



A High Performance Clear Coating Scheme for Wooden Boats

Where the Scheme is Applicable

This scheme is recommended for finishing all bare surfaces of plywood, solid timber and laminated stock of decks, hulls and interiors or for other wood surfaces where a high build quality and lasting clear finish is required. The scheme is particularly suited to finishing decorative plywood surfaces of decks which require the highest resistance to deterioration from abrasion and weathering.

The scheme is unsuitable for boats of traditional construction and for application over existing varnish finishes.

The essential elements of the scheme are:

- To fully encapsulate and stabilise bare wood surfaces with a waterproof epoxy 'membrane'.
- To finish with a two-pack polyurethane varnish.

The Products and their Functions

Product	Description	Function
SP 320	Clear, solvent-free epoxy.	Serves as a clear, highly adhesive, thick application primer. The most convenient and economical way to fill the grain and provide a waterproof barrier.
SP Microballoons and SP Colloidal Silica	Filler ingredients available separately.	When added to mixed SP 320 epoxy system, creates low density, non-sag filler mixes which blend in with the colour of mahogany, are easy to sand and inexpensive.
SP Ultravar 2000	Clear two-pack polyurethane varnish.	To protect the underlying wood and epoxy coating from the damaging effects of ultra-violet radiation and to give a long lasting high quality gloss surface finish.

Clear Coating Schedule

This can commence once all filling (of all screw holes, etc) has been completed.

Day	Activity	Notes
Day One	Apply 2 coats of SP 320 by brush 'wet-on-tacky' - i.e. apply 2nd coat when 1st coat is gelled, but not hard.	If roller is used compensate thickness with additional coat: 2 brushed coats often sufficient for decks; 3 coats for hulls or heavy duty applications.
Day Two	Day for Curing	Cure at elevated temperature if possible to shorten cure time - 21°C to 25°C is ideal.
Day Three	If surface is sufficiently hard, sand first with 180 grit wet or dry paper used wet to obtain a perfectly flat finish then 240 and 280 grit wet paper. Wash with clean fresh water and dry. Finish with dry 280 grit paper. Remove dust then wipe with SP Solvent E (SP Ultravar 2000 Brushing Solvent). Apply one or two coats of SP Ultravar 2000.	Use Solvent wipe to test for surface cleanliness and coating clarity before varnish application. Apply by brush, foam roller or spray. Observe recommended overcoating interval. Thin Ultravar 2000 using either SP Solvent E for brushing or SP Solvent H for Spraying the product.
Day Four	Day for curing	
Day Five	Sand with 320 grit wet or dry paper used wet, then wipe with Ultravar 2000 Brushing Solvent. Apply second and third coats of Ultravar 2000.	

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SP Systems therefore strongly recommend that representative test panels and component sections are built and tested by the user in order to define the best process and materials to use for the desired component. This should be done under conditions as close as possible to those that will be used on the final component.

SP Systems' guides are being continuously reviewed and updated. Please ensure that you have the current version before using the product, by contacting SP Systems' Marketing Services and quoting the revision number in the bottom left-hand corner of this page.

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