International

Perfection® Pro

Application Guide

AkzoNobel

Perfection Pro®

Application Manual

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1. Overview

Perfection Pro is a linear high performance polyester based two pack polyurethane that can be rolled, brushed or sprayed.

Perfection Pro is available in a wide range of colours for Professional application only. The revolutionary colour mixing system provides concentrated colorants that are then mixed with binders to create Perfection Pro.

There are two versions of Perfection Pro available, a brush & roller binder specifically optimised for easy application using traditional methods and a spray binder, specifically developed for air atomised spray application.

The mixing ratio of all Perfection Pro products with the curing agent is 2:1 by volume.

2. Surface Preparation

Good Surface Preparation is essential if the full potential of high performance epoxy schemes is to be realised.

Before commencing application of Perfection Pro it is vital that correct surface preparations have been carried out as described in the Professional Application Manual and Product Data Sheets. To access this information visit **www.yachtpaint.com** or contact your local International Technical representative who will be happy to guide you through the preparation process for the relevant substrate.

3. Application

PERFECTION PRO BRUSH & ROLLER BINDER

Perfection Pro Brush & Roller Binder has been specifically optimised to eliminate aeration during mixing and application. The tailored solvent blend has been developed to increase flow and improve wet edge time to make application easier.

While the product may be brush applied, exceptional finishes have been observed when applied by roller only. High density, solvent resistant foam rollers have proven to give the best result, however different rollers may be used to suit individual requirements.

Once the product has been mixed 2:1 by volume with curing agent, Brushing Thinner 100 can be added up to 20% by volume of the overall mix. Most applications will only require 5–10% thinner, however in hot temperatures or where significant airflow is present, additional thinner can be added.

The first coat should be applied in a smooth, uniform coat of approximately 75–100 microns Wet Film Thickness (WFT). Care should be taken not to 'overwork' the product but to allow the paint to flow naturally. Initial flow will continue for up to 30 minutes.

It is recommended that prior to application of the second coat that the surface is finely abraded with an abrasive pad or lightly sanded with P400 to remove the gloss. Not only does this help to remove any dust inclusions but it also helps with surface wetting of the second coat. If no preparation is carried out prior to the second coat, an additional 5% of solvent may be required to help wetting out of the surface.

For most colours, two coats is sufficient to achieve full opacity, however for optimal performance and longevity it is recommend to apply a third and final coat. Aesthetically it is a good idea to lightly sand the second with P400 prior to application of the final coat. This will provide improved application properties but will also minimise the surface texture built up in the first few coats.

APPLICATION OF PERFECTION PRO BY BRUSH & ROLLER

Prior to application of Perfection Pro 1–2 coats of Perfection Undercoat (YRA003) should be applied once surface has been primed sufficiently in line with product datasheets. Perfection Undercoat (YRA003) should be mixed 3:1 by volume and allowed to stand for 20 minutes to allow bubbles to disperse. Application should be very much as for the finish coat as detailed on the following pages. The undercoat will as it cures shrink back and many application marks will reduce in size. Once cured, sand the Perfection Undercoat (YRA003) with 320–400 grade paper. Remove sanding debris. This should leave a surface suitable for the application of the Perfection Pro finish.

Having prepared the undercoat surface it is ready for application of the finishing coats of Perfection Pro. Pick a good time of the day to start. Don't paint in direct sunlight as this gives a heated substrate that in turn 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. If painting outside it is a good idea to construct a tent over the boat using a suitable tarpaulin. Arrange it to ensure that the sun is kept off the surface before, during and for the first hour or so after painting to ensure maximum flow of the product.

Do not paint if there is a wind or breeze blowing across the surface as the wet edge will be reduced and addition of retarder solvent may not suffice to keep a suitably long wet edge. On decks and other horizontal surfaces where there may be many details to cut in around, work ahead slightly by cutting in the various objects using retarder solvent added so that by the time you reach those areas with the infill painting they will still flow into the main application. Do not try and paint large areas by yourself. If using brushes for the main application change them frequently and have the unused brush rinsed in retarder solvent to free the bristles up.

