

# Epoxy GP Coating Primers



## PRODUCT DESCRIPTION

Epoxy GP Coating is a primer for pre-treated steel, aluminium and dimensionally stable plywood. It features unlimited recoatability with two-pack products.

## PRODUCT INFORMATION

Colour	IPB110-White, IPB164-Grey (Light Grey - approx. RAL 7035).
Finish	Matt
Specific Gravity	1.33
Volume Solids	46%
Mix Ratio	100 Part A : 15 Part B by Volume. 100 Part A : 10 Part B by Weight.
Converter/Curing Agent	IPB112
Typical Shelf Life	2 years
VOC (As Supplied)	468 g/lit
Unit Size	5 Lt , 20 Lt

## DRYING/OVERCOATING INFORMATION

	Drying			
	10°C (50°F)	15°C (59°F)	25°C (77°F)	35°C (95°F)
Hard Dry		48 hrs	24 hrs	12 hrs
Touch Dry		2 hrs	1 hrs	1 hrs
Pot Life		8 hrs	8 hrs	8 hrs

**Note:** Pot life reduces as temperature and mix volume increases. Pot life refers to the Working Pot Life. It is recommended not to prepare a larger volume than required for immediate use. Drying times quoted in this datasheet were measured without thinners. Drying time will vary according to the application method, and the quantity and type of thinner used.

Overcoated By	Overcoating Substrate Temperature							
	10°C (50°F)		15°C (59°F)		25°C (77°F)		35°C (95°F)	
	Min	Max	Min	Max	Min	Max	Min	Max
Epoxy Finishing Filler	48 hrs	ext	24 hrs	ext	16 hrs	ext	16 hrs	ext
Epoxy GP Coating	48 hrs	ext	24 hrs	ext	16 hrs	ext	16 hrs	ext
Interfill 550	48 hrs	ext	24 hrs	ext	16 hrs	ext	16 hrs	ext
Interfill 830	48 hrs	ext	24 hrs	ext	16 hrs	ext	16 hrs	ext
Interfill Deck	48 hrs	ext	24 hrs	ext	16 hrs	ext	16 hrs	ext
Interior Primer 860	48 hrs	ext	24 hrs	ext	16 hrs	ext	16 hrs	ext
Interprime 450	48 hrs	ext	24 hrs	ext	16 hrs	ext	16 hrs	ext
Interprime 820	48 hrs	ext	24 hrs	ext	16 hrs	ext	16 hrs	ext
Interprotect (Professional)	48 hrs	ext	24 hrs	ext	16 hrs	ext	16 hrs	ext
Interthane 870	48 hrs	ext	24 hrs	ext	16 hrs	ext	16 hrs	ext
Interthane 990	48 hrs	ext	24 hrs	ext	16 hrs	ext	16 hrs	ext
Perfection Pro Undercoat	48 hrs	ext	24 hrs	ext	16 hrs	ext	16 hrs	ext
Perfection Undercoat	48 hrs	ext	24 hrs	ext	16 hrs	ext	16 hrs	ext

**Note:** All overcoating times are approximate. When being overcoated, the surface must be dry, clean, grease- and dust-free. Maximum recoat time without sanding is 6 months (in shed). Inspection for cleanliness is recommended. Do not wipe with solvents. Interfill 550 available in limited markets only.

## APPLICATION AND USE

### Preparation

**STEEL** Clean off all rust, dust, oil, grease and dirt and ensure surface is dry. Blast to near white metal surface (Sa 2½) in accordance with ISO8501-1. Remove all blast or sanding residue using a clean air line and sweeping with a clean brush or broom. Vacuum clean for best results. If blast cleaning is not possible, all steel has to be re-prepared by rotary wire brushes and/or sanding discs (coarse 24 grit) to a grade St 3. Remove sanding debris.

**STEEL with a Shop Primer** If the steel surface has been treated with a shop primer, the shop primer should be in good condition and be suitable to be overcoated with the chosen paint system. The shop primer should be applied to a Sa 2½ blast cleaned steel surface.

**Exterior** Clean off all rust, dust, oil, grease and dirt and ensure surface is dry. All welded seams, rusted areas, burn marks and other damage in the shop primer has to be blast cleaned with a not too coarse, dry sharp abrasive to a min. grade Sa 2½ according to ISO 8501-1. The intact shop primer has to be sweepblasted. If blast cleaning is not possible,

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all steel has to be re-prepared by rotary wire brushes and/or sanding discs (coarse 24 grit) to a grade St 3.

**Interior** Clean off all rust, dust, oil, grease and dirt and ensure surface is dry. All untreated weld seams, rusted areas, burn marks and other damage in the shop primer has to be re-prepared with rotary wire brushes and/or sanding discs. Ensure the surface is thoroughly cleaned.

## ALUMINIUM

**Exterior** Clean the surface with Super Cleaner (rinse well afterwards with clean fresh water) and blast the surface with a dry, non-metallic, fine, sharp abrasive. Apply the first coat of Epoxy GP Coating as soon as possible after the surface preparation. An alternative surface preparation is a chemical treatment of the aluminium after cleaning and sanding with aluminium oxide 24-80 (grit) grade (or equivalent).

