

Two-component paint system on fibreglass (GRP) above the waterline

August-2018

General surface preparation

Cleaning

New fibreglass must be chemically fully cured and at least 4 weeks old before a paint system may be applied. In case of both new and older fibreglass Start by cleaning the fibreglass surface with warm soapy fresh water in order to remove all water-soluble dirt and other contamination.

Degreasing

After drying, thoroughly degrease the fibreglass surface with Epifanes Fiberglass Prep Cleaner to remove all wax residues. In case of insufficient degreasing, adhesion problems may occur. Degreasing by performing the