Mix the components in the ratio 2:1 (2 volumes of base and 1 volume of curing agent) and stir thoroughly.

Apply the product by roller and allow to flow.

If the coverage seems very poor, wet the roller again and repeat over the same area and do not press too hard. You will find that this virtual double coating deposits more paint which will cover better.

If applying by brush, try and flow the paint on and again do not try and stretch coverage out. Perfection Pro requires a good film build of paint to enable it to flow and stretch during the curing cycle which then results in a very high gloss film. Do not try and roll the paint out as far as you can otherwise the paint film will be too thin and will not flow.

For most colours two coats of finish will suffice but occasionally with certain shades it may prove necessary to apply a third coat. Consult the product datasheet for over-coating times. Second and third coats should be applied exactly the same as the first. With the darker colours blending the finish coat and the undercoat 50/50 as a final undercoat will go some way to giving an easier colour to overcoat compared to white.

It is recommended that equipment be cleaned in International Thinner No. 100 or Thinner 910. Some items 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.

PERFECTION PRO SPRAY BINDER

Perfection Pro Spray Binder has been formulated for optimum application using air atomised spray equipment. For best results, conventional or compliant (reduced pressure) equipment should be used. High Volume Low Pressure (HVLP) equipment is unlikely to atomise the paint sufficiently to achieve a fully aesthetic finish.

After mixing 2:1 by volume with the curing agent, reduce using International Thinner 910 to a viscosity of 14–15 seconds using a DIN 4 viscosity cup. This is normally achieved with 25–33% by volume. Thinner 910 is suitable for use between 15–25ºC.

For high temperature applications (or those with increased airflow) a blend of Thinner 910 and Thinner 100 may be used. This can be adjusted to the specific environment, however for temperatures over 25ºC a blend of 75:25 (mix 75% Thinner 910 with 25% Thinner 100) is recommended. Blend the solvents together first and then reduce Perfection Pro to 14–15 seconds through a DIN 4 viscosity cup.

DRYING TIME

The curing/drying time of Perfection Pro 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, has a significant effect on solvent release and drying.

Perfection Pro 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 a slower evaporating thinner 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 are 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 Pro has been formulated to give the ultimate finish under a wide range of conditions. To allow the product to perform in hot tropical conditions, its natural curing rate has been adjusted for these conditions. Consequently, under cool 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. If accelerator is required please discuss this with your International technical advisor.

Such 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 an accelerator 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 PAINT MIXING

Choose the level of accelerator you require given the environment in which the Perfection Pro is being applied.

Mix Part A & Part B (curing agent) of the paint together and stir thoroughly. The paint should then be thinned as required (see section entitled Perfection Pro Application (Solvent Use, Viscosity & Spraying) on Page 6) to the viscosity recommended. Stand for 5 minutes to allow gases and entrapped air to escape. The selected level of accelerator should be added and thoroughly stirred in. The paint is now ready for use.

POT LIFE

The addition of accelerator decreases the pot life (working life) of Perfection Pro. 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 Pro, the pot life of the product is roughly the point at which viscosity increases to one and a half times the original. i.e. initially at 14–15 seconds DIN 4 and rising to 21–22.5 seconds. The product whilst remaining liquid would give a material, which, whilst sprayable, would normally fail to produce acceptable flow.

ACCELERATOR USE IN PERFECTION PRO

	Below 10ºC	10 – 15ºC	15 – 20ºC	20 – 25ºC	25 – 30ºC	30ºC & above
Maximum addition per 1L mixed product	Do not use below 10ºC	2.5mls	2.5mls	2.5mls	2.5mls	No addition required

- Data is based on using Awlgrip Pro-Cure X-98 or X-138.
- Less accelerator may be used but more is not recommended.
- The above levels will typically reduce dry times and pot lives by at least half and thus recoat time should be reduced by around the same factor.

