely.
- The seams must be clean, dry and dust free. Do not clean with compressed air, because this can contain oil. Instead, use an industrial vacuum cleaner.
- Use Simson Cleaner E to clean the teak.
- Apply Simson Prep P to the seam sides with a brush. A continuously, thin layer is obtained by striking the brush several times in the seam (see picture). Drying time: minimum 30 minutes, maximum 24 hours.
- The temperature should be between +5°C and +35°C, maximum relative humidity is 75%.
- It has to be noted that the surfaces should be primed once.
- A teak deck will shrink and expand due to the changing environmental conditions. The deck caulk will accommodate to these movements without loss of adhesion on the seam sides.

When the teak planks has a thickness of more than 10 mm it is advised to use bond breaker tape, which is applied on the bottom of the seam (after drying of the pretreatment), to prevent three-side adhesion in the seam.

### CAULKING

- During the caulking procedure the deck should be protected from direct sunlight and rain. The temperature should be between +5°C and +35°C, relative humidity between 40% and 75%.
- Cut the nozzle to the width of the seam.
- The seams must be filled from the bottom to the top, to prevent air voids to be included in the seam. The nozzle is placed on the seam bottom, the gun is held at an angle of 60° to 80°. Pull the nozzle at a constant speed through the seam and apply the deck caulk with a 10% to 20% surplus.

- Immediately after applying the deck caulk, or at least before skin forming, the deck caulk must be pressed onto the seam with a spatula.
- After 2 to 7 days (depending on temperature and relative humidity), the deck caulk can be sanded.

## JOINT GEOMETRY

Teak plank width (mm)	Minimum seam width (mm)	Minimum seam depth (mm)
35	4	6
45	4	6
60	5	6
90	6	7
95	6	8
120	16	10

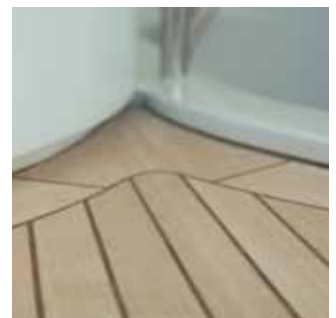
## CAULKING WITH MSR DECK CAULK S

### PRE-TREATMENT

- Remove old sealant and other remaining material completely.
- The seams must be clean, dry and dust free. Do not clean with compressed air, because this can contain oil. Instead, use an industrial vacuum cleaner.
- Use Simson Cleaner E to clean the teak.  
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- Immediately after applying the deck caulk, or at least before skin forming, the deck caulk must be pressed onto the seam with a spatula.
- After 4 to 7 days (depending on temperature and relative humidity), the deck caulk can be sanded.



### SANDING OF THE TEAK DECK

Prior to sanding, remove the excess deck caulk with a chisel to avoid a high load on the seam sides during the sanding operation.

Sand the deck in at least two steps, first with a 80 grain sandpaper in parallel direction of the seams. The second step should be done with at least 120 grain sand paper.

### FINAL TREATMENT OF THE TEAK DECK

Usually, no treatment is necessary or recommended after the sanding operation. For optical reasons, after-treatment is being applied more and more. No recommendation can be given on this matter, because of the large number of available lacquer and varnish systems. We advise a thorough investigation before applying any after-treatment. Never apply such a treatment before the deck caulk has cured completely. In general, lacquer and varnish systems affect the elasticity of the seams (consult Bostik). Consult Bostik for further information.



**A PERFECT DURABLE TEAK DECK WILL BE OBTAINED IF...**



**...THE INSTRUCTIONS ARE FOLLOWED PROPERLY**

# Maintaining teak decks

## CLEANING TEAK DECKS DURING SERVICE LIFE

Bostik recommends the following to clean and maintain your teak deck and Simson MSR Deck Caulk Advanced:

To keep teak decks healthy, give them a weekly washdown and flush them regularly with clean salt water. Salt water is a natural bleaching agent in conjunction with sun. Salt water also leaves a fine salt deposit, which will absorb moisture out of air and prevents the wood from drying out. It also reduces mildew, mould and algae growth. Fresh water is better than none, wet or damp teak resists checking and cracking because it does not shrink or swell as much.

Due to the good chemical resistance of the MSR Deck Caulk Advanced, teak cleaners with a pH between 6-8 can also be used. Scrub in circular or across the grain motion. Try to minimise scrubbing as it can take the soft grain of teak away. Allow teak to fade to its natural gray-silver colour and let its natural oil take care of the algae growth.

## NEVER DO OR APPLY THE FOLLOWING

Never use stiff bristle brushes for scrubbing.

Never pressure wash the deck: it will remove the soft grain and raise the grain.

Never use household detergents like ammonia, bleach, Tri-Sodium-Phosphate (TSP) and vinegar to clean, remove stains nor bleach your deck. All these products may cause irreversible damage to the seam compound /deck caulk, the teak wood and other materials on the boat.

Never use 2-component cleaners and brighteners. The majority of these heavy-duty 2-component systems are alkaline-acid combining a very strong alkaline solution (chlorine bleach, potassium and sodium hydroxides) and a very strong acid (oxalic, sulfuric or phosphoric acid), in liquid or crystal form to be diluted. These 2-component chemicals corrode, soften and damage the seam compound/deck caulk. These cleaners will also eat away the light coloured soft grain of the teak, leaving rough grooves of the darker

coloured grain on the deck. Then premature sanding is the only option to repair the deck. These chemicals also remove the protective natural teak oil, which tends to concentrate at the wood's surface, thereby making the teak much more susceptible to damages. These cleaners also harm the surrounding and attached hardware like the fiberglass polyester (they harm the gel coat), anodised aluminium, chrome fittings, paint and varnishes especially if any residue is left on the deck. These chemicals are also hazardous for you and the environment.

1-Component cleaners on the market are much gentler, but most of them are still corrosive chemicals (some of them contain oxalic acid), which will damage your teak wood and deck seams. If you want to use one of these products for oil spots or food spots contact Bostik for proper recommendation.

Never use oil on your deck, because the teak itself already contains a natural (teak) oil which provides durability to the wood. Synthetic and organic oils (tung oil, wood oil) are sold as teak oils to oil your teak. If your deck is properly maintained as described above, your deck does not need to be oiled. These oils tend to permeate and stain porous gel coat as well.

All information and recommendations in this application manual are based on thorough investigation and actual experience and are without engagement. Although the documentation is set up with the most carefulness, we can not take any responsibility for mistakes, inaccuracies or printing errors.

Because the application of the described products (regarding design as well as production) is completely beyond the control of Bostik, no responsibility for carried out works can be accepted. If any additional technical information should be needed, contact Bostik for professional advice.



## Download Bostik's Marine app!

### THE APP INCLUDES:

- Instruction videos
- Supporting documentation
- Calculation tool
- Dealer locator



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Please contact your local  
Bostik representative for  
more information or to  
arrange trials.

**Bostik SA**

253, avenue du Président Wilson  
93211 La Plaine Saint-Denis Cedex

France

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[www.bostik.com](http://www.bostik.com)

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