



Keel Installation



Step 1 – Preparing the top surface

- Sand the top surface of the keel untill you reach clean, unoxidised metal
- If rust enters bolt holes during transport clean by re-tapping the thread
- Wipe away any dust or grease using Acetone
- Insert keel bolts and hand tighten
- Tape sides of keel for easy cleanup



Step 2 – Prop the keel upright and mark the centerline

- Mark out centerline of keel using a felt pen and laser line, keel must be perfectly upright



Step 3 – Prepare hull

- Sand the hull where the keel will be mounted, clean dust away with Acetone

Before



After



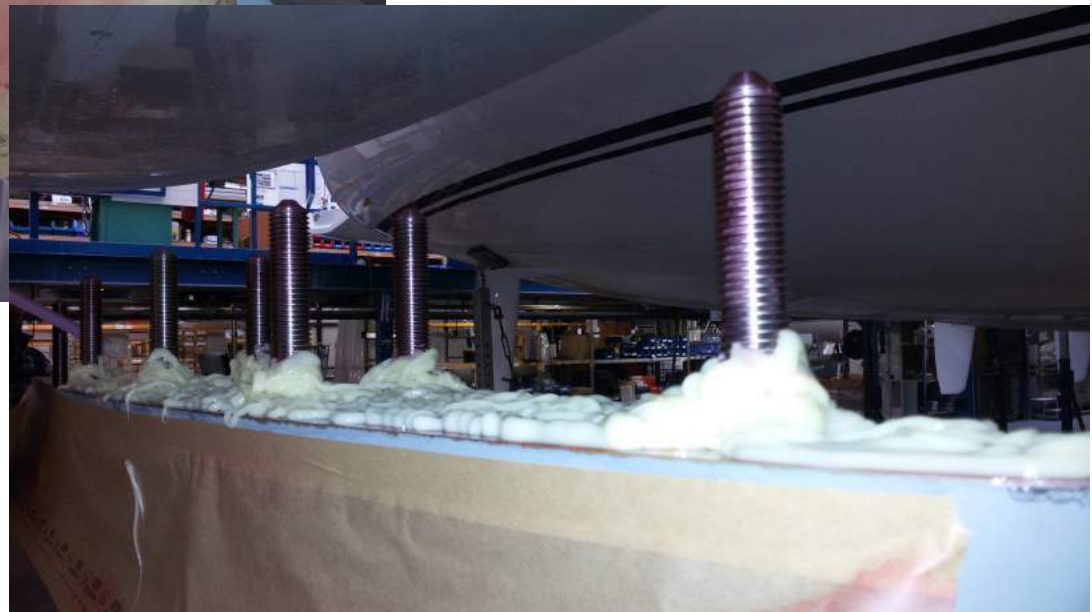
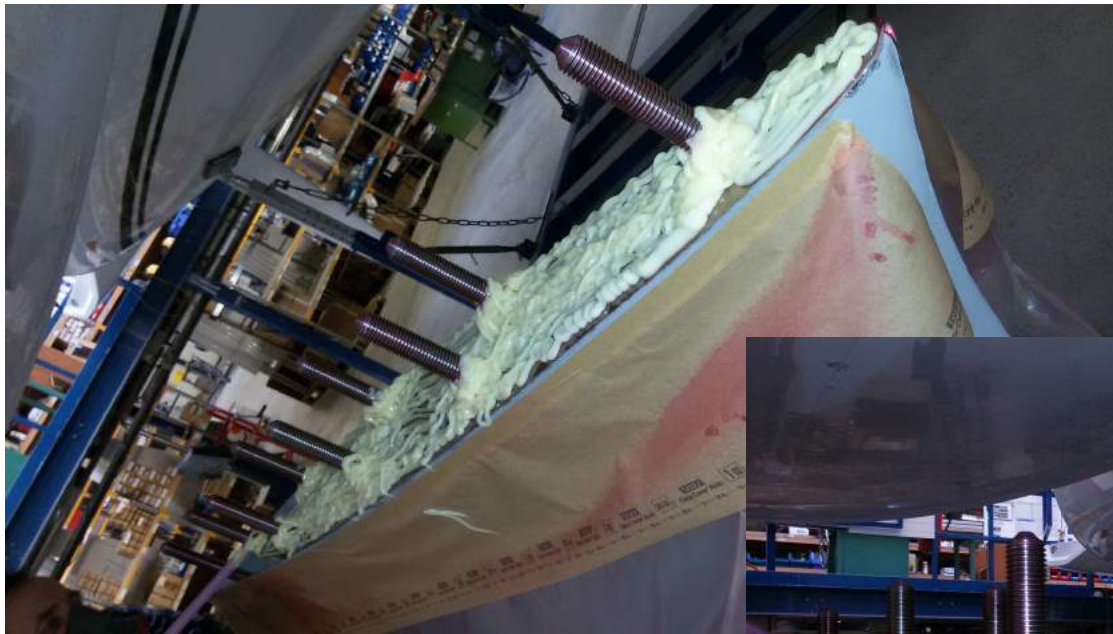
Step 4 – Prime surface of keel