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 safer. If the surface is affected then it will have to be sanded down and re-coated again.

A good rule for two pack polyurethanes is to avoid painting if humidity is above 70% and do not apply when humidity is 85% or higher.

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 airlines, 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

Avoid the temptation to apply excessive film thickness in any one session as heavy films may lead to solvent entrapment resulting in soft films and the possibility of solvent blistering at any time in the future.

Do not re-apply further paint until the previously applied product feels hard.

The main area where this has been 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. This can result in loss of gloss, loss of adhesion and a high degree of sensitivity to moisture leading to blistering especially behind squabs etc around cockpit seating areas.

PRIOR TO FINISH APPLICATION

Before any application takes place ensure the surface is thoroughly clean and all rubbing debris removed. There are as many methods for cleaning the surface as there are days in the week.

The use of tack rags can help achieve the required level of cleanliness. What must be stressed however is the level of cleanliness required to achieve quality finishes and the thoroughness required in the preparation process. Tack rags vary considerably from one manufacturer to another and only those containing minimum levels of tackiness and which have been specifically manufactured for use with 2 part polyurethanes should be used. Awlgrip can offer Tack Rags (Part No 073009) that are suited for use with two pack paints. Care should be exercised as some tack rags can leave behind a deposit leading to cissing and cratering.

Solvent wipe down may be used but again care must be exercised that the solvent used does not affect the underlying surface leading to striations showing through the newly applied paint. 600 Wipedown Solvent, International Thinners #3 and International Thinners #7 have been found to work very well on cured and sanded primers and undercoats.

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 striations evident in the surface of the dried Perfection Pro. This is most noticeable in dark colours.

If water wash down is employed the surface must be allowed to dry thoroughly otherwise humidity blisters may form under the cured finish. Care must be taken that no water is trapped behind masking paper etc that can then at a later stage run down the newly applied wet paint.

PERFECTION PRO APPLICATION (SOLVENT USE, VISCOSITY & SPRAYING)

Spray gun model, its set up with air cap and fluid nozzle, and viscosity goes 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.

VISCOSITY CONVERSIONS FOR PERFECTION PRO

Sometimes a DIN 4 cup is not available to measure the viscosity of a paint but other similar flow cups are. As other types of flow cups are slightly different in size the times measured will be different and hence a conversion chart is required to convert those times back to DIN 4 times.

Ford No 4	BS B4	DIN 4	Zahn #2
		14	14
		15	16
14		15	17
14	16	16	19
15	24	16	20
19	25	18	22
22	30	20	27
27	34	23	34
30	40	26	41
36	47	30	49

SPRAYING EQUIPMENT

When spraying Perfection Pro 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.

Suggested spray gun set up for Perfection applications

SATA 3000, 4000 or 5000 RP	Gravity	Pressure Feed
Air Cap	Matched to fluid tip	Matched to fluid tip
Fluid Tip	1.2–1.3	0.8–1.1
Air Pressure	28–35 PSI / 1.9–2.4 bar	28–35 PSI / 1.9–2.4 bar
Viscosity24	14–15 seconds DIN 4	14–15 seconds DIN 4
Fluid Flow Rate	N/A	200–250ml/min
DeVilbiss Advanced HD		
Air Cap	510+ or 520	510+, 520 or CDT
Fluid Tip	1.2–1.3	0.85–1.1
Air Pressure	28–35 PSI / 1.9–2.4 bar	28–35 PSI / 1.9–2.4 bar
Viscosity24	14–15 seconds DIN 4	14–15 seconds DIN 4
Fluid Flow Rate	N/A	200–250ml/min

DETAILING AND CHEMICALS

The chemistry of Perfection Pro provides a resin rich layer at the surface of the paint during the cure cycle and it is this layer that adds to the exterior exposure performance of the product.

Depending on how much of this clear layer is removed during detailing, exterior exposure performance in relation to gloss retention may be affected to various degrees.

It is realised that at times the finish will be spoilt by dust and dirt and that some detailing of the paint will be required and so any detailing work should be carried out with the above factors in mind.

