



# Perfection Professional Application Manual

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Fibreglass (GRP)/ Epoxy composite
Aluminium
Steel
Wood

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## Perfection Coating System Overview

The Perfection system has been totally revised and is the latest in a long line of two component polyurethane coating developments to come out of the central research facility of International Paint for use under the world renowned International name. This latest development is in keeping with our policy of continuous product improvement as technology moves forward.

The on-going development of Perfection is not alone. An exceptional amount of research has gone into the development of each product in the range to make it compete with the best products in its class (i.e. finish primer, high build primer as in the Interprime range, Interprotect and fairing compounds as in the Interfill range, etc...). We constantly review the complete painting system to ensure that International products are properly integrated into the complete paint systems.

Perfection has been re-formulated with versatility in mind whether you prefer brush/roller application or spray application. The product objectives are those of fitting the requirements of the skilled amateur while producing characteristics that the professional applicator expects. These products can be used to make the project proceed quicker and with minimal effort.

Our Technical Representatives are familiar with the systems used for topsides finishing on yachts and are well versed in the application and use of all the products, including Perfection. Please do not hesitate to call your local Technical Representative and ask for advice.

### Important Note

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## Application of Perfection by conventional spray

### *Introduction: Brief overview of system*

**Perfection** is part of a complete system of “easy to use” top coating products that will give truly professional finishes.

It is important to understand all the components of the **Perfection** system so that they may be used to maximum advantage.

The components of the system are as follows:

- Colour base
- Perfection Varnish/Glaze Coat base
- Accelerator
- Hardener/Curing agent

The mixing ratio base with the hardener is 2:1 by volume. The level of accelerator permitted as an addition is detailed later (see Page 10) but is typically between 1 ml and 12 mls per mixed 750 mls unit or up to 40 mls per 2.25 litre unit of **Perfection** un-thinned to spray viscosity.

### *Perfection Colours and White – Details and Use*

The whites, all of the standard colours (as shown on the colour card) and Clear/Glaze Coat can all be handled in a similar fashion as they have similar application and curing characteristics. They can be accelerated when necessary by the addition of **Accelerator for 2-part Polyurethanes (YQA100)**.

Certain colours, notably bright reds, yellow, green and dark blues, will have been formulated on lead free pigments for health and safety reasons, and offer a slightly lower degree of opacity. These colours should be applied to a uniformly coloured undercoat to achieve full colour average.

Once the first coat of **Perfection** (this would normally comprise a half wet coat followed by a full coat) has been cured the final **Perfection** colour can then be applied. Follow, if required, with a coat of **Interspray 900 Glazecoat** to give added visual depth to the colour in the darker shades or co-blended with the selected colour in white or pastel shades. This coat of clear or lightly pigmented glazecoat may be accelerated if required following recommendations shown later and will demonstrate an enhancement to the finished appearance.

Product Code	Colour
YGB001	Curing Agent
YQA100	Accelerator for 2-part Polyurethanes
YZM914	Matting agent for 2-Part Polyurethane's
YZA900	Interspray 900 Glazecoat
YHA183	Perfection Platinum
YHA184	Perfection Mediterranean White
YHA192	Perfection Off White
YHA194	Perfection Oyster White *
YHA198	Perfection Matterhorn White
YHA216	Perfection Royal Blue
YHB000	Perfection Snow White
YHB663	Perfection Jade Mist Green
YHF991	Perfection Mauritius Blue
YHK990	Perfection Flag Blue
YHS056	Perfection Fighting Lady Yellow
YHE294	Perfection Chilli Red **
YHS070	Perfection Cream
YHY999	Perfection Jet Black
YHS299	Perfection Rochelle Red **

\*\* Available from June 2005

### ***Interspray 900 Glazecoat (Clear) – (YZA900) Details and Use***

**Interspray 900 Glazecoat (YZA900)** is designed as a clear finish to be used mainly over dark colours such as deep blues to enhance the distinction of image or as a co-blend in pastel shades. The clear glazecoat may be used in its own right as an interior varnish to give a high gloss hardwearing finish. **Interspray 900 Glazecoat** is not specifically recommended for use as an exterior clear varnish due to its inherent hardness. In these situations use a product specifically formulated for these conditions.

When using as the final finishing coat over pastel colours, the **Interspray 900 Glazecoat (YZA900)** (clear) may be mixed with portions of the desired colour. ***Interspray 900 Glazecoat should not be used over the pure white shades without co-blending as it may alter the appearance of the shade.*** If time does not permit the separate application of clear to a sanded, cleaned, dry colour then the clear may be applied over a tacky/wet coat of colour. **Interspray 900 Glazecoat** may be accelerated with **Accelerator for 2-part Polyurethanes (YQA100)**.

## ***Accelerator for 2-part Polyurethanes (YQA100) Details and Use***

**Accelerator for 2-part Polyurethanes**, supplied for use with **Perfection**, is a highly reactive material that can substantially reduce the curing times of the product under a variety of conditions. The accelerator must be used with care and excessive additions avoided.

### ***Drying times***

The curing/drying time of **Perfection** is affected by the amount of paint applied, the temperature and available ventilation. The intervals at which coats are applied when applying wet on wet, have a significant effect on solvent release and drying. The information given is for a typical application of one half wet coat followed by two full coats leading to a dry film build of around 75 – 100 microns, Standard Spray Solvent - YTA915 being used.

**Perfection** passes through various phases during its curing cycle as follows:

- Flow time - the time during which the paint remains very wet and mobile and will flow readily. This time can be extended by the use of the **Thinner 920** (YTA920), or **Thinner 925** (YTA925) a slower evaporating solvent blend.
- Tacky stage - the stage at which a high proportion of the solvents have left the paint film and when touched with a finger, paint is removed.
- Tack off stage - the stage at which a fingerprint can be left on the surface but no paint is removed. This is the usual stage at which, during application by spray, the next coat is applied. At this stage the paint film is becoming cross-linked but will blend and flow into the new coat.
- Touch dry - the stage at which no fingerprint is left on the surface, the paint has gelled right through but is not yet very hard. At this stage cross-linking has increased substantially. Re-coating at this stage will not result in maximum flow and gloss of the paint film.
- Firm stage - the stage at which moderate pressure does not affect the film.
- After the above stage the paint film progressively becomes harder over a period of time dependant on curing temperatures, amount of paint applied, and levels of accelerator used.

### *Where and when to use*

**Perfection** has been formulated to give the ultimate finish under a wide range of conditions. The use of the accelerator may be necessary unless longer drying cycles are not a problem. Remember the ultimate finish is obtained by the slowest cure of the product that you can accept.

The conditions where the accelerator may be required are those, for example, where the paint film will be exposed to dust and dirt before the paint has reached its touch dry time. When the temperatures/conditions are such that the paint film will be exposed to humid conditions before the paint has reached a satisfactory degree of cure the use of **Accelerator (YQA100)** can prove invaluable in preventing down glossing. This is especially important for horizontal surfaces such as decks, cockpit areas, and heavily raked surfaces such as transoms and cabin sides painted outside.

Remember that when applying the paint, the surface temperature will drop in late afternoon. Care should be exercised that the dew point is not reached. Such conditions lead to deposition of moisture on the surface followed by a loss of gloss as the paint cures.

### *How to add accelerator and mix paint*

Choose the level of **Accelerator for 2-part Polyurethanes** you require given the environment in which **Perfection** is being applied. **Perfection** should be prepared for use.

Mix Part A (base) & Part B (curing agent) of the paint together and stir thoroughly. The paint should then be thinned as required (see section entitled "Spraying - Viscosity and Solvent use") to a viscosity of 14 – 15 seconds DIN 4. Stand for 20 minutes to allow gases and entrapped air to escape. The selected level of **Accelerator for 2-part Polyurethanes** should be added and stirred in. The paint is now ready for use.

### *Pot life*

The addition of **Accelerator for 2-part Polyurethanes** decreases the pot life (working life) of **Perfection**. People's concept of pot life varies, some even confusing the time to gelation as being the pot life. In practice, for materials such as **Perfection**, the pot life of the product is the point at which viscosity increase renders it unsuitable for spray application without orange peel. E.g. initially 14 – 15 seconds DIN 4 raising to 20 - 25 seconds the product still remaining liquid would give a material, which, while sprayable, would fail to produce acceptable flow. Consult the **Perfection** product data sheet.

### **Accelerator for 2-part Polyurethanes (YQA100) use –750 mls unit**

	Below 10°C	10 -15°C	15 -20°C	20 -25°	25-30°C	30°Cand above
Maximum addition per mixed 750 mls unit	Do not use Perfection below 10°C	12 mls	6.5 mls	4.0 mls	2.5 mls	0.75 ml

*Note: European packaging consists of a 750 mls container part filled with 500 mls of base component to accommodate addition of 250 mls of curing agent.*

### **Accelerator for 2-part Polyurethanes (YQA100) use – 2.5 litre container (2.25 litre unit)**

	Below 10°C	10 -15°C	15 - 20°C	20 -25°C	25 - 30°C	30°C and above
Maximum addition per mixed 2.25 litre unit	Do not use Perfection below 10°C	40 mls	21 mls	13 mls	8 ml	2.5 mls

*Note: European packaging also comprises a 2.5 litre unit part filled with 1.5 litres base component to accommodate the addition of 750 mls of curing agent making a 2.25 litre unit.*

### **Important advice – Effect of moisture**

One of the most important factors which influences the final finish obtained with two component polyurethane finishes is the presence of moisture. Moisture will "kill" the gloss of a urethane finish if allowed to come in contact with the surface of the paint before it has cured. This is very important to remember when painting outside and this should be taken into account when commencing painting. Remember that as evening draws on, condensation may be formed. If the paint is not going to be cured before this moisture hits the surface then either arrange a cover to protect the surfaces, accelerate the paint, or leave until the weather is suitable. If the surface is affected then it will have to be sanded down and re-coated either with the colour again or a coat of **Interspray 900 Glazecoat**.

No definitive time period for the sensitivity of the paint to moisture can be given due to the large number of variables involved. It is wise however, to allow at least twice the quoted firm dry times of the product before allowing surfaces to be moistened.