**Interior** Clean the surface well with Super Cleaner, preferably with high pressure water or steam cleaner. Rinse with fresh water. Repeat this if necessary until the surface is completely clean and free from any grease.

**PLYWOOD:** Degrease the wood with Degreaser (Oplosser) or 600 Wipedown Solvent. All traces of sanding dust must be removed as this will impair adhesion. Sand the whole surface with 150-180 (grit) grade paper. Clean the surface with Degreaser (Oplosser) or 600 Wipedown Solvent and clean cloths. Tropical hardwood has always to be degreased with Degreaser (Oplosser).

**GRP** Thoroughly degrease the GRP with Degreaser (Oplosser) or 600 Wipedown Solvent. All traces of dust/surface contaminants must be removed as this will impair adhesion.

## Method

For more information regarding sanding refer to "The Importance of Good Sanding Practices" leaflet.

## Hints

**Mixing** Ensure the correct volume mix ratio is used. Thoroughly stir Part A before use to obtain a homogenous product. Use a mixer for this that is powered by either an air-driven motor or an explosion-proof electric motor. Next add Part B (Curing Agent) while stirring until a homogenous mix is achieved.

**Thinner** Thinner No.7

**Thinning** If the paint is too thick, e.g. at lower temperatures, add a small amount of thinner to reduce viscosity. The amount of thinner to be added depends on the conditions of application and method of application being used. Add thinner only after thoroughly mixing the components.

**Cleaner** Thinner No.7 or Degreaser (Oplosser).

**Ventilation and Humidity Control** To achieve sufficient curing, the maximum relative humidity should not exceed 80%. During application and drying in a confined spaces, continuous ventilation is required to extract solvent vapours for health and safety reasons and to assist the drying process.

**Airless Spray** Thin 5-15% using Thinner No.7 at 23°C. Tip Size: 0.48 mm/19 thou. Pressure: 140-160 bar.

**Conventional Spray** Thin 15-20% using Thinner No.7 at 23°C. Tip Size: 2.0-2.2 mm/80-86 thou. Pressure: 3-4 bar.

**Brush** Thin 0-5% using Thinner No.7 at 23°C.

**Roller** Thin 0-5% using Thinner No.7 at 23°C.

**Other** If a hull is to be treated with Epoxy GP Coating and left for a long period outside, apply at least 2 coats at a DFT of 80 microns per coat.

## Some Important Points

Ambient temperature should be minimum 10°C/50°F and maximum 35°C/95°F. Substrate temperature should be minimum 10°C/50°F and maximum 35°C/95°F. Product temperature should be minimum 10°C/50°F and maximum 35°C/95°F. The substrate temperature must be at least 3°C above the dewpoint to prevent condensation. It is recommended not to apply the product under adverse weather conditions. Coverage depends on several factors, including shape of the yacht, surface roughness, method of application being used and conditions of application.

## Compatibility/Substrates

Steel, with or without shop primer, aluminium and dimensional stable marine plywood.

## Number of Coats

Variable. Check with individual specifications.

## Coverage

(Theoretical) - 7.6 m<sup>2</sup>/L per coat by brush/roller; 4.5 m<sup>2</sup>/lt by airless spray.  
(Practical) - 6.9 m<sup>2</sup>/L per coat by brush/roller; 3.4 m<sup>2</sup>/lt airless spray.

## Recommended DFT per coat

60 microns dry by brush / roller, 100 microns dry by spray

## Recommended WFT per coat

130 microns wet by brush / roller, 217 microns wet by spray

## Application Methods

Airless Spray, Brush, Conventional Spray, Roller

## TRANSPORTATION, STORAGE AND SAFETY INFORMATION

### Storage

#### GENERAL INFORMATION:

Exposure to air and extremes of temperature should be avoided. For the full shelf life of this product to be realised ensure that between use the container is firmly closed and the temperature is between 5°C/41°F and 35°C/95°F. Keep out of direct sunlight.

#### TRANSPORTATION:

The product should be kept in securely closed containers during transport and storage.

### Safety

**GENERAL:** Avoid contact with skin and eyes. Epoxy GP Coating can cause dermatitic skin reactions. Always use gloves and goggles and keep skin protected with overalls. Any accidental skin contact should be immediately washed off with soap and water. Do not eat, drink or smoke in mixing or application areas. Wear suitable respiratory protective equipment. Read the label safety section for Health and Safety Information, also available from our Technical Help Line.

**DISPOSAL:** Do not discard tins or pour paint into water courses, use the facilities provided. It is best to allow paints to harden before disposal.

Remainders of this product cannot be disposed of through the municipal waste route or dumped without permit. Disposal

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## IMPORTANT NOTES

of remainders must be arranged for in consultation with the authorities.

*The information given in this sheet is not intended to be exhaustive. Any person using the product without first making further written enquiries as to the suitability of the product for the intended purpose does so at their own risk and we can accept no responsibility for the performance of the product or for any loss or damage (other than death or personal injury resulting from negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.*