With the Perfection chemistry there is virtually no after flow when cutting and polishing procedures are used and so such procedures as used commonly with Acrylic Polyurethanes are not recommended.

Note that acid or alkaline based materials allowed to remain in contact with Perfection Pro may lead to blooming and discolouration of the surface especially with darker colours where such effects are more obvious.

Some sunscreen products especially those based on “Nano’ technology can have a serious degrading effect on polyurethane paints and anyone using such materials should studiously avoid touching any paint work.

PRESSURE DROPS IN AIR LINES

Inner line dia in mm	Operating Pressure		Drop in pressure in bar/PSI at a line length					
	Bar	PSI	5 metre (16ft)		10 metre (32ft)		15 metre (49ft)	
			Bar	PSI	Bar	PSI	Bar	PSI
6mm	3	45	0.7	10.5	1.2	17.4	1.8	26.1
	4	60	1.0	14.5	1.6	23.2	2.2	31.9
	5	75	1.3	18.85	1.9	27.55	2.5	36.25
	6	90	1.5	21.75	2.2	31.9	2.8	40.6
9mm	3	45	0.23	3.34	0.38	5.51	0.60	8.85
	4	60	0.30	4.93	0.55	7.98	0.81	11.75
	5	75	0.43	6.24	0.63	9.14	0.92	13.34
	6	90	0.60	8.70	0.80	11.60	1.10	15.95

Because of the considerable drop in air pressure we recommend the use of air lines with an inner diameter of 9mm. With lines of more than 10 metre length (32ft) or high air requirement we recommend an inner diameter of 13mm. 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.

4. Precautions

HEALTH & SAFETY

All of the products sold by International Paint in the Perfection Pro 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. Ensure correct Health & Safety guidelines and procedures are followed at all times.

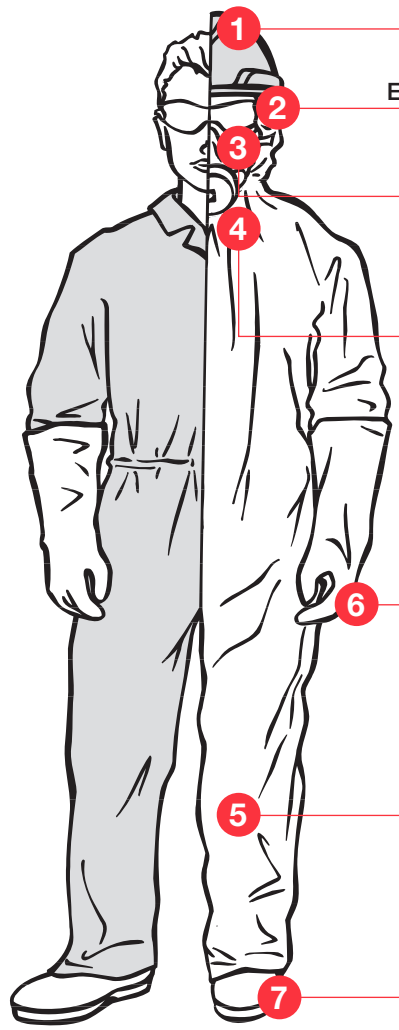
THESE PRODUCTS ARE FOR PROFESSIONAL USE ONLY
KEEP OUT OF REACH OF CHILDREN

The best protection against breathing the evaporating solvents or atomised paint, particularly isocyanate containing paints such as polyurethane base-coats and 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. Never clean paint or epoxy off your skin with solvents. There are many excellent hand cleaners on the market.

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.

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.



SAFETY HELMET: Essential for head protection. A chinstrap will prevent the helmet from being knocked or blown off.

EAR PROTECTORS: Sometimes required when working in continuous noises; e.g. near compressors.

GOGGLES: Safety spectacles to avoid eye contact with paint or paint dust are sometimes required.