It is also important to avoid moisture contamination of the paint when applying and it is therefore important to ensure you have good, working moisture traps on all air lines placed so that air entering the spray gun is dry. Moist air may lead to surface defects such as cissing and diminished gloss in the cured film.



### ***Film build***

When applying **Perfection** avoid the temptation to apply excessive film thickness in any one coat session. Heavy films will cause solvent entrapment leading to soft films and the possibility of solvent bubbling or causing blistering at a future (as long as 1-2 years) date. In any one-session try to avoid applying much more than about 100 microns dry. Do not re-apply further paint until the previously applied product feels hard.

The main area where this can be a problem is on horizontal surfaces like decks where the paint can be applied very heavily without worries of runs and sags. When first applied the finish looks good but as the paint cures the film remains softer than it should, and some slight loss of gloss can be experienced.

### ***Prior to finish application***

The Project/Quality Manager should insist on trial applications of both undercoat and finish coatings. The trials should be organised well in advance (at the priming stages) in readiness for the final application.

This is important to ensure that the application team is familiar with the gun settings that will achieve the best result.

Before any application takes place ensure the surface is **thoroughly** clean and **all** sanding debris removed. The use of a reputable Wipe Down Solvent can help achieve the required level of cleanliness. What must be stressed, however, is the level of cleanliness required to achieve quality finishes and we cannot underestimate the thoroughness required in the preparation process.

During the cleaning process wash down solvent or water must not be allowed to dry on the surface. Residues **must** be removed using dry paper wipes. Even the most minute deposit of sanding residue remaining on the surface can impair the finish by leaving the most unsightly marks evident in the surface of the dried **Perfection**. This is particularly noticeable in dark colours.

Final cleaning should be done using a reputable Wipe Down Solvent and the two-cloth method for cleaning. This method of cleaning helps remove any dust and grease from the surface. The cloths you use should be lint free absorbent cloths obtainable from automotive paint supplies shops. Alternatively industrial tissue may be used. Take care to wear solvent resistant gloves, a solvent vapour respirator and provide adequate ventilation.

#### **Procedure:**

1. Use one solvent wetted cloth to initially wipe the surface.
2. Without allowing the surface to dry, remove the residue with the second cloth
3. Only wipe small areas at a time to prevent the solvent drying on the surface. Ideally two people working side by side, one wetting and the other drying is best.
4. Change cloths frequently to prevent the build up of contaminants.

### ***Perfection Application (Solvent use, viscosity & spraying)***

Spray gun model, its set up with air cap and fluid nozzle, and viscosity go hand in hand. Ignore one facet and optimum results will not be achieved. Individual applicators have their own application technique usually based upon experience from spraying large areas on the one hand and intricate shaped objects on the other. Spray techniques noticeably vary, with the American technique one of a more deliberate and somewhat closer approach than the European with free movement further away from the object surface. A properly adjusted paint has to accommodate all methods hence International has a range of spray solvents to accommodate both temperature and application technique variables.

### ***Thinners range for Perfection***

Thinner	Sales Code	Description
<b>Thinner 910</b>	YTA910	Fast Spray solvent
<b>Thinner 915</b>	YTA915	Standard Spray solvent
<b>Thinner 920</b>	YTA920	Slow Spray Solvent
<b>Thinner 925</b>	YTA925	Extra Slow Spray Solvent

The following table gives suggested methods of application. We must point out that these are only suggestions based on our own trial applications during product development. As with all applications on site it is advisable to undertake trial applications in the conditions that prevail before spray application to the vessel.

	10 - 18°C	16 - 22°C	20 - 28°C	28°C+
<b>Thinners type</b>	YTA910	YTA915	YTA920	YTA925
<b>Suggested viscosity</b>	15 seconds DIN 4 viscosity cup (approximately 25 - 35% thinning – mix ratio 2:1:1 up to 2:1:1½, Base :Curing Agent :Thinners)			
<b>Type of first coat to apply</b>	Medium wet or half coat with even coverage			
<b>Time to overcoat</b>	No paint removal with light finger touch			
<b>Second &amp; Third coats</b>	Full coat			
<b>Time to overcoat</b>	No paint removal with light finger touch			

It is always better practice to use a DIN 4 viscosity cup measurement to determine viscosity; this ensures the best flow out.

The chart below shows the temperature ranges for the spray thinners. In the overlap areas it is possible to blend adjacent thinners in the series to achieve the optimum mix. Spray solvent selection by temperature band.

Temperature	10°C	15°C	20°C	25°C	30°C	35°C	40°C
Thinners							
YTA910							
YTA915							
YTA920							
YTA925							

The key to total performance is controlled solvent release. Whatever blend is used it must evaporate out of the paint film at a suitable rate to allow the product to flow (level out). Good ventilation and a dry environment are essential for maximum solvent release. Poor ventilation and damp atmospheres may generate dull hazy finishes. Additionally if the material does not flow to an orange peel free finish this is an indication that one of the parameters for curing is incorrect. Measuring the viscosity is a prime starting point. While the chart gives suggested percentage solvent additions the true check is the viscosity at a given temperature. A typical spray viscosity for **Perfection** is 15 seconds DIN 4.

### Viscosity Conversions @ 23°C

Centipoises	Ford No 4	BS B4	DIN 4	Zahn #2
			14	14
10			15	16
15	14		15	17
22	14	16	16	19
32	15	24	16	20
50	19	25	18	22
65	22	30	20	27
85	27	34	23	34
100	30	40	26	41
125	36	47	30	49

Please note that conversions for viscosity cups are only approximations and are given for guidance only. Application trials undertaken by International in Europe are standardised with DIN 4 viscosity cup.

### Spraying Equipment

When spraying **Perfection** it is important to use good quality equipment with a good source of clean, dry air available in sufficient volumes for the job in hand. There are numerous gun set-ups that will provide an excellent finish. The important aspect of spraying these types of products is to obtain complete atomisation of the paint. Setting the paint and gun up ready to paint and flicking the gun across a small area quickly, with the trigger pulled, can check this. Examination of the sprayed pattern should reveal a very fine deposition of paint composed of very, very fine droplets. If the droplets are not fine and tend to be larger, then complete atomisation has not occurred and the gun set-up should be altered.

<b>Suggested spray gun set up for European Perfection applications</b>		
<b>DeVilbiss JGA 700</b>		
<b>Air Cap</b>	<b>No.30</b>	
<b>Fluid Tip</b>	<b>AV15FF</b>	
<b>Air Pressure</b>	<b>4.0 – 4.4 bar (60 – 65 psi)</b>	
<b>Viscosity</b>	<b>15 seconds DIN 4</b>	
<b>De Vilbiss JGA series</b>	<b>Gravity Feed</b>	<b>Suction Feed</b>
<b>Air Cap</b>	<b>704 or 765 at 18°C</b>	<b>No.43</b>
<b>Fluid Tip</b>	<b>1.4 mm</b>	<b>1.4 mm</b>
<b>Air Pressure</b>	<b>4.0 bar (60 psi)</b>	<b>4.0 bar (60 psi)</b>
<b>Viscosity</b>	<b>15 seconds DIN 4</b>	<b>15 seconds DIN 4</b>
<b>DeVilbiss KB3</b>		
<b>Pressure pot system</b>		
<b>Air Cap</b>	<b>767, 777 or 797</b>	
<b>Fluid Tip</b>	<b>1.1 mm</b>	
<b>Air Pressure</b>	<b>4.0 bar (60 psi)</b>	
<b>Pot pressure</b>	<b>0.5 – 0.7 bar (7 – 10 psi)</b>	
<b>Viscosity</b>	<b>15 seconds DIN 4</b>	
<b>DeVilbiss Gti</b>	<b>Suction feed</b>	<b>Pressure pot system</b>
<b>Air Cap</b>	<b>110</b>	<b>110 or 112</b>
<b>Fluid Tip</b>	<b>1.3 mm</b>	<b>1.0 or 1.1 mm</b>
<b>Air Pressure</b>	<b>2.0 bar (30 psi)</b>	<b>2.0 bar (30 psi)</b>
<b>Pot pressure</b>	<b>Not applicable</b>	<b>0.5 – 0.7 bar (7 – 10 psi)</b>
<b>Viscosity</b>	<b>15 seconds DIN 4</b>	<b>15 seconds DIN 4</b>
<b>De Vilbiss GFV</b>		
<b>Gravity feed</b>		
<b>Air cap</b>	<b>No.30 or No.43</b>	
<b>Fluid tip</b>	<b>1.1 –1.4 mm</b>	
<b>Air pressure</b>	<b>3.0 – 3.7 bar (45 – 55 psi)</b>	
<b>Viscosity</b>	<b>15 seconds DIN 4</b>	
<b>Sata Jet</b>	<b>NR 95 Gravity feed</b>	<b>NR 90 Gravity Feed</b>
<b>Air cap</b>	<b>50518</b>	<b>50153</b>
<b>Fluid tip</b>	<b>1.3 mm</b>	<b>1.5 mm</b>
<b>Air Pressure</b>	<b>3.0 bar (45 psi)</b>	<b>4.5 bar (67 psi)</b>
<b>Viscosity</b>	<b>15 seconds DIN 4</b>	<b>15 seconds DIN 4</b>

## *General information for primers associated with Perfection painting specifications*

### *Interprime 820 High Performance Epoxy Primer*

**Interprime 820** is a high performance epoxy primer for use above and below the waterline. It offers excellent anticorrosive protection and is, therefore, strongly recommended for use on steel and aluminium substrates that require protection that lasts. Superb adhesion to metal makes it ideal for use as a holding primer prior to application of the full paint scheme. It can be over-coated with itself after 8hrs at 23°C and with Interfill Epoxy Fillers after 24hrs at 23°C. With an extended maximum over-coating time, **Interprime 820** is the ultimate choice for larger projects where the metal needs to be protected whilst fitting is being carried out. Where a topcoat system is required, and additional coats of **Interprime 820** have been used, the **Interprime 820** should be sanded prior to application of fillers or the undercoat in order to achieve the optimal finish.

