

### DESCRIPTION

This system describes how the interior behind linings and bilges of a steel yacht may be coated with a two component epoxy system.

### PRINCIPAL CHARACTERISTICS

This coating system may be applied directly to properly pre-treated steel and gives an excellent protection against corrosion. This system is scratch resistant and resistant to a wide range of chemicals, water and oil.

### SURFACE CONDITION

Steel, in good condition.

### SURFACE PREPARATION

New building

1. Remove all shop primers, rust and corrosion products, preferably by grit blasting to ISO Sa2 ½ or by powertool cleaning to ISO St3;
2. The surface should be dry and free from grease, loose particles and other contamination.

Maintenance

1. Remove all rust, corrosion products and paint layers with insufficient adhesion (including one component paints in good condition), preferably by grit blasting to ISO Sa2 ½ or by powertool cleaning to ISO St3;
2. Previous layers of two component paint which have good adhesion and which are in good condition should be abraded; preferably by sweep blasting or using grit paper;
3. Clean and dry the surface thoroughly.

### MATERIALS AND SPREADING RATES

The following materials are used in this paint system:

IJmopox ZF primer	spreading rate approx. 0,10 l/m <sup>2</sup>
Variopox Rolcoating	spreading rate approx. 0,15 l/m <sup>2</sup> (solvent free system)
IJmopox HB coating	spreading rate approx. 0,22 l/m <sup>2</sup> (high solids system)
IJmopox Verdunner	spreading rate depends on application method

### APPLICATION

New building

1. Apply one coat of IJmopox ZF primer to a total dry film thickness of 50 µm (minimum spreading rate approx. 0,10 l/m<sup>2</sup>);
2. Apply one to two coats of Variopox Rolcoating to a total dry film thickness of 150 µm (minimum spreading rate approx. 0,15 l/m<sup>2</sup>);
3. As alternative for Variopox Rolcoating two coats of IJmopox HB coating may be applied instead to a total dry film thickness of 150 µm (minimum spreading rate approx. 0,22 l/m<sup>2</sup>). Variopox Rolcoating is free from any solvent and is preferred.

Maintenance

1. Apply as spot-repair to damaged and bare areas one coat of IJmopox ZF primer to a total dry film thickness of 50 µm (minimum spreading rate approx. 0,10 l/m<sup>2</sup>);
2. Apply one to two coats of Variopox Rolcoating to a total dry film thickness of 150 µm (minimum spreading rate approx. 0,15 l/m<sup>2</sup>);
3. As alternative for Variopox Rolcoating two coats of IJmopox HB coating may be applied instead to a total dry film thickness of 150 µm (minimum spreading rate approx. 0,22 l/m<sup>2</sup>). Variopox Rolcoating is free from any solvent and is preferred.

### ADDITIONAL INFORMATION

- Bilges and anchor locker**  
 This paint system is also suitable for bilges and anchor lockers. Bilges may be contaminated with oil residues therefore special attention should be given to the preparation of the surface.
- Previous paint: one or two component?**  
 When it is not known if the previous coating system was based on one- or two component products, this can be determined with a simple test. Soak a small piece of cloth in Double Coat Ontvetter and leave this for 15 minutes on the surface. Remove the cloth and check the surface. When the previous paint has not dissolved, is not softened and cannot be easily removed it is most probably a two component paint. Only then it is possible to apply a fresh coat of two component paint.
- Durability and surface preparation**  
 The durability of any paint system depends on a number of variables, amongst others: total dry film thickness, method of application, skill of labour, the conditions during which the coating is applied and cured, the exposure conditions during service and the preparation of the surface. Insufficient surface preparation might lead to blistering and loss of adhesion.
- Sanding**  
 A durable adhesion will be obtained by thorough preparation of the surface. This may be achieved by sanding the surface. Sanding is also necessary when the time lapsed between application of each coat exceeds the maximum overcoating interval. During application of the finishing coats, we recommend to use for each coat a finer grit paper. The table gives the recommended grit sizes:

Grit paper:	Recommended for:
P24 – P36	Suitable for steel prior to application of IJmopox ZF primer.
P60	Suitable for polyester gelcoat prior to the use of epoxy adhesives and bonding pastes.
P60 – P80	Suitable for: <ul style="list-style-type: none"> <li>Removal of old coats of paint,</li> <li>Sanding aluminium prior to application of IJmopox ZF primer.</li> </ul>
P120	Suitable for: <ul style="list-style-type: none"> <li>Sanding polyester gelcoat prior to repair with fillers,</li> <li>Sanding of Variopox Injectiehars, Variopox Impregneerhars en Variopox Universele hars.</li> </ul>
P120 – P180	Suitable for: <ul style="list-style-type: none"> <li>Wood, after application of first coat of paint,</li> <li>Epoxy fillers,</li> <li>Polyester fillers,</li> <li>Sanding of IJmopox ZF primer and/or IJmopox HB coating between each coat.</li> </ul>
P180 – P220	Suitable for: <ul style="list-style-type: none"> <li>Sanding of Variopox Injectiehars, Variopox Impregneerhars en Variopox Universele hars,</li> <li>Sanding of IJmopox ZF primer of IJmopox HB coating prior to application of Double Coat.</li> </ul>
P220 – P280	Suitable for sanding gelcoat prior to application of Double Coat.
P320 – P400	Suitable for sanding Double Coat between each coat.
P600	Suitable for sanding Double Coat prior to application of the final coat Double Coat when dark colours are used such as DC 855, DC 854 en RAL 5011, etc.
Finer then P600	Suitable to remove dull areas prior to polishing.

## 11: STEEL – INTERIOR BEHIND LININGS

- Example application schedule

Step		Dry film thickness (µm)	Spreading rate (m <sup>2</sup> /l)	Recoating interval at 20 °C	Preparation before next step
1	Pre-treatment				
2	Apply first coat of IJmopox ZF primer	50	11.0	16 hours	When recoated within 72 hours no preparation is required, otherwise sanding with P180. Sanding P180.
3	Apply first coat of Variopox Rolcoating	75	13.3	8 hours	
4	Apply second coat of Variopox Rolcoating	75	13.3	8 hours	

- Relation dry/wet film thickness

Volume % IJmopox thinner	0	3	6	9	12
Wet film thickness IJmopox ZF primer at 50 µm dry film thickness	91	94	96	99	102
Wet film thickness IJmopox HB coating at 50 µm dry film thickness	71	74	76	78	80
Wet film thickness Variopox Rolcoating at 75 µm dry film thickness	75				

For detailed information on the products mentioned in this sheet, please refer to our technical information sheets.

Date: January 15

*Disclaimer*

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