MASK: A facemask with renewable filter cartridges is very useful when spraying or blasting is carried out. It prevents inhalation of dust. The filters should be renewed regularly. There are many types available but all should be to an approved standard. Filters are available for fumes and dust and the correct type should be chosen depending on the conditions of use.

GLOVES: Heavy-duty gloves should be worn when required but especially when handling paint to avoid skin contact.

OVERALLS: An overall is essential. It should be washed regularly to avoid build-up of materials.

SAFETY SHOES: Water and oil resistant boots or shoes are needed – preferably with protected toecaps.

5. Appendix

CHART 1: THINNING AND VOLUME SOLIDS CALCULATOR

Use this chart to calculate the new volume solids of your paint mix after thinning by a certain percentage.

Original volume solids of paint	Percentage of Thinner added to Paint						
	5%	10%	15%	20%	25%	33%	50%
15%	14	13.6	13	12.5	12	11	10
20%	19	18	17	16.7	16	15	13
25%	24	23	22	21	20	19	17
30%	29	27	26	25	24	23	20
35%	33	32	30	29	28	26	23
40%	38	36	35	33	32	30	27
45%	43	41	39	37	36	34	30
50%	48	45	43	42	40	38	33
55%	52	50	48	46	44	41	37
60%	57	55	52	50	48	45	40
65%	62	59	56	54	52	49	43
70%	67	64	61	58	56	53	47
75%	71	68	65	62	60	56	50
80%	76	73	70	67	64	60	53
85%	81	77	74	71	68	64	57
90%	86	82	78	75	72	68	60
95%	90	86	83	79	76	71	63
100%	95	91	87	83	80	75	67

Volume Solids after Thinning % = $\frac{\text{Volume Solids Before Thinning}}{100 + \text{Percentage of Thinner Added}}$

CHART 2: WET/DRY FILM BUILDS VERSUS VOLUME SOLIDS.

Use this chart to calculate required wet film builds to apply to achieve required dry film build stated in specification.

Volume solids	Dry Film Thickness (Microns)										
	25	50	75	100	125	150	200	250	300	500	1000
10%	250	500									
15%	166	334	500								
20%	125	250	375	500							
25%	100	200	300	400	500						
30%	83	167	250	333	417	500					
35%	72	143	214	286	357	429	571				
40%	62.5	125	187	250	312	375	500				
45%	55	111	167	222	278	333	444	555			
50%	50	100	150	200	250	300	400	500			
55%	45	91	136	182	227	273	364	454			
60%	42	83	125	167	208	250	333	417	500		
65%	38	77	115	154	192	231	308	385	461	770	
70%	36	71	107	143	178	214	286	357	428	714	
75%	33	67	100	133	167	200	267	333	400	667	
80%	31	62	94	125	156	187	250	312	375	625	
85%	29	59	88	118	147	176	235	294	353	588	
90%	28	56	83	111	139	167	222	278	333	555	1111
95%	26	53	79	105	132	158	210	236	316	526	1052
100%	25	50	75	100	125	150	200	250	300	500	1000

Wet Film Thickness = $\frac{\text{Dry Film Thickness x 100}}{\text{Volume Solids \%}}$

CHART 3: USEFUL CONVERSION FACTORS

Volume

1 US gallon	3.785 litres
1 Quart	0.946 litres (946 mls)
1 Pint	0.473 litres (473 mls)
1 Quart	2 Pints
1 US Quart	*2 US Pints*
4 Quarts	1 Gallon
4 US Quarts	*1 US Gallon*
8 Pints	1 Gallon
8 US Pints	*1 US Gallon*
1 pound per 1 US gallon	0.11983 kilos per litre

Area/Coverage

1 sq meter	10.763 sq feet
Multiply sq feet/US gallon by 0.0245 to get sqm/litre *ie 300sq feet/US gallon equals 300 x 0.0245 = 7.35 sqm/litre* OR *Divide Sqft/US gallon by 40 and that will give roughly sqm/litre* *ie 300 divided by 40 = 7.5*	

Thickness

One mil	one thou
One mil	25 microns
1000 microns	1 mm
1 litre of any paint or filler applied to 1 sq meter will cover that area to depth of 1mm whilst it is wet.	