**Interprime 820** is suitable for both roller and spray application when used as a holding primer. A range of solvents is available to allow spray application in both temperate and tropical conditions. Available in white and grey for over-coating identification. Also suitable for use on GRP/fibreglass and rigid wood constructions.

### *Interprime 880 High Performance Epoxy Finish Primer*

**Interprime 880** is a recent advance in epoxy primer technology thus producing a primer with the capability of curing at a wide range of temperatures. This curing ability makes it an ideal product for maintenance situations in warm climates where rapid curing characteristics ensure continuation of working practises, reducing the risk of vessels delaying time on slipways and in dry docks as well as maintaining its characteristics as a product suitable for new buildings.

**Interprime 880** offers additional advantages since it gives more typical primer characteristics and is therefore more than an intermediate between primer system and finishing coats, having the ability to perform as an anticorrosive when adjacent to bare metals, typically sand through areas, and can be safely applied over **Interfill 830**, **Interfill 833** and **Interfill 835**. It can be used as a build coat in maintenance systems. The product will also continue to perform as an undercoat prior to finishing for those applicators that have a preference for epoxy undercoats rather than polyurethane based undercoats in superyacht painting systems.

**Interprime 880** off white finish primer (also available in blue/grey) has excellent sanding characteristics. It can be prepared for finishing coats with the very minimum of sanding marks when sanded with 320 - 400 grade wet or dry paper. **Interprime 880** assures excellent gloss hold out and long-term durability of the topcoat.

## *Interprotect*

**Interprotect** is a well-established two-component epoxy primer with a long track record. It is recognised as a primer for a wide range of substrates and is regularly over coated with **Perfection Undercoat**, which, when sanded provides an excellent sub-coat for the application **Perfection**.

**Interprime 820 application data: (Continued on next page)**

Conventional Spray:	Pressure Pot	Siphon Cup	Gravity Feed
Tip Size	0.070 - 0.086"	NA	0.070 - 0.086"
Pot Pressure **	0.6 - 1.0 bar (10 - 15 psi)	NA	NA
Output Pressure	3.5 – 4.0 bar (50 - 60 psi)	NA	3.0 - 3.75 bar (45 - 55 psi)
HVLP:	Pressure Pot	Siphon Cup	Gravity Feed
Tip Size	0.070"	NA	NA
Pot Pressure **	0.5 – 0.6 bar (8 - 10 psi)	NA	NA
Output Pressure	3.5 bar (50 psi)	NA	3.0 – 3.75 bar (45 - 55 psi)
Airless spray:			
Interprime 820	Tip Size: 0.015-0.021 (60 - 80° Nozzle) Pressure: 175 – 210 bar (2500-3000 psi)		

<b>Interfill 835 application data:</b>			
<b>Conventional Spray</b>	<b>Pressure Pot</b>	<b>Siphon Cup</b>	<b>Gravity Feed</b>
Tip Size	0.070 - 0.110	NA	NA
Pot Pressure **	1.0 – 1.5 bar (15 – 20 psi)	NA	NA
Output Pressure	2.75 – 3.25 bar (40 – 50 psi)	NA	NA
<b>DeVilbiss 558</b>			
Tip Size	1.8 - 2.5 mm		
Pot Pressure	1.0 – 1.5 bar (15 –20 psi)		
Output Pressure	2.75 – 3.25 bar (40 – 50 psi)		
<b>Airless spray:</b>	<b>Interfill 835 should not be applied by airless spray</b>		
<b>DeVilbiss</b>			
<b>Gun: JGA-510</b>			
<b>Pressure pot:</b>	<b>Tip: AV-650-EX</b>	<b>Needle: JGA-402-EX</b>	<b>Air Cap: MB-4039-30</b>

<b>Interprime 880 High Performance Epoxy Finish Primer application data:</b>			
<b>Conventional Spray:</b>	<b>Pressure Pot</b>	<b>Siphon Cup</b>	<b>Gravity Feed</b>
Tip Size	1.6 – 1.8 mm	NA	1.8 – 2.0 mm
Pot Pressure **	0.6 – 0.8 bar (8 -12 psi)	NA	NA
Output Pressure	3.25 – 4.0 bar (50 - 60 psi)	NA	3.0 – 3.75 bar (45 - 55 psi)
<b>Airless spray:</b>			
<b>Tip Size: 0.015 - 18 (65-80° Nozzle equivalent to HD815, HD615 or HD818) Pressure: 175 – 210 bar (2400-3000 psi )</b>			

<b>DeVilbiss</b>			
<b>Gun: JGA-510</b>			
<b>Pressure pot:</b>	<b>Tip: AV-650-FX</b>	<b>Needle: JGA-402-FX</b>	<b>Air Cap: AV-1239-704</b>
<b>Air pressure</b>	<b>3.25 – 4.0 bar (50 - 60 psi)</b>		
<b>Pot pressure</b>	<b>0.6 – 0.7 bar (8 -10 psi)</b>		
<b>Preferred tip &amp; cap for best atomisation ** Based on a 2 metre length of hose.</b>			

### ***Pressure Drops in Air Lines***

Inner line dia in mm	Operating pressure	Drop in pressure in bar at a line length		
		5 metre	10 metre	15 metre
	Bar	Bar	Bar	Bar
6 mm	3.0	0.7	1.2	1.8
	4.0	1.0	1.6	2.2
	5.0	1.3	1.9	2.5
	6.0	1.5	2.2	2.8
9 mm	3.0	0.23	0.38	0.60
	4.0	0.30	0.55	0.81
	5.0	0.43	0.63	0.92
	6.0	0.60	0.80	1.10

Because of the considerable drop in air pressure we recommend the use of air lines with an inner diameter of 6 mm. With lines of more than 10metre length or high air requirement we recommend an inner diameter of 9 mm. To control the operating pressure a compressor air micrometer with a pressure gauge should be used on the spray gun.

Note the quantity of paint actually used. This will allow for a theoretical calculation of paint film thickness to be calculated. Thickness readings can be taken off the undercoat, but not the final finish coat as this would leave marks, so place steel shims around the vessel to measure thickness of the final coat. Observe the gloss and profile of the final coatings.

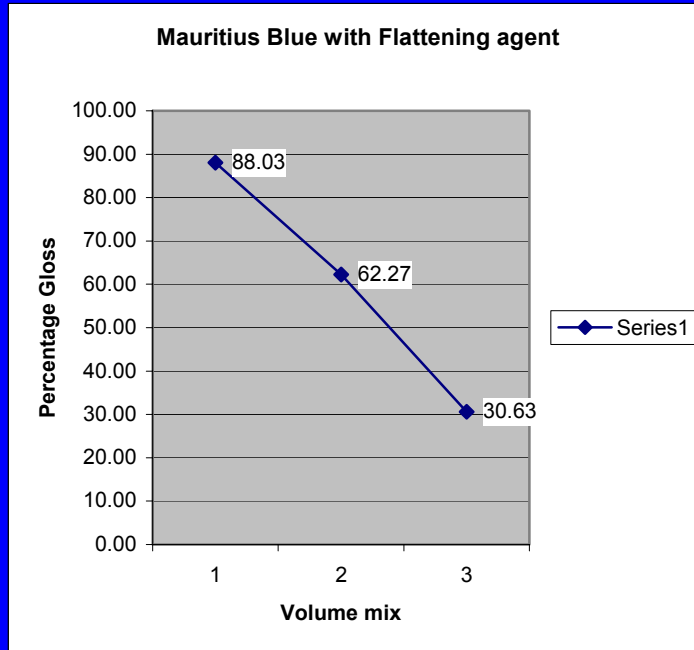
### ***Matting Agent for 2-part Polyurethanes (YZM914/YGA900) – How to Use***

**Matting Agent for 2-part Polyurethanes (YZM914/YGA900)** can be used to reduce the level of gloss finishes right down to a matt finish. The actual levels required may vary from colour to colour. This essentially is because the level of colouring pigment to resin ratio varies between colours. Check the levels required for a specific job by practical application trial.

It is recommended that reduced gloss products be sprayed to ensure uniformity of finish. Brushing products of this type may result in an uneven level of sheen if not applied with great care and skill. It should also be noted that the exact gloss levels obtained would vary slightly with the film build applied. If sprayed slightly dry, and with thin coats, the gloss will be less than for more heavily applied wet coats.



**Typical Gloss levels when using Matting Agent for 2-component Polyurethane with Perfection Mauritius Blue**



See table below for more information.

**Typical Gloss Reduction using Matting Agent for 2 Part Polyurethane (YZM914/YGA001) with Perfection**

Gloss Level	Amount of Mixed Perfection (Base and Curing agent)	Mixed Flattening Agent (YZM914) (Part A and Part B)
High Semi-gloss (1)	2 parts by volume	1 part by volume
Low Semi-gloss (2)	1 part by volume	1 part by volume
Satin/Matt (3)	1 part by volume	2 parts by volume

## *Application of Perfection by Brush/Roller*

Whether painting with polyurethane and epoxy for the first time, or having the experience from the professional ranks as applicators, there are still some golden rules that need following, not least of all considering our personal protection, then considering how much surface preparation is required before finally moving on to applying primer, possibly some filler, undercoat and Perfection finish.

### *Surface Preparation prior to application of Perfection*

When fibreglass boats require painting it is usually because they have been in service for a while and there will be the inevitable scratches and gouges in a gelcoat looking rather sad lacking in gloss and somewhat faded. The same could be said of aged paint systems on other substrates such as steel or aluminium where mechanical damage as well as UV degradation leaves them requiring maintenance.

Having removed fittings, lettering etc always remember to degrease the surface with **Yacht Line Super Cleaner (YMA620)** and an abrasive pad thus removing traces of wax, oil and dirt before starting. It will also be contaminated with traces of adhesive left behind from self-adhesive lettering. Sand the surface with 220-grade paper using an orbital sander or even by hand in areas that could not be reached with the sander. Remove the sanding debris and wipe clean with a suitable wipe down solvent.

