

Verfsysteem Klein Jacht, applicatie specificaties.

Underwater Hull

High performance Spray - Underwater Steel	
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Surface Preparations

All welded seams, corroded areas, burn spots and other damages in the pre fabrication primer should be gritblasted with a moderate dry sharp abrasive to a min. grade P Sa 2½ according to ISO 8501-1. The prefabrication primer has to be grit swept. Grease, oil, dirt, weld spatters, etc. should be removed first.

								Overcoating 23 C			
Product	Colour	DFT µm	Coats	WFT µm	Volume Solids (%)	TSR (m ² /lt)	Volume lt	Min	Max	Pot Life 23 C	Thinner
Epoxy GP Coating**		100	FC	159	41	6,3		8hrs	12 mnths	4hrs	YTA910, YTA925, YTA920
Interprime 450	alu	150	FC	250	60	4		7hrs	14days	2,5hrs	GTA220
Interprime 450	bronze	150	FC	250	60	4		7hrs	14days	2,5hrs	GTA220
Epoxy AF Tiecoat	Licht grijs	75	FC	90	57	7,6		12hrs	5days	6hrs	GTA220
Micron Extra		100	FC	200	60	6		6hrs	ext		YTA085
Micron Extra		100	FC	200	60	6		6hrs	ext		YTA085
Total		675		1149							

Scheme Notes:

* Minimum required dft for the ac system should be 350 μ .

* Antifouling: Ask the International Representative for the allowed Antifouling type at the moment of application.

Advisory Notes:

* Surface roughness recommended before priming between an av .50 to 75 micron.

* For initial priming the first coat should be suitably thinned when applied to ensure complete substrate wet out.

* The initial primer can act as a holding primer for prepared substrates. The primer surface can be directly overcoated with

International epoxy primers for up to 12 months following solvent wipe down. No sanding is required prior to overcoating within that time period.

See product datasheets for more details. * If the overcoating times shown for primers, fillers, undercoats and finishes are exceeded they must be abraded

before overcoating as recommended in the product datasheets. * The filler area in the waterline area where the bottomscheme has to be applied:

Apply on the Filler a thin coat (65 μ dft) of Epoxy GP Coating and let it dry for a minimum of 24 hours (20 degr Celcius) before applying

the rest of the bottom scheme (Interprime 450).

** Epoxy GP Coating has to cure for a minimum of 4 days at 20 degrees Celcius before launching and transport to the site in Makkum.

Note: Components that have t

the 2 coats of 150 micron dft.

Note: Stainless steel bulb has to be blastcleaned with a non metallic, sharp angled grit. Dedust and clean. Surface profile

Topside, Steel Hull Exterior above water

High performance - Topside Steel

Surface Preparations

All welded seams, corroded areas, burn spots and other damages in the pre fabrication primer should be gritblasted with a moderate dry sharp abrasive to a min. grade P Sa 2½ according to ISO 8501-1. The prefabrication primer has to be grit swept. Grease, oil, dirt, weld spatters, etc. should be removed first.

[illegible]

Scheme Notes:

* Apply Awl Grip Topcoat according manufacturers instructions. See also the technical datasheets.

The minimum dft after sanding of the High Build primer is 100 μ and of the 545 primer is 50 μ .

Advisor Notes:

* Surface roughness recommended before priming between .50 to 75 micron.

* For initial priming the first coat should be suitably thinned when applied to ensure complete substrate wet out.

* The initial primer can act as a holding primer for prepared substrates. The primer surface can be directly overcoated with

International epoxy primers for up to 12 months following solvent wipe down. No sanding is required prior to overcoating within that time period.

See product datasheets for more details. * If the overcoating times shown for primers, fillers, undercoats and finishes are exceeded they must be abraded

before overcoating as recommended in the product datasheets. Minimum surface temperature is 16 degrees Celsius

*** The 545 needs to be sanded to achieve a smooth substrate.

** Apply fillers as much as possible without any air pockets. To prevent air pockets as much as possible we recommend to fill the dents first and to apply the filler

in a max of 5 mm per layer. Any air pockets have to be opened and filled before applying the next layer. Fillers should always be sanded prior to overcoating

A solvent free filler can be overcoated with itself or another solvent free filler as soon as it is cured enough not to be lifted in the screeding process.

If additional sanding is undertaken it may be necessary to apply additional coats in order to maintain minimum dft levels as determined by the specification.

If the overcoating times shown for primers and finishes are exceeded they should be abraded before overcoating as recommended in the product datasheets.