Temperature

95ºF	35ºC
77ºF	25ºC
50ºF	10ºC

Weight and Liquid Weight

1oz (1 ounce)	28.35 grams
1 fluid oz	28.4 mls
35 fluid oz	1 litre approx.

Pressure

1 BAR	approx 14.5 psi
1Kg/cm^2	14.4 psi

6. Specifications

Aluminium:
Degrease then 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 (Note: Power wire brushing is not permitted as it is ineffective and wires are often steel, leading to corrosion).

Steel:
Degrease then blast to near white metal AS1627.4 Class 2.5. Power tool clean all welds, damages, corroded areas and intact shop primer to AS1627.2 Class 2

GRP and Epoxy Composite:
Remove any surface wax or mould release agent (parting agent) from the laminate or gelcoat with a suitable liquid detergent or wiping with a suitable solvent. Sand to a dull gloss free surface ensuring there are no air voids left untreated.

Timber:
Sand wood thoroughly. Ensure the surface is wiped clean with a cloth soaked in International® Thinners No.10 or No.4 or other suitable fast solvent and allow to dry.

Product Name	Thickness per Coat		Sequential Overcoating Times			
	WFT	DFT		15ºC	23ºC	35ºC
Surface Priming						
Interprime 820 (thinned 15%)	160 microns	65 microns	**Min:**	36 hrs	24 hrs	24 hrs
			Max:	3 mths	3 mths	3 mths
Optional Surface Primer for GRP & Timber						
Interprime 820 (thinned 15%)	102 microns	42 microns	**Min:**	24 hrs	16 hrs	10 hrs
			Max:	–	–	–
Filling & Fairing						
Interfill 830 (optional)	20,000 microns	20,000 microns	**Min:**	3 days	2 days	1 day
			Max:	–	–	–
Interfill 833 (optional)	160 microns	65 microns	**Min:**	–	–	–
			Max:	–	–	–
Priming						
Interprime 820	275 microns	125 microns	**Min:**	16 hrs	12 hrs	6 hrs
			Max:	5 days	3 days	2 days
OR						
Interprotect	305 microns	125 microns	**Min:**	24 hrs	16 hrs	10 hrs
			Max:	–	–	–
Undercoating						
Perfection Undercoat (second coat optional)	100 microns	50 microns	**Min:**	16 hrs	10 hrs	8 hrs
			Max:	3 days	2 days	1 day
Top-coating						
Perfection Pro	50 microns	25 microns	**Min:**	–	–	–
			Max:	3 days	2 days	1 day
Perfection Pro	75 microns	37 microns	**Min:**	–	–	–
			Max:	3 days	2 days	1 day
Perfection Pro	75 microns	37 microns	**Min:**	–	–	–
			Max:	3 days	2 days	1 day

Note: For roller applied Perfection Pro additional coats may be required to achieve the correct dry film thickness. Please consult the Technical Data Sheet for more information or contact an International Technical Representative.

ADVISOR NOTES

Prepare the substrate in accordance with the Surface Preparation details as outlined in the Professional Application Manual and Product Datasheets.

- Surface prime with Interprime 820 (thinned 15%) as a holding primer to freshly prepared substrate. Interprotect thinned down may be used on non-metallic surfaces.
- Fill and fair with Interfill 830 sand with 60–80 grade paper, Interfill 833 sand with 80–120 grade paper.
- Prime with one coat of Interprime 820 or Interprotect.
- Sand the Interprime 820 or Interprotect with P180 - 240 prior to application of Perfection Undercoat.
- Undercoat with one or two coats of Perfection Undercoat. Sand with 320–400 grade paper to obtain a smooth surface. Remove sanding debris before proceeding.
- Topcoat with 2–3 coats of Perfection Pro by conventional spray to obtain a full gloss.

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