Fill any scratches or gouges that have been well sanded with **Interfill 830 Filler (YAA867/868)** and/or **Interfill 833 (YAA813/814)** epoxy filler having first ensured sanding debris has been removed from within the scratches or other damaged areas. If debris has not been removed adhesion of the filler will be impaired. Whilst filling check the surface very carefully for pinholes which are quite common in the gelcoat surface of aged fibreglass hulls, these too should be filled or they will show as defects once the finishing coats of Perfection are applied. A slight overfill is recommended. Once the filler is cured it should be sanded smooth with 120-grade paper. Remove the sanding debris and the boat is ready to prime.

### *Application of Interprotect*

Commence painting from a point where the overlap will not show for example down the stem or at the corner of the transom. Some professionals tend to treat the transom as a separate entity particularly if it is a square and not rounded junction to the hull. Apply an even coat of **Interprotect** with a roller and lightly tip off the surface with a brush to removed the stippled texture that results from roller application. Do not apply too thickly to avoid sags or runs and remember that the primer coat is really one to seal a surface that has become slightly porous with aging as well as providing a foundation for application of finish. Allow to cure checking the Product Datasheet for the recommended overcoating time at the temperature at which you are working and at which the product will cure. For example at 23°C the second coat could be applied after 10 hours so in all probability the first coat would be left to cure overnight and sand with 120 – 220 grade paper. Remove sanding debris and give the surface a wipe down with a suitable wipe down solvent. When adequately cured apply a second coat following the same procedure as for the first rolling and tipping off with a brush.

Once cured the primer should be sanded with 220 - 320 grade paper to produce a smooth surface. Remove the sanding debris and give the surface a final wipe down prior to applying 1-2 coats of **Perfection Undercoat**. Once cured sand the **Perfection Undercoat** with 320 – 400 grade paper. Remove sanding debris. This should leave a surface suitable for the application of **Perfection** finish.

### *Application of Perfection by Brush/Roller*

Having prepared the undercoat the surface is ready for application of the finishing coats of Perfection. Pick a good time of the day to start. Do not paint in direct sunlight as a heated substrate will reduce the wet edge time of the product. Also avoid painting in the evening, as condensation on the surface of the finish will cause it to down gloss. The ideal time is in the morning after the dew has left the surface.

Mix the components in the ratio 2:1 (2 volumes of base and 1 volume of curing agent), stir thoroughly and stand for 20 minutes to allow bubbles to disperse before applying. Always have some **Thinners No. 9** to hand in case the product needs thinning slightly but only add it if the temperature is high and the brush feels as if it is dragging on the surface. Certainly there should not be a need to add more than 10% by volume and it is advised to add small percentages at a time to make the necessary adjustments.

Roll an even coat over a convenient area, not too large so that the wet edge time is retained, and tip off gently with a quality brush in a vertical direction. For tipping off purposes it is recommended that a fine burred ended or chiselled bristle brush made of China bristle or badger hair be used. Choose a size that is comfortable to handle and allow the brush to glide over the surface holding it at an angle of about 45°. It is preferable when doing this to have two operators, one attending to rolling and the other tipping off. Once tipped off leave well alone and after a short period the coating will level out to a classic full gloss finish.

Some operators, particularly those in the professional sector prefer to brush throughout and not use a roller at all. Or it could be that small complex areas are such that even when using brush/roller techniques the roller cannot access the area to be painted. Brush apply in broad diagonal strokes, cross spread in horizontal strokes before tipping of in a vertical direction. The multiple direction approach produces an even distribution of paint and at the same time removes bubbles and brush marks to give a smooth gloss finish.

For most colours two full coats of finish will suffice but occasionally with certain shades it may prove necessary to apply additional coats to obtain complete opacity. Consult the product datasheet for over-coating times.

It is recommended that equipment be cleaned in **Thinners No. 9**. Some items used such as tray liners and foam rollers are disposable items that will not be cleaned. Ensure these are disposed of according to local waste disposal laws and practises. For further information consult [yachtpaint.com](http://yachtpaint.com)

### ***Typical Specification for Brush/Roller application to metal boats***

1-2 coats <b>Interprotect*</b>	50 microns DFT per coat
<b>Interfill 830 and/or Interfill 833*</b>	fill as required
1-2 coats <b>Interprotect*</b>	50 microns DFT per coat
1-2 coats <b>Polyurethane Basecoat</b>	38 microns DFT per coat
2 - 3 coats <b>Perfection</b>	37 microns DFT per coat

**\*Note:** For GRP boats the use of Interprotect and Interfill epoxy fillers may be unnecessary and can be omitted. For alternative specifications consult your local International Technical Representative.

## Precautions Health & Safety

All of the products sold by International Paint for use in the Perfection coatings system contain chemical compounds that can damage the health of someone using them without the proper safety equipment. Adequate protection from any product only comes from inhibiting the ingestion of these chemicals, whether it is through the mouth, lungs, skin, or mucous membranes.

### ***THESE PRODUCTS ARE FOR PROFESSIONAL USE KEEP OUT OF REACH OF CHILDREN***

If spraying is the elected choice of application the best protection against breathing the evaporating solvents or atomised paint, particularly epoxy based primers and isocyanate containing paints such as polyurethane finishes, is a Positive Pressure Fresh Air System (Air fed Hood) with a full face mask to protect against inhalation through the mucous membranes, ingestion and contact with the eyes.

To protect against absorption through the skin, wear disposable paint suits with hoods, apply suitable barrier cream to hands and face, and wear gloves and masks whenever you are exposed to any of these products. Protect your eyes from splashes of paint or thinners. Never clean paint or epoxy off your skin with solvents. There are many excellent hand and skin cleaners on the market that are better suited for this purpose.

Remember also that you will be sanding down epoxy-based primers and polyurethane finishes as well as old gel coat, so you should wear a suitable dust mask eye protection when sanding.

If at any time you experience dizziness, nausea, dullness, numbness, feel intoxicated, or have difficulty breathing during the application of these products or shortly thereafter, consult a doctor immediately and if possible show him the MSDS sheets of the products that you were exposed to. **Material Safety Data Sheets** are available by calling your local International Technical Representative or by visiting [www.yachtpaint.com](http://www.yachtpaint.com)

Most of the materials listed in this Application Guide contain solvents that can ignite and burn or explode in the presence of a flame or spark. **Never smoke near an open or closed can of paint.**

## Contents Coating Guide by Substrate

### Specifications

*commencing page 24*

Fibreglass (GRP) including epoxy composites

Aluminium

Steel

Wood

### Product Data Sheets

*refer to [yachtpaint.com](http://yachtpaint.com)*

## FRP/GRP/Epoxy Composites

Specification code	Vessel Area	Product utilisation	Application method
SYG17.0(eu/na)	Topsides & Superstructure	Interfill 835/Interprime 880 (2x) and Perfection (2-3x)	Pressure & Conventional Spray
SYG21.0(eu/na)	Topsides & Superstructure	Interprime 820/Interfill 830/Interfill 833 / Interprime 880 (2x) and Perfection (2-3x)	Pressure & Conventional Spray
SYG32.0(eu/na)	Masts	Interprime 820/Interfill 833 Interprime 880 (2x) and Perfection (2-3x)	Pressure & Conventional Spray
SYG12.0(eu)	Topsides & Superstructure	Interprotect*/ Interfill 830 and or Interfill 833*/Interprotect* Perfection Undercoat (2x) and Perfection (2-3x) * optional when painting GRP	Brush/roller

Alternative specifications available on request. Consult your local Technical Representative.

Note: Specifications coded "eu/na" use product available in Europe and North America whilst the specification coded "eu" uses a product only available in Europe.



## GRP/FRP: Topsides & Superstructure

High Performance Spray

### Surface Preparation

Remove any surface wax or mould release agent (parting agent) from the laminate or gelcoat with Yacht Line Super Cleaner or Solvent Wash #202 in North America, or wiping with a suitable solvent.

Product Name	Thickness per coat		Sequential overcoating times			
	WFT	DFT		15°C	23°C	35°C
Interfill 835	800 microns	500 microns	Min	3 days	24 hrs	24 hrs
			Max	-	-	-
Interprime 880	250 microns	100 microns	Min	1 hr	1 hr	1 hr
			Max	7 days	7 days	7 days
Interprime 880	250 microns	100 microns	Min	1 hr	1 hr	1 hr
			Max	7 days	7 days	7 days
Perfection	50 microns	25 microns	Min	14 hrs	6 hrs	4 hrs
			Max	3 days	2 days	1 day
Perfection	75 microns	37 microns	Min	14 hrs	6 hrs	4 hrs
			Max	3 days	2 days	1 day
Perfection	75 microns	37 microns	Min	14 hrs	6 hrs	4 hrs
			Max	3 days	2 days	1 day

### Advisor Notes

- Prepare the substrate in accordance with the Surface Preparation details as outlined in the Perfection Application Manual and Product Datasheets.
- Apply **Interfill 835** by conventional spray ensuring the recommended wet film thickness is not exceeded. Sand with 180 - 240 grade paper. Remove sanding debris before proceeding.
- Apply two coats of **Interprime 880** to the DFT specified on the product datasheet. Sand with 320 – 400 grade paper to obtain a smooth surface. Remove sanding debris before proceeding.
- Apply 2-3 coats of **Perfection** by conventional spray to obtain a full gloss. Spray details are outlined in the Perfection Application Manual.



## GRP/FRP: Topsides & Superstructure

High Performance Spray

### Surface Preparation

Remove any surface wax or mould release agent (parting agent) from the laminate or gelcoat with Yacht Line Super Cleaner or Solvent Wash #202 in North America, or wiping with a suitable solvent.

