

### PRODUCT DESCRIPTION

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

### PRODUCT INFORMATION

<b>Colour</b>	IPB110-White, IPB164-Light Grey - White, Light Grey (approx. RAL 7035).
<b>Finish</b>	Matt
<b>Specific Gravity</b>	1.33
<b>Volume Solids</b>	46%
<b>Mix Ratio</b>	100 Part A : 15 Part B by Volume. 100 Part A : 10 Part B by Weight., Converter/Curing Agent - IPB112
<b>Typical Shelf Life</b>	1 yrs
<b>VOC (As Supplied)</b>	468 g/ltr
<b>Unit Size</b>	5 Lt , 20 Lt

### DRYING/OVERCOATING INFORMATION

#### Drying

	10°C	15°C	23°C	35°C
Hard Dry [ISO]		48hrs	24hrs	12hrs
Touch Dry [ISO]		2hrs	1hrs	1hrs
Pot Life		8hrs		

**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.

#### Overcoating

##### Substrate Temperature

Overcoated By	10°C		15°C		23°C		35°C	
	Min	Max	Min	Max	Min	Max	Min	Max
Epoxy Finishing Filler	48hrs	ext	24hrs	ext	16hrs	ext	16hrs	ext
Epoxy GP Coating	48hrs	ext	24hrs	ext	16hrs	ext	16hrs	ext
Epoxy LG Filler	48hrs	ext	24hrs	ext	16hrs	ext	16hrs	ext
Interfill 830	48hrs	ext	24hrs	ext	16hrs	ext	16hrs	ext
Interprotect	48hrs	ext	24hrs	ext	16hrs	ext	16hrs	ext
Interprotect (Professional)	48hrs	ext	24hrs	ext	16hrs	ext	16hrs	ext
Midcoat Flat	48hrs	ext	24hrs	ext	16hrs	ext	16hrs	ext
Midcoat Flat HS	48hrs	ext	24hrs	ext	16hrs	ext	16hrs	ext
Sikkens Epoxy Barriercoat GP	48hrs	ext	24hrs	ext	16hrs	ext	16hrs	ext
Sikkens Epoxy Heavycoat	48hrs	ext	24hrs	ext	16hrs	ext	16hrs	ext
UC Gloss	48hrs	ext	24hrs	ext	16hrs	ext	16hrs	ext
UC Gloss HS	48hrs	ext	24hrs	ext	16hrs	ext	16hrs	ext

**Note:** All overcoating times are approximate. When being overcoated, the surface must be dry, clean, grease- and dust-free.

### 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 P24) 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, all steel has to be re-prepared by rotary wire brushes and/or sanding discs (coarse P24) 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 International's 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 grit P24-80 (or equivalent).

**Interior:** Clean the surface well with International's 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. Sand the whole surface with sanding paper grit P150-180. All traces of sanding dust must be removed as this will impair adhesion. Clean the surface with Degreaser (Oplosser) or 600 Wipedown Solvent and clean cloths. Tropical hardwood has always to be degreased with Degreaser (Oplosser).

**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** Thinners No.7

**Thinning** If the paint is too thick, e.g. at lower temperatures, add a small amount of thinners 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** Thinners 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) - 7.60 (m<sup>2</sup>/lt) by brush/roller; 4.5 m<sup>2</sup>/lt by airless spray.

(Practical) - 6.90 (m<sup>2</sup>/lt) by brush/roller; 3.4 m<sup>2</sup>/lt airless spray.

**Recommended DFT**

100 microns dry by airless spray / 60 microns dry by brush or roller

**Recommended WFT**

220 microns wet by airless spray / 130 microns wet by brush or roller

**Application Methods**

Airless Spray, Brush, Roller, Conventional Spray

**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/40°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 of remainders must be arranged for in consultation with the authorities.

**IMPORTANT NOTES**

*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 or 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.*

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