Note: Apply above exterior steel ceilings (behind panelling) 2 coats of 100 microns dft Epoxy GP Coating

Steel Hull & Superstructure Interior behind isolation and panelling (Dry Areas, incl. engine room)				
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General:	All the Steel is blast cleaned to a grade Sa 2½ according ISO 8501-1 and primed with a suitable low zinc silicate shopprimer (Sigmaweld MC)
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<u>Surface Preparations:</u>	Derust and Clean all rust spots, welds, etc to a grade St 3 acc ISO 8501-1. Clean the intact shopprimer. Grease, oil, weldspatter, dirt etc has to be removed previously.
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								Overcoating 23 C			
Product	Colour	DFT µm	Coats	WFT µm	Volume Solids (%)	TSR (m²/lit)	Volume lt	Min	Max	Pot Life 23 C	Thinner
Interior Primer 860		100	FC	143	70	7		2½hrs	12mnths	1hr	Spray YTA910, Brush Thinner nr 7
Total		100									

Scheme Notes:
Interior Primer is available in the colour white and grey.
Engine room. All surfaces are covered with panelling.

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<u>General:</u>	All the Steel is blast cleaned to a grade Sa 2½ according ISO 8501-1 and primed w ith a suitable low zinc silicate shopprimer (Sigmaw eld MC)
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<u>Surface Preparations:</u>	Derust and Clean all rust spots, welds, etc to a grade St 3 acc ISO 8501-1. Clean the intact shopprimer. Grease, oil, weldspatter, dirt etc has to be removed previously.
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Scheme Notes:
Any visible areas can be finished with 1 coat Interior Finish 750. Apply the Interior Finish 750 within 1 month on the Interior Primer 860 to ensure proper adhesion.
If this time is exceeded we recommend to sand the primer and clean it to ensure proper adhesion.
Interior Primer 860 is available in white and light grey.

Steel Hull Interior, visible area's (Dry areas, including lockers)								
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General:	All the Steel is blast cleaned to a grade Sa 2½ according ISO 8501-1 and primed with a suitable low zinc silicate shopprimer (Sigmaweld MC)
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<u>Surface Preparations:</u>	Derust and Clean all rust spots, welds, etc to a grade St 3 acc ISO 8501-1. Clean the intact shopprimer. Grease, oil, weldspatter, dirt etc has to be removed previously.
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								Overcoating 23 C			
Product	Colour	DFT µm	Coats	WFT µm	Volume Solids (%)	TSR (m²/ltr)	Volume lt	Min	Max	Pot Life 23 C	Thinner
Interior Primer 860		100	FC	143	70	7		2½hrs	12mnths	1hr	Spray YTA910, Brush Thinner nr 7
Interior Finish 750		40	FC	80	51	12,8		24h	ext		
Total		140									

Scheme Notes:									
Interior Primer 860 is available in white and light grey									
Interior Finish is available in Ral 9003 and 9010									
For Cranebox at the Stern Deck Aft, MOB Store and Stern Room Aft Anchor apply two coats of Interior Primer 860 of 100 µ dft per coat before applying the Interior Finish 750.									
For these areas apply the Interior Finish 750 within 1 month on the Interior Primer 860 to ensure proper adhesion. If this time is exceeded we recommend to sand the primer and clean it to ensure proper adhesion.									

High performance Spray - Steel Note: Construction is from steel. For mounting the composite chain lockers, stainless steel bars are used

All welded seams, corroded areas, burn spots and other damages in the pre fabrication primer should be gritblasted with a moderate dry sharp abrasive to a min. grade P Sa 2½ according to ISO 8501-1. The pre fabrication primer has to be grit sw ept. Grease, oil, dirt, weld spatters, etc. should be removed first. The stainless steel has to be gritblasted till an even roughed surface with an angular non metallic blasting grit. (Surface profile 50 to 75µ) Prime within 2 hours after blasting

Scheme Notes:

* Minimum required dft for the ac system should be 350 μ .

Advisor Notes:

See product datasheets for more details

* For initial priming the first coat should be suitably thinned when applied to ensure complete substrate wet out.

* If the overcoating times shown for primers, fillers, undercoats and finishes are exceeded they must be abraded before overcoating as recommended in the product datasheets.

Surface Preparations

All welded seams, corroded areas, burn spots and the whole surface has to be gritblasted with a moderate dry sharp abrasive to a min. grade Sa 2½ according to ISO 8501-1. Grease, oil, dirt, weld spatters, etc. should be removed first.

Scheme Notes:

FC = Full Coat, SC = Stripe Coat