Product Name	Thickness per coat		Sequential overcoating times			
	WFT	DFT		15°C	23°C	35°C
<b>Interprime 820</b> (thinned 15%)	160 microns	65 microns	<b>Min</b>	36 hrs	24 hrs	24 hrs
			<b>Max</b>	3 mths	3 mths	3 mths
<b>Interfill 830</b>	20,000 microns	20,000 microns	<b>Min</b>	3 days	2 days	1 day
			<b>Max</b>	-	-	-
<b>Interfill 833</b>	3,000 microns	3,000 microns	<b>Min</b>	3 days	2 days	1 day
			<b>Max</b>	-	-	-
<b>Interprime 880</b>	250 microns	100 microns	<b>Min</b>	1hr	1 hr	1 hr
			<b>Max</b>	7 days	7 days	7 days
<b>Interprime 880</b>	250 microns	100 microns	<b>Min</b>	1hr	1 hr	1 hr
			<b>Max</b>	7 days	7 days	7 days
<b>Perfection</b>	50 microns	25 microns	<b>Min</b>	14 hrs	6 hrs	4 hrs
			<b>Max</b>	3 days	2 days	1 day
<b>Perfection</b>	75 microns	37 microns	<b>Min</b>	14 hrs	6 hrs	4 hrs
			<b>Max</b>	3 days	2 days	1 day
<b>Perfection</b>	75 microns	37 microns	<b>Min</b>	14 hrs	6 hrs	4 hrs
			<b>Max</b>	3 days	2 days	1 day

### Advisor Notes

- Prepare the substrate in accordance with the Surface Preparation details as outlined in the Perfection Application Manual and Product Datasheets.
- **Interprime 820 (thinned 15%)** should be used as a holding primer to freshly prepared substrate.
- Fill as required with **Interfill 830** up to a maximum depth of 2 centimetres per single application. Sand with 40 – 80 grade paper. Remove sanding debris before proceeding.
- If minor regularities remain they should be filled with **Interfill 833** as part of the refining process. Sand with 180 – 240 grade paper. Remove sanding debris before proceeding.
- Apply two coats of **Interprime 880** to the DFT specified on the product datasheet. Sand with 320 – 400 grade paper to obtain a smooth surface. Remove sanding debris before proceeding.
- Apply 2-3 coats of **Perfection** by conventional spray to obtain a full gloss. Spray details are outlined in the Perfection Application Manual.

Specification SYG21.0eu/na-f





## GRP/FRP: Masts & Spars

High Performance Spray

### Surface Preparation

Remove any surface wax or mould release agent (parting agent) from the laminate or gelcoat with Yacht Line Super Cleaner or Solvent Wash #202 in North America, or wiping with a suitable solvent.

Product Name	Thickness per coat		Sequential overcoating times			
	WFT	DFT		15°C	23°C	35°C
<b>Interprime 820</b> (thinned 15%)	160 microns	65 microns	<b>Min</b>	36 hrs	24 hrs	24 hrs
			<b>Max</b>	3 mths	3 mths	3 mths
<b>Interfill 833</b>	3,000 microns	3,000 microns	<b>Min</b>	3 days	2 days	1 day
			<b>Max</b>	-	-	-
<b>Interprime 880</b>	250 microns	100 microns	<b>Min</b>	1hr	1 hr	1 hr
			<b>Max</b>	7 days	7 days	7 days
<b>Interprime 880</b>	250 microns	100 microns	<b>Min</b>	1hr	1 hr	1 hr
			<b>Max</b>	7 days	7 days	7 days
<b>Perfection</b>	50 microns	25 microns	<b>Min</b>	14 hrs	6 hrs	4 hrs
			<b>Max</b>	3 days	2 days	1 day
<b>Perfection</b>	75 microns	37 microns	<b>Min</b>	14 hrs	6 hrs	4 hrs
			<b>Max</b>	3 days	2 days	1 day
<b>Perfection</b>	75 microns	37 microns	<b>Min</b>	14 hrs	6 hrs	4 hrs
			<b>Max</b>	3 days	2 days	1 day

### Advisor Notes

- Prepare the substrate in accordance with the Surface Preparation details as outlined in the Perfection Application Manual and Product Datasheets.
- **Interprime 820 (thinned 15%)** should be used as a holding primer to freshly prepared substrate.
- Fill as required with **Interfill 833**. Sand with 180 – 240 grade paper. Remove sanding debris before proceeding.
- Apply two coats of **Interprime 880** to the DFT specified on the product datasheet. Sand with 320 – 400 grade paper to obtain a smooth surface. Remove sanding debris before proceeding.
- Apply 2-3 coats of **Perfection** by conventional spray to obtain a full gloss. Spray details are outlined in the Perfection Application Manual.



## GRP/FRP: Topsides & Superstructure

High Performance brush/roller application

### Surface Preparation

Remove any surface wax or mould release agent (parting agent) from the laminate or gelcoat with Yacht Line Super Cleaner or Solvent Wash #202 in North America, or wiping with a suitable solvent.

Product Name	Thickness per coat		Sequential overcoating times			
	WFT	DFT		15°C	23°C	35°C
Interprotect*	110 microns	50 microns	Min	36 hrs	24 hrs	24 hrs
			Max	3 mths	3 mths	3 mths
Interfill 830*	20,000 microns	20,000 microns	Min	6 hrs	5 hrs	4 hrs
			Max	-	-	-
Interfill 833*	3,000 microns	3,000 microns	Min	3 days	2 days	1 day
			Max	-	-	-
Interprotect*	110 microns	50 microns	Min	5 hrs	3hrs	2 hrs
			Max	6 mths	6 mths	6 mths
Polyurethane Basecoat	75 microns	38 microns	Min	16 hrs	10 hrs	8 hrs
			Max	3 days	2 days	1 day
Polyurethane Basecoat	75 microns	38 microns	Min	16 hrs	10 hrs	8 hrs
			Max	3 days	2 days	1 day
Perfection	75 microns	37 microns	Min	14 hrs	6 hrs	4 hrs
			Max	3 days	2 days	1 day
Perfection	75 microns	37 microns	Min	14 hrs	6 hrs	4 hrs
			Max	3 days	2 days	1 day
Perfection	75 microns	37 microns	Min	14 hrs	6 hrs	4 hrs
			Max	3 days	2 days	1 day

\* coatings are optional for GRP

### Advisor Notes

- Prepare the substrate in accordance with the Surface Preparation details as outlined in the Perfection Application Manual and Product Datasheets.
- Apply 1-2 coats of **Interprotect** depending on condition of substrate. Sand with 280 – 320 grade paper. Remove sanding debris. (Note: should filling be required this should be undertaken with **Interfill 830** and/or **Interfill 833** between coats of primer)
- Apply 1-2 coats of **Interprotect** depending on condition of substrate. Sand with 280 – 320 grade paper. Remove sanding debris.
- Apply two coats of **Polyurethane Basecoat** by brush/roller.
- Apply 2-3 coats of **Perfection** by brush/roller. Recommendations for brush/roller application are outlined in the Perfection Application Manual.

# Aluminium

Specification code	Vessel Area	Product utilisation	Application method
<b>SYA41.0(eu/na)</b>	Topsides & Superstructure	Interprime 820/Interfill 830/Interfill 833 Interprime 880 (2x) and Perfection (2-3x)	Pressure & Conventional Spray
<b>SYA48.0(eu/na)</b>	Topsides & Superstructure	Interprime 820/Interfill 830/Interfill 835 Interprime 880 (2x) and Perfection (2-3x)	Pressure & Conventional Spray
<b>SYA49.0(eu/na)</b>	Masts	Interprime 820//Interfill 833 Interprime 880 (2x) and Perfection (2-3x)	Pressure & Conventional Spray
<b>SYA65.0(eu)</b>	Topsides & Superstructure	Etch Primer/Interprotect/ Interfill 830/ Interfill 833/Interprotect (3x) Perfection Undercoat (2x) and Perfection (2-3x)	Brush / Roller

**Alternative specifications available on request. Consult your local Technical Representative.**

**Note: Specifications coded "eu/na" use product available in Europe and North America whilst the specification coded "eu" uses a product only available in Europe.**



## Aluminium: Topsides & Superstructure

High Performance Spray

### Surface Preparation

Aluminium vessels: Low pressure grit blast using aluminium oxide or an equivalent abrasive (not copper slag) or power disc to a surface profile of 50 – 75 microns/2-3- mils (NB Power wire brushing is not permitted as it is ineffective and wires are often steel, leading to corrosion).

Product Name	Thickness per coat		Sequential overcoating times			
	WFT	DFT		15°C	23°C	35°C
<b>Interprime 820</b> (thinned 15%)	160 microns	65 microns	<b>Min</b>	36 hrs	24 hrs	24 hrs
			<b>Max</b>	3 mths	3 mths	3 mths
<b>Interfill 830</b>	20,000 microns	20,000 microns	<b>Min</b>	3 days	2 days	1 day
			<b>Max</b>	-	-	-
<b>Interfill 833</b>	3,000 microns	3,000 microns	<b>Min</b>	3 days	2 days	1 day
			<b>Max</b>	-	-	-
<b>Interprime 880</b>	250 microns	100 microns	<b>Min</b>	1hr	1 hr	1 hr
			<b>Max</b>	7 days	7 days	7 days
<b>Interprime 880</b>	250 microns	100 microns	<b>Min</b>	1hr	1 hr	1 hr
			<b>Max</b>	7 days	7 days	7 days
<b>Perfection</b>	50 microns	25 microns	<b>Min</b>	14 hrs	6 hrs	4 hrs
			<b>Max</b>	3 days	2 days	1 day
<b>Perfection</b>	75 microns	37 microns	<b>Min</b>	14 hrs	6 hrs	4 hrs
			<b>Max</b>	3 days	2 days	1 day
<b>Perfection</b>	75 microns	37 microns	<b>Min</b>	14 hrs	6 hrs	4 hrs
			<b>Max</b>	3 days	2 days	1 day

### Advisor Notes

- Prepare the substrate in accordance with the Surface Preparation details as outlined in the Perfection Application Manual and Product Datasheets.
- **Interprime 820 (thinned 15%)** should be used as a holding primer to freshly prepared substrate.
- Fill as required with **Interfill 830** up to a maximum depth of 2 centimetres per single application. Sand with 40 – 80 grade paper. Remove sanding debris before proceeding.
- If minor regularities remain they should be filled with **Interfill 833** as part of the refining process. Sand with 180 – 240 grade paper. Remove sanding debris before proceeding.
- Apply two coats of **Interprime 880** to the DFT specified on the product datasheet. Sand with 320 – 400 grade paper to obtain a smooth surface. Remove sanding debris before proceeding.
- Apply 2-3 coats of **Perfection** by conventional spray to obtain a full gloss. Spray details are outlined in the Perfection Application Manual.

