

APPLICATION INSTRUCTIONS

For product description refer to the product data sheet



BLAKES EPOXY PRIMER UNDERCOAT

MIXED PRODUCT 45551

BASE 45559

CURING AGENT 95360

- Scope:** These APPLICATION INSTRUCTIONS cover surface preparation, application equipment, and application details for BLAKES EPOXY PRIMER UNDERCOAT.
- Surface preparation:**
- Iron and Steel:** Remove oil and grease etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Abrasive blasting to Sa 2^{1/2}, SCPC-SP10. Small areas may be mechanically grinded to leave a metallicly clean and rough surface.
 - Aluminium:** Remove oil and grease etc. with suitable detergent for aluminium surfaces followed by (high pressure) fresh water cleaning. Abrasive sweeping with non-metallic abrasive to produce a uniformly roughened surface.
 - Plywood:** Sand the surface carefully and remove dust. Saturate the surface, especially the edges, with one or more thinned coat of EPU or a suitable epoxy sealer.
 - Glassfibre:** Degrease the surface with BLAKES DEGREASER. Grind the surface with sandpaper 180 grit, remove dust.
 - Repair and maintenance:** Remove oil and grease with suitable detergent, salt and other contaminants by (high pressure) fresh water cleaning. Clean damaged areas thoroughly by abrasive blasting, power tool cleaning, or other suitable cleaning method dictated by the substrate. Feather edges to sound and intact areas. Brush off loose material. BLAKES EPOXY PRIMER UNDERCOAT should not be applied on paints of another generic type.
- Application Method:** The paint may be applied by spray, brush, paint pad or roller. BLAKES PAINTS recommend that Anza application tools are used for their products. Customers please be aware that certain brands of application tools can be adversely effected by products such as EPU which contains strong solvents. The indicated dry film thickness of 100 micron is only obtainable by spray application. or brush application approximately 10% thinning is recommended for good brush ability. If conditions of application are difficult the product can be thinned up to 40%, certain conditions may also require adding more thinners to the mixed product during application. Tools should be cleaned immediately after use with BLAKES THINNERS No. 5 or BLAKES DEGREASER.
- Thinner:** BLAKES THINNERS NO. 5 Thinning must only take place after mixing of base and curing agent.
- Pot Life:** 2 hours (20°C) for application by spray. 6 hours (20°C) for application by brush or roller. Mixed paint must be applied before pot-life is exceeded.
- Application Conditions:** Use only where application and curing can proceed at temperatures above 5°C. At the freezing point and below be aware of the risk of ice on the surface, which will hinder adhesion. The temperature of the paint itself shall be above 15°C, preferably 15-20°C. The surface must be clean and dry and its temperature must be above the dew point to avoid condensation. In confined areas provide adequate ventilation during application and drying.

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RECOAT / OVERCOATING INTERVALS:

When BLAKES EPOXY PRIMER UNDERCOAT is applied in 100 micron dry film thickness the following recoat/overcoating intervals are valid:

SURFACE TEMPERATURE		5°C	10°C	20°C	30°C
BLAKES EPOXY PRIMER UNDERCOAT	min. max.	46 hours (90 days)	16 hours 60 days	8 hours 30 days	6 hours 20 days
HEMPEL EPOXY FILLER 35250	min. max.	- -	16 hours 60 days	8 hours 30 days	6 hours 20 days
BLAKES UNDERWATER PRIMER BLAKES TIGER CRUISING / TIGER XTRA	min. max.	8 hours 12 hours	12 hours 18 hours	6 hours 9 hours	4 hours 6 hours
BLAKES POLYGLOSS	min. max.	21 hours 9 days	16 hours 6 days	8 hours 3 days	6 hours 2 days
Fully cured		21 days	14 days	7 days	5 days

When BLAKES EPOXY PRIMER UNDERCOAT is applied in 60 micron dry film thickness the following recoat/overcoating intervals are valid:

SURFACE TEMPERATURE		5°C	10°C	20°C	30°C
BLAKES EPOXY PRIMER UNDERCOAT	min. max.	12 hours (90 days)	8 hours 60 days	4 hours 30 days	3 hours 20 days
HEMPEL EPOXY FILLER 35250	min. max.	- -	8 hours 60 days	4 hours 30 days	3 hours 20 days
BLAKES UNDERWATER PRIMER BLAKES TIGER CRUISING / TIGER XTRA	min. max.	3 hours 12 hours	2 hours 8 hours	1 hours 4 hours	45 minutes 3 hours
BLAKES POLYGLOSS	min. max.	12 hours 9 days	8 hours 6 days	4 hours 3 days	3 hours 2 days
Fully cured		21 days	14 days	7 days	5 days

Note:

If the maximum recoat interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.

