

TRACK MOUNT – SIKA FLEX 252

APPLICATION INSTRUCTIONS

Sikaflex 252 Adhesive Sealant is an elastic 1- component polyurethane adhesive especially designed for bonding large components in the vehicle assembly industry.

- It is suitable for bonding a large variety of substrates, coated Metal, Aluminium, Ceramic materials, and Plastics.
- Capable of withstanding high dynamic stresses.
- Has good gap filling properties.
- Tensile strength of 3MPa.

Sikaflex 252 Adhesive Sealant has been used, proved, and tested by Tracklander for over 40 years and is recommended to bond and seal Aluminium Moulded Tracks to Vehicle Roof Tops. The Tracks are used to mount a variety of Roof Racks, Roof Bars and Accessories to Passenger, Commercial and 4WD Vehicles that don't have conventional Rain Gutters or specific Roof Mounting Points.

Please follow the preparation and Sikaflex Application Instructions below:

1



- Mark and Drill holes as specified by Track Mount Fitting Instructions.
- Apply Zinc Primer to all drill holes.

2



- Pour Sika Remover-208 (also used as a cleaner) on to a clean cloth or Paper Towel.
- Never dip the Cloth or Paper Towel into the Sika Remover container, as it may contaminate the contents!

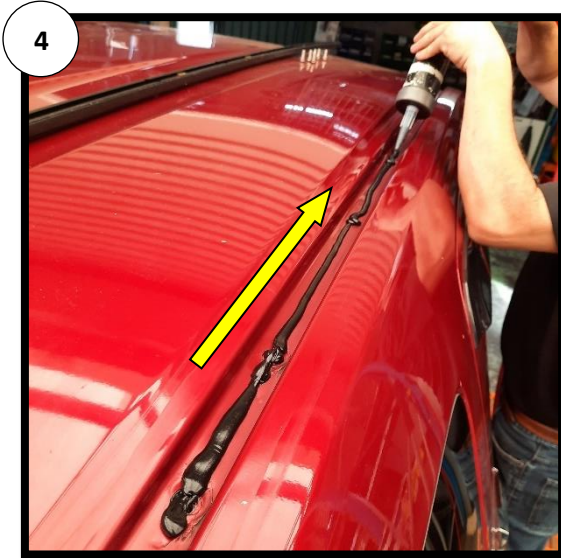
3



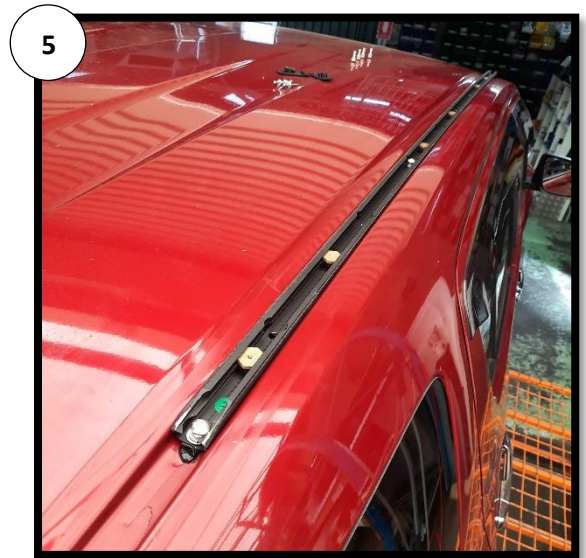
- Wipe the surface with the wetted cloth in one direction only.
- With a fresh side of the wetted cloth, wipe again to thoroughly clean the surface.
- **NOTE: Wipe the surface in the same direction both times, to remove all contaminants.**
- Before the solvent dries on the surface (evaporates), wipe it off with a clean, dry, lint-free paper towel.
- Repeat the last two steps, until no contaminants show up on the white paper towel.
- Tightly reseal container immediately after use.

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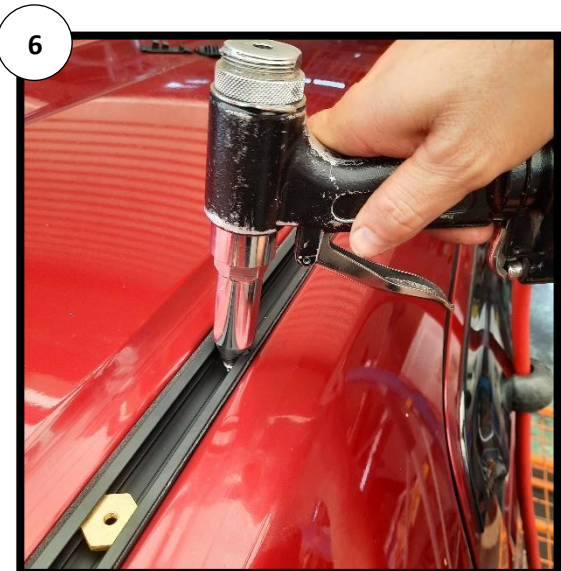
APPLICATION INSTRUCTIONS



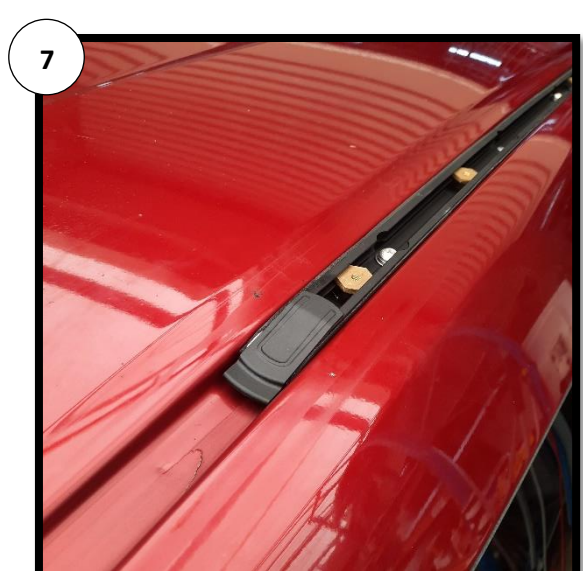
- Starting at one end, apply a thin bead of Sikaflex Sealant (approx. 5mm wide x 5mm high) along the whole length of track area.
- **NOTE: Make sure Sikaflex, covers the drill holes.**



- **NOTE: Before Track is fitted make sure the bottom side of Track is clean. Remove any Foam Tape or Adhesive.**
- Sikaflex must bond to hard and stable surfaces for maximum strength.
- Wipe the bottom side of the Track clean, with Sika Remover-208 (the same process as Step 3.)
- Place Track in position and fit Rivets to all holes.



- Fit End Caps and Threaded Plates into Track.
- Fasten all Rivets, starting from the centre of Track and work your way towards each end.



- Remove any excess Sikaflex Sealant with a Cloth or Paper Towel moistened with Sika Remover-208.
- Allow 48 Hours for 2mm thick Sikaflex at 23°C, to fully cure.
- Full Cure will take longer in cooler temperature.