Specification SYA41.0eu/na-f



## Aluminium: Topsides & Superstructure

High Performance Spray

### Surface Preparation

Aluminium vessels: Low pressure grit blast using aluminium oxide or an equivalent abrasive (not copper slag) or power disc to a surface profile of 50 – 75 microns/2-3- mils (NB Power wire brushing is not permitted as it is ineffective and wires are often steel, leading to corrosion).

Product Name	Thickness per coat		Sequential overcoating times			
	WFT	DFT		15°C	23°C	35°C
<b>Interprime 820</b> (thinned 15%)	160 microns	65 microns	<b>Min</b>	36 hrs	24 hrs	24 hrs
			<b>Max</b>	3 mths	3 mths	3 mths
<b>Interfill 830</b>	20,000 microns	20,000 microns	<b>Min</b>	3 days	2 days	1 day
			<b>Max</b>	-	-	-
<b>Interfill 835</b>	800 microns	500 microns	<b>Min</b>	3 days	24 hrs	24 hrs
			<b>Max</b>	-	-	-
<b>Interprime 880</b>	250 microns	100 microns	<b>Min</b>	1hr	1 hr	1 hr
			<b>Max</b>	7 days	7 days	7 days
<b>Interprime 880</b>	250 microns	100 microns	<b>Min</b>	1hr	1 hr	1 hr
			<b>Max</b>	7 days	7 days	7 days
<b>Perfection</b>	50 microns	25 microns	<b>Min</b>	14 hrs	6 hrs	4 hrs
			<b>Max</b>	3 days	2 days	1 day
<b>Perfection</b>	75 microns	37 microns	<b>Min</b>	14 hrs	6 hrs	4 hrs
			<b>Max</b>	3 days	2 days	1 day
<b>Perfection</b>	75 microns	37 microns	<b>Min</b>	14 hrs	6 hrs	4 hrs
			<b>Max</b>	3 days	2 days	1 day

### Advisor Notes

- Prepare the substrate in accordance with the Surface Preparation details as outlined in the Perfection Application Manual and Product Datasheets.
- **Interprime 820 (thinned 15%)** should be used as a holding primer to freshly prepared substrate.
- Fill as required with **Interfill 830** up to a maximum depth of 2 centimetres per single application. Sand with 40 – 80 grade paper. Remove sanding debris before proceeding.
- Undertake any refining of the filler using **Interfill 835** to remove small imperfections that remain after major filling is completed. Sand with 180- 240 grade paper. Remove sanding debris before proceeding.
- Apply two coats of **Interprime 880** to the DFT specified on the product datasheet. Sand with 320 – 400 grade paper to obtain a smooth surface. Remove sanding debris before proceeding.
- Apply 2 –3 coats of **Perfection** by conventional spray to obtain a full gloss. Spray details are outlined in the Perfection Application Manual.



## Aluminium: Masts & Spars

High Performance Spray

### Surface Preparation

Chemical pre-treatment of aluminium using acid etch and de-oxidising rinse.

Product Name	Thickness per coat		Sequential overcoating times			
	WFT	DFT		59°F	73°F	95°F
<b>Interprime 820</b> (thinned 15%)	160 microns	65 microns	<b>Min</b>	36 hrs	24 hrs	24 hrs
			<b>Max</b>	3 mths	3 mths	3 mths
<b>Interfill 833</b>	3,000 microns	3,000 microns	<b>Min</b>	3 days	2 days	1 day
			<b>Max</b>	-	-	-
<b>Interprime 880</b>	250 microns	100 microns	<b>Min</b>	1hr	1 hr	1 hr
			<b>Max</b>	7 days	7 days	7 days
<b>Interprime 880</b>	250 microns	100 microns	<b>Min</b>	1hr	1 hr	1 hr
			<b>Max</b>	7 days	7 days	7 days
<b>Perfection</b>	50 microns	25 microns	<b>Min</b>	14 hrs	6 hrs	4 hrs
			<b>Max</b>	3 days	2 days	1 day
<b>Perfection</b>	75 microns	37 microns	<b>Min</b>	14 hrs	6 hrs	4 hrs
			<b>Max</b>	3 days	2 days	1 day
<b>Perfection</b>	75 microns	37 microns	<b>Min</b>	14 hrs	6 hrs	4 hrs
			<b>Max</b>	3 days	2 days	1 day

### Advisor Notes

- Prepare the substrate in accordance with the Surface Preparation details as outlined in the Perfection Application Manual and Product Datasheets.
- **Interprime 820 (thinned 15%)** should be used as a holding primer to freshly prepared substrate.
- Fill as required with **Interfill 833**. Sand with 180 – 240 grade paper. Remove sanding debris before proceeding.
- Apply two coats of **Interprime 880** to the DFT specified on the product datasheet. Sand with 320 – 400 grade paper to obtain a smooth surface. Remove sanding debris before proceeding.
- Apply 2 –3 coats of **Perfection** by conventional spray to obtain a full gloss. Spray details are outlined in the Perfection Application Manual.



## Aluminium: Topsides & Superstructure

High Performance brush/roller application

### Surface Preparation

Chemical pre-treatment following disc grind preparation of aluminium using acid etch primer.

Product Name	Thickness per coat		Sequential overcoating times			
	WFT	DFT		15°C	23°C	35°C
Etch Primer	50 microns	4.5 microns	Min	1 hr	1 hr	1 hr
			Max	24 hrs	24 hrs	24 hrs
Interprotect	110 microns	50 microns	Min	36 hrs	24 hrs	24 hrs
			Max	3 mths	3 mths	3 mths
Interfill 830	20,000 microns	20,000 microns	Min	6 hrs	5 hrs	4 hrs
			Max	-	-	-
Interfill 833	3,000 microns	3,000 microns	Min	3 days	2 days	1 day
			Max	-	-	-
Interprotect	110 microns	50 microns	Min	5 hrs	3 hrs	2 hrs
			Max	6 mths	6 mths	6 mths
Interprotect	110 microns	50 microns	Min	5 hrs	3 hrs	2 hrs
			Max	6 mths	6 mths	6 mths
Interprotect	110 microns	50 microns	Min	5 hrs	3 hrs	2 hrs
			Max	3 days	2 days	1 day
Polyurethane Basecoat	75 microns	38 microns	Min	16 hrs	10 hrs	8 hrs
			Max	3 days	2 days	1 day
Polyurethane Basecoat	75 microns	38 microns	Min	16 hrs	10 hrs	8 hrs
			Max	3 days	2 days	1 day
Perfection	75 microns	37 microns	Min	14 hrs	6 hrs	4 hrs
			Max	3 days	2 days	1 day
Perfection	75 microns	37 microns	Min	14 hrs	6 hrs	4 hrs
			Max	3 days	2 days	1 day
Perfection	75 microns	37 microns	Min	14 hrs	6 hrs	4 hrs
			Max	3 days	2 days	1 day

### Advisor Notes

- Prepare the substrate in accordance with the Surface Preparation details as outlined in the Perfection Application Manual and Product Datasheets.
- Apply 1-2 coats of **Interprotect** depending on condition of substrate. Sand with 280 –320 grade paper. Remove sanding debris. (Note: should filling be required this should be undertaken with **Interfill 830** and /or **Interfill 833** between coats of primer)
- Apply 1-2 coats of **Interprotect** depending on condition of substrate. Sand with 280 –320 grade paper. Remove sanding debris.
- Apply 1-2 coats of **Polyurethane Basecoat** depending on condition of substrate. Sand with 320 - 400 grade paper. Remove sanding debris.
- Apply 2 –3 coats of **Perfection** by brush/roller. Recommendations for brush/roller application are outlined in the Perfection Application Manual.

# Steel

Specification code	Vessel Area	Product utilisation	Application method
<b>SYS49.0(eu/na)</b>	Topsides & Superstructure	Interprime 820/Interfill 830/Interfill 835 Interprime 880 (2x) and Perfection (2-3x)	Pressure & Conventional Spray
<b>SYS53.0(eu/na)</b>	Topsides & Superstructure	Interprime 820/Interfill 830/Interfill 833 Interprime 880 (2x) and Perfection (2-3x)	Pressure & Conventional Spray
<b>SYS65.0(eu)</b>	Topsides & Superstructure	Etch Primer/ Interprotect/ Interfill 830 and/or Interfill 833 / Interprotect (3x) / Polyurethane Basecoat(2x) and Perfection (2 -3x)	Brush / Roller

**Alternative specifications available on request. Consult your local Technical Representative.**

**Note: Specifications coded "eu/na" use product available in Europe and North America whilst the specification coded "eu" uses a product only available in Europe.**





## Steel: Topsides & Superstructure

High Performance Spray

### Surface Preparation

Steel: Blast to near white metal SSPC-SP10 or Sa2.5 of SIS 05 59 00 (ISO8501-1). Power tool clean all welds, damages, corroded areas and intact shop primer to SSPC-SP3 or Pt3 of JSRA SPSS-1975 or ST3 of SIS 05 09 00 (ISO8501-1)