- Using Plexus PC 120 primer, spray the surface of the keel
- Working time is 30 minutes. Re-apply if left longer than this



Step 5 – Apply Plexus glue to keel

- Apply glue liberally to the keel surface. Raise glue around bolts, ensuring a watertight seal



Step 6 – Hull and keel marriage

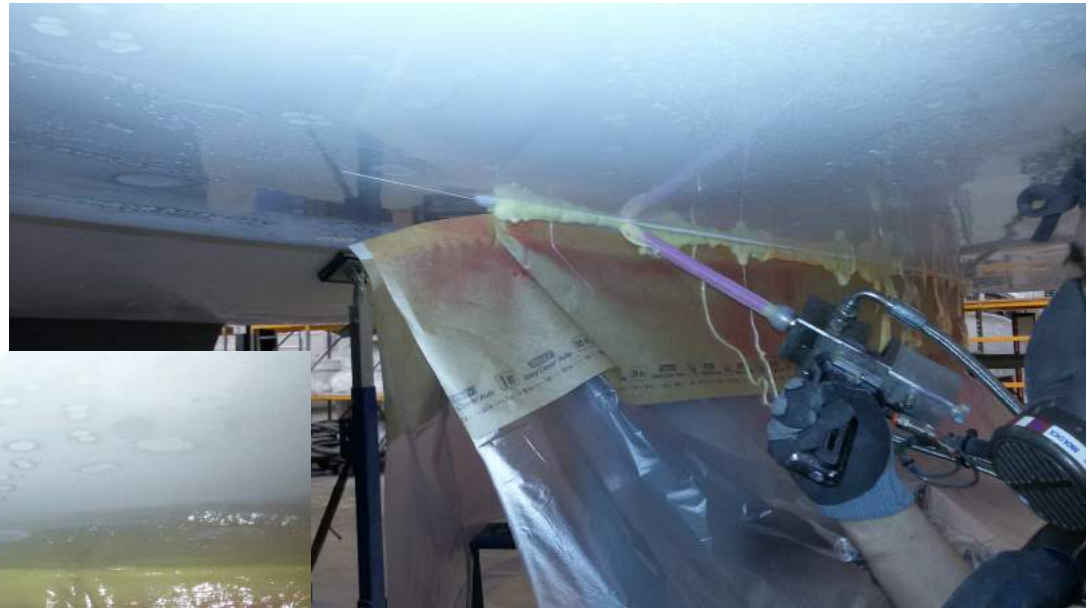
- Lower the hull onto the keel
- Using the laser line, check the proper alignment of hull and keel

Note: reference points marked in red



Step 7 – Finalise gluing process

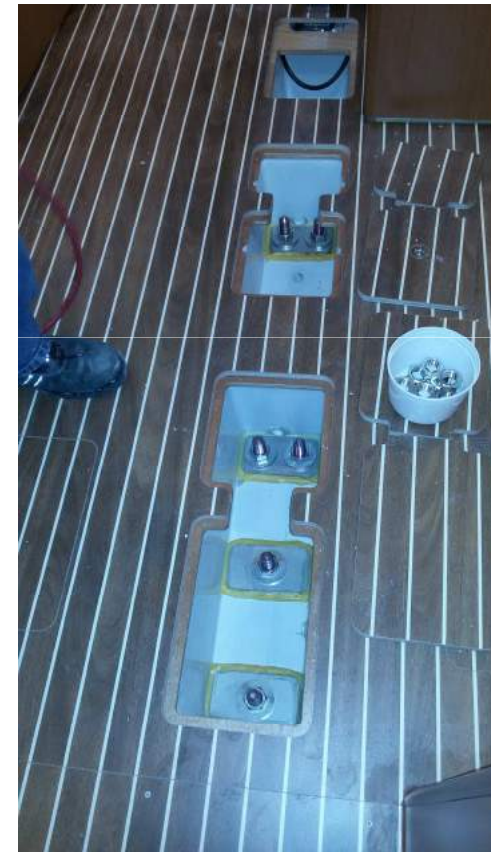
- Apply glue once more around the keel, filling in any gaps
- Clean up excess glue with a rubber spachelor



Step 7 – Finalise gluing process cont.

- Apply glue inside surrounding keel bolt holes and fit all internal washers
- Press washers lightly down so glue comes out the sides and hand tighten nuts onto bolts. Allow glue to dry for one hour
- A 2-3 mm film of glue should be between washer and GFK
- About 100ml of glue should be used per washer.

Note: Placement of round washers



Step 8 – Tighten keel bolts

- After one hour drying time, using a torque wrench tighten lower nuts. The Bavaria Cruiser 56 uses 530 Nm, all other sailing yachts tighten to 363 Nm
- Apply upper nut, and tighten to same Nm value
- Attach the grounding cable to the forward keel washer



Step 9 – Finalise the keel

- Lightly sand the glued area to ensure a smooth surface and wipe the dust away
- Using KIM TEC Zinkstaub farbe (Zink Powder Paint), paint the keel and hull joint





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Thank you!