Product Name	Thickness per coat		Sequential overcoating times			
	WFT	DFT		15°C	23°C	35°C
<b>Interprime 820</b> (thinned 15%)	160 microns	65 microns	<b>Min</b>	36 hrs	24 hrs	24 hrs
			<b>Max</b>	3 mths	3 mths	3 mths
<b>Interfill 830</b> <b>Standard Cure</b>	20,000 microns	20,000 microns	<b>Min</b>	3 days	2 days	1 day
			<b>Max</b>	-	-	-
<b>Interfill 835</b>	800 microns	500 microns	<b>Min</b>	3 days	24 hrs	24 hrs
			<b>Max</b>	-	-	-
<b>Interprime 880</b>	250 microns	100 microns	<b>Min</b>	1 hr	1 hr	1 hr
			<b>Max</b>	7 days	7 days	7 days
<b>Interprime 880</b>	250 microns	100 microns	<b>Min</b>	1 hr	1 hr	1 hr
			<b>Max</b>	7 days	7 days	7 days
<b>Perfection</b>	50 microns	25 microns	<b>Min</b>	14 hrs	6 hrs	4 hrs
			<b>Max</b>	3 days	2 days	1 day
<b>Perfection</b>	75 microns	37 microns	<b>Min</b>	14 hrs	6 hrs	4 hrs
			<b>Max</b>	3 days	2 days	1 day
<b>Perfection</b>	75 microns	37 microns	<b>Min</b>	14 hrs	6 hrs	4 hrs
			<b>Max</b>	3 days	2 days	1 day

### Advisor Notes

- Prepare the substrate in accordance with the Surface Preparation details as outlined in the Perfection Application Manual and Product Datasheets.
- **Interprime 820 (thinned 15%)** should be used as a holding primer to freshly prepared substrate.
- Fill as required with **Interfill 830** up to a maximum depth of 2 centimetres per single application. Sand with 40 – 80 grade paper. Remove sanding debris before proceeding.
- Undertake any refining of the filler using **Interfill 835** to remove small imperfections that remain after major filling is completed. Sand with 180-240 grade paper. Remove sanding debris before proceeding.
- Apply two coats of **Interprime 880** to the DFT specified on the product datasheet. Sand with 320 – 400 grade paper to obtain a smooth surface. Remove sanding debris before proceeding.
- Apply two coats of **Perfection** by conventional spray to obtain a full gloss. Spray details are outlined in the Perfection Application Manual.



## Steel: Topsides & Superstructure

High Performance Spray

### Surface Preparation

Steel: Blast to near white metal SSPC-SP10 or Sa2.5 of SIS 05 59 00 (ISO8501-1). Power tool clean all welds, damages, corroded areas and intact shop primer to SSPC-SP3 or Pt3 of JSRA SPSS-1975 or ST3 of SIS 05 09 00 (ISO8501-1)

Product Name	Thickness per coat		Sequential overcoating times			
	WFT	DFT		15°C	23°C	35°C
<b>Interprime 820</b> (thinned 15%)	160 microns	65 microns	<b>Min</b>	36 hrs	24 hrs	24 hrs
			<b>Max</b>	3 mths	3 mths	3 mths
<b>Interfill 830</b>	20,000 microns	20,000 microns	<b>Min</b>	3 days	2 days	1 day
			<b>Max</b>	-	-	-
<b>Interfill 833</b>	3,000 microns	3,000 microns	<b>Min</b>	3 days	2 days	1 day
			<b>Max</b>	-	-	-
<b>Interprime 880</b>	250 microns	100 microns	<b>Min</b>	1hr	1 hr	1 hr
			<b>Max</b>	7 days	7 days	7 days
<b>Interprime 880</b>	250 microns	100 microns	<b>Min</b>	1hr	1 hr	1 hr
			<b>Max</b>	7 days	7 days	7 days
<b>Perfection</b>	50 microns	25 microns	<b>Min</b>	14 hrs	6 hrs	4 hrs
			<b>Max</b>	3 days	2 days	1 day
<b>Perfection</b>	75 microns	37 microns	<b>Min</b>	14 hrs	6 hrs	4 hrs
			<b>Max</b>	3 days	2 days	1 day
<b>Perfection</b>	75 microns	37 microns	<b>Min</b>	14 hrs	6 hrs	4 hrs
			<b>Max</b>	3 days	2 days	1 day

### Advisor Notes

- Prepare the substrate in accordance with the Surface Preparation details as outlined in the Perfection Application Manual and Product Datasheets.
- **Interprime 820 (thinned 15%)** should be used as a holding primer to freshly prepared substrate.
- Fill as required with **Interfill 830** up to a maximum depth of 2 centimetres per single application. Sand with 40 – 80 grade paper. Remove sanding debris before proceeding.
- If minor regularities remain they should be filled with **Interfill 833** as part of the refining process. Sand with 180 – 240 grade paper. Remove sanding debris before proceeding.
- Apply two coats of **Interprime 880** to the DFT specified on the product datasheet. Sand with 320 – 400 grade paper to obtain a smooth surface. Remove sanding debris before proceeding.
- Apply two coats of **Perfection** by conventional spray to obtain a full gloss. Spray details are outlined in the Perfection Application Manual.



## Steel: Topsides & Superstructure

High Performance brush/roller application

### Surface Preparation

Steel: Power tool clean all welds, damages, corroded areas and intact shop primer to SSPC-SP3 or Pt3 of JSRA SPSS-1975 or ST3 of SIS 05 09 00 (ISO8501-1)

Product Name	Thickness per coat		Sequential overcoating times			
	WFT	DFT		15°C	23°C	35°C
Interprotect	110 microns	65 microns	Min	36 hrs	24 hrs	24 hrs
			Max	3 mths	3 mths	3 mths
Interfill 830	20,000 microns	20,000 microns	Min	3 days	2 days	1 day
			Max	-	-	-
Interfill 833	3,000 microns	3,000 microns	Min	3 days	2 days	1 day
			Max	-	-	-
Interprotect	110 microns	65 microns	Min	5 hrs	3 hrs	2 hrs
			Max	6 mths	6 mths	6 mths
Interprotect	110 microns	50 microns	Min	5 hrs	3 hrs	2 hrs
			Max	6 mths	6 mths	6mths
Interprotect	110 microns	50 microns	Min	5 hrs	3 hrs	2 hrs
			Max	3 days	2 days	1 day
Polyurethane Basecoat	75 microns	38 microns	Min	16 hrs	10 hrs	8 hrs
			Max	3 days	2 days	1 day
Polyurethane Basecoat	75 microns	38 microns	Min	16 hrs	10 hrs	8 hrs
			Max	3 days	2 days	1 day
Perfection	75 microns	37 microns	Min	14 hrs	6 hrs	4 hrs
			Max	3 days	2 days	1 day
Perfection	75 microns	37 microns	Min	14 hrs	6 hrs	4 hrs
			Max	3 days	2 days	1 day
Perfection	75 microns	37 microns	Min	14 hrs	6 hrs	4 hrs
			Max	3 days	2 days	1 day

### Advisor Notes

- Prepare the substrate in accordance with the Surface Preparation details as outlined in the Perfection Application Manual and Product Datasheets.
- Apply 1-2 coats of **Interprotect** depending on condition of substrate. Sand with 280 – 320 grade paper. Remove sanding debris. (**Note:** should filling be required this should be undertaken with **Interfill 830** and/or **Interfill 833** between coats of primer)
- Apply 1-2 coats of **Interprotect** depending on condition of substrate. Sand with 280 – 320 grade paper. Remove sanding debris.
- Apply two coats of **Perfection Undercoat** by brush/roller.
- Apply 2 -3 coats of **Perfection** by brush/roller. Recommendations for brush/roller application are outlined in the Perfection Application Manual.

# Wood

Specification code	Vessel Area	Product utilisation	Application method
<b>SYW11.0(eu/na)</b>	Topsides & Superstructure	Interprime 820/Interfill 830/Interfill 833 Interprime 880 (2x) and Perfection (2-3x)	Pressure & Conventional Spray
<b>SYW15.0(eu/na)</b>	Masts	Interprime 880 (2x) and Perfection (2x)	Pressure & Conventional Spray
<b>SYW18.0(eu/na)</b>	Masts	Interprime 820/Interfill 833 Interprime 880 (2x) and Perfection (2x)	Pressure & Conventional Spray
<b>SYW33.0(eu/na)</b>	Topsides & Superstructure	Interprime 820/Interfill 830/Interfill 835 Interprime 880 (2x) and Perfection (2-3x)	Pressure & Conventional Spray
<b>SYW3.0(eu)</b>	Topsides & Superstructure	Interprotect/ Interfill 830 and/or Interfill 833/ Interprotect (2x) / Polyurethane Basecoat (2x) and Perfection (2-3x)	Brush / Roller

**Alternative specifications available on request. Consult your local Technical Representative.**

**Note: Specifications coded "eu/na" use product available in Europe and North America whilst the specification coded "eu" uses a product only available in Europe.**



## Wood: Topsides & Superstructure

High Performance Spray

### Surface Preparation

Sand wood thoroughly with 180 – 280 grade paper. Ensure the surface is wiped clean with a cloth soaked in Interspray solvent, or other suitable fast solvent and allow to dry.

Product Name	Thickness per coat		Sequential overcoating times			
	WFT	DFT		15°C	23°C	35°C
<b>Interprime 820</b> (thinned 15%)	160 microns	65 microns	<b>Min</b>	36 hrs	24 hrs	24 hrs
			<b>Max</b>	3 mths	3 mths	3 mths
<b>Interfill 830</b>	20,000 microns	20,000 microns	<b>Min</b>	3 days	2 days	1 day
			<b>Max</b>	-	-	-
<b>Interfill 833</b>	3,000 microns	3,000 microns	<b>Min</b>	3 days	2 days	1 day
			<b>Max</b>	-	-	-
<b>Interprime 880</b>	250 microns	100 microns	<b>Min</b>	1 hr	1 hr	1 hr
			<b>Max</b>	7 days	7 days	7 days
<b>Interprime 880</b>	250 microns	100 microns	<b>Min</b>	1 hr	1 hr	1 hr
			<b>Max</b>	7 days	7 days	7 days
<b>Perfection</b>	50 microns	25 microns	<b>Min</b>	14 hrs	6 hrs	4 hrs
			<b>Max</b>	3 days	2 days	1 day
<b>Perfection</b>	75 microns	37 microns	<b>Min</b>	14 hrs	6 hrs	4 hrs
			<b>Max</b>	3 days	2 days	1 day
<b>Perfection</b>	75 microns	37 microns	<b>Min</b>	14 hrs	6 hrs	4 hrs
			<b>Max</b>	3 days	2 days	1 day

### Advisor Notes

- Prepare the substrate in accordance with the Surface Preparation details as outlined in the Perfection Application Manual and Product Datasheets.
- **Interprime 820 (thinned 15%)** should be used as a holding primer to freshly prepared substrate.
- Fill as required with **Interfill 830** up to a maximum depth of 2 centimetres per single application. Sand with 40 – 80 grade paper. Remove sanding debris before proceeding.
- If minor regularities remain they should be filled with **Interfill 833** as part of the refining process. Sand with 180 – 240 grade paper. Remove sanding debris before proceeding.
- Apply two coats of **Interprime 880** to the DFT specified on the product datasheet. Sand with 320 – 400 grade paper to obtain a smooth surface. Remove sanding debris before proceeding.
- Apply 2-3 coats of **Perfection** by conventional spray to obtain a full gloss. Spray details are outlined in the Perfection Application Manual.



## Wood: Masts & Spars

High Performance Spray

### Surface Preparation

Sand wood thoroughly with 180 – 280 grade paper. Ensure the surface is wiped clean with a cloth soaked in Interspray solvent, or other suitable fast solvent and allow to dry.

Product Name	Thickness per coat		Sequential overcoating times			
	WFT	DFT		15°C	23°C	35°C
<b>Interprime 820</b> (thinned 15%)	160 microns	65 microns	<b>Min</b>	36 hrs	24 hrs	24 hrs
			<b>Max</b>	3 mths	3 mths	3 mths
<b>Interprime 880</b>	250 microns	100 microns	<b>Min</b>	1 hr	1 hr	1 hr
			<b>Max</b>	7 days	7 days	7 days
<b>Interprime 880</b>	250 microns	100 microns	<b>Min</b>	1hr	1 hr	1 hr
			<b>Max</b>	7 days	7 days	7 days
<b>Perfection</b>	50 microns	25 microns	<b>Min</b>	14 hrs	6 hrs	4 hrs
			<b>Max</b>	3 days	2 days	1 day
<b>Perfection</b>	75 microns	37 microns	<b>Min</b>	14 hrs	6 hrs	4 hrs
			<b>Max</b>	3 days	2 days	1 day
<b>Perfection</b>	75 microns	37 microns	<b>Min</b>	14 hrs	6 hrs	4 hrs
			<b>Max</b>	3 days	2 days	1 day

### Advisor Notes

- Prepare the substrate in accordance with the Surface Preparation details as outlined in the Perfection Application Manual and Product Datasheets.
- **Interprime 820 (thinned 15%)** should be used as a holding primer to freshly prepared substrate.
- Apply two coats of **Interprime 880** to the DFT specified on the product datasheet. Sand with 320 – 400 grade paper to obtain a smooth surface. Remove sanding debris before proceeding.
- Apply 2-3 coats of **Perfection** by conventional spray to obtain a full gloss. Spray details are outlined in the Perfection Application Manual.



## Wood: Masts & Spars

High Performance Spray

### Surface Preparation

Sand wood thoroughly with 180 – 280 grade paper. Ensure the surface is wiped clean with a cloth soaked in Interspray solvent, or other suitable fast solvent and allow to dry.

Product Name	Thickness per coat		Sequential overcoating times			
	WFT	DFT		15°C	23°C	35°C
<b>Interprime 820</b> (thinned 15%)	160 microns	65 microns	<b>Min</b>	36 hrs	24 hrs	24 hrs
			<b>Max</b>	3 mths	3 mths	3 mths
<b>Interfill 833</b>	3,000 microns	3,000 microns	<b>Min</b>	3 days	2 days	1 day
			<b>Max</b>	-	-	-
<b>Interprime 880</b>	250 microns	100 microns	<b>Min</b>	1hr	1 hr	1 hr
			<b>Max</b>	7 days	7 days	7 days
<b>Interprime 880</b>	250 microns	100 microns	<b>Min</b>	1hr	1 hr	1 hr
			<b>Max</b>	7 days	7 days	7 days
<b>Perfection</b>	50 microns	25 microns	<b>Min</b>	14 hrs	6 hrs	4 hrs
			<b>Max</b>	3 days	2 days	1 day
<b>Perfection</b>	75 microns	37 microns	<b>Min</b>	14 hrs	6 hrs	4 hrs
			<b>Max</b>	3 days	2 days	1 day
<b>Perfection</b>	75 microns	37 microns	<b>Min</b>	14 hrs	6 hrs	4 hrs
			<b>Max</b>	3 days	2 days	1 day

### Advisor Notes

- Prepare the substrate in accordance with the Surface Preparation details as outlined in the Perfection Application Manual and Product Datasheets.
- **Interprime 820 (thinned 15%)** should be used as a holding primer to freshly prepared substrate.
- Fill as required with **Interfill 833**. Sand with 180 – 240 grade paper. Remove sanding debris before proceeding.
- Apply two coats of **Interprime 880** to the DFT specified on the product datasheet. Sand with 320 – 400 grade paper to obtain a smooth surface. Remove sanding debris before proceeding.
- Apply 2-3 coats of **Perfection** by conventional spray to obtain a full gloss. Spray details are outlined in the Perfection Application Manual.



## Wood: Topsides & Superstructure

High Performance Spray

### Surface Preparation

Sand wood thoroughly with 180 – 280 grade paper. Ensure the surface is wiped clean with a cloth soaked in Interspray solvent, or other suitable fast solvent and allow to dry.

Product Name	Thickness per coat		Sequential overcoating times			
	WFT	DFT		15°C	23°C	35°C
<b>Interprime 820</b> (thinned 15%)	160 microns	65 microns	<b>Min</b>	36 hrs	24 hrs	24 hrs
			<b>Max</b>	3 mths	3 mths	3 mths
<b>Interfill 830</b>	3,000 microns	3,000 microns	<b>Min</b>	3 days	2 days	1 day
			<b>Max</b>	-	-	-
<b>Interfill 835</b>	800 microns	500 microns	<b>Min</b>	3 days	24 hrs	24 hrs
			<b>Max</b>	-	-	-
<b>Interprime 880</b>	250 microns	100 microns	<b>Min</b>	1hr	1 hr	1 hr
			<b>Max</b>	7 days	7 days	7 days
<b>Interprime 880</b>	250 microns	100 microns	<b>Min</b>	1hr	1 hr	1 hr
			<b>Max</b>	7 days	7 days	7 days
<b>Perfection</b>	50 microns	25 microns	<b>Min</b>	14 hrs	6 hrs	4 hrs
			<b>Max</b>	3 days	2 days	1 day
<b>Perfection</b>	75 microns	37 microns	<b>Min</b>	14 hrs	6 hrs	4 hrs
			<b>Max</b>	3 days	2 days	1 day
<b>Perfection</b>	75 microns	37 microns	<b>Min</b>	14 hrs	6 hrs	4 hrs
			<b>Max</b>	3 days	2 days	1 day

### Advisor Notes

- Prepare the substrate in accordance with the Surface Preparation details as outlined in the Perfection Application Manual and Product Datasheets.
- **Interprime 820 (thinned 15%)** should be used as a holding primer to freshly prepared substrate.
- Fill as required with **Interfill 830** up to a maximum depth of 2 centimetres per single application. Sand with 40 – 80 grade paper. Remove sanding debris before proceeding.
- Undertake any refining of the filler using **Interfill 835** to remove small imperfections that remain after major filling is completed. Sand with 180 - 240 grade paper. Remove sanding debris before proceeding.
- Apply two coats of **Interprime 880** to the DFT specified on the product datasheet. Sand with 320 – 400 grade paper to obtain a smooth surface. Remove sanding debris before proceeding.
- Apply 2-3 coats of **Perfection** by conventional spray to obtain a full gloss. Spray details are outlined in the Perfection Application Manual.





## Wood: Topsides & Superstructure

High Performance brush/roller application

### Surface Preparation

Sand wood thoroughly with 180 – 280 grade paper. Ensure the surface is wiped clean with a cloth soaked in Interspray solvent, or other suitable fast solvent and allow to dry.

Product Name	Thickness per coat		Sequential overcoating times			
	WFT	DFT		15°C	23°C	35°C
Interprotect	110 microns	50 microns	Min	36 hrs	24 hrs	24 hrs
			Max	3 mths	3 mths	3mths
Interfill 830	20,000 microns	20,000 microns	Min	3days	2 days	1day
			Max	-	-	-
Interfill 833	3,000 microns	3,000 microns	Min	3 days	2 days	1 day
			Max	-	-	-
Interprotect	110 microns	50 microns	Min	5 hrs	3 hrs	2 hrs
			Max	6 mths	6 mths	6 mths
Interprotect	110 microns	50 microns	Min	5 hrs	3 hrs	2 hrs
			Max	3 days	2 days	1 day
Perfection Undercoat	75 microns	38 microns	Min	16 hrs	10 hrs	8 hrs
			Max	3 days	2 days	1 day
Perfection Undercoat	75 microns	38 microns	Min	16 hrs	10 hrs	8 hrs
			Max	3 days	2 days	1 day
Perfection	75 microns	37 microns	Min	14 hrs	6 hrs	4 hrs
			Max	3 days	2 days	1 day
Perfection	75 microns	37 microns	Min	14 hrs	6 hrs	4 hrs
			Max	3 days	2 days	1 day
Perfection	75 microns	37 microns	Min	14 hrs	6 hrs	4 hrs
			Max	3 days	2 days	1 day

### Advisor Notes

- Prepare the substrate in accordance with the Surface Preparation details as outlined in the Perfection Application Manual and Product Datasheets.
- Apply 1-2 coats of **Interprotect** depending on condition of substrate. Sand with 280 – 320 grade paper. Remove sanding debris. Note: should filling be required this should be undertaken with Interfill **830** and/or **Interfill 833** between coats of primer
- Apply 1-2 coats of **Interprotect** depending on condition of substrate. Sand with 280 – 320 grade paper. Remove sanding debris
- Apply two coats of **Polyurethane Basecoat** by brush/roller
- Apply 2 –3 coats of **Perfection** by brush/roller. Recommendations for brush/roller application are outlined in the Perfection Application Manual.

Specification SYW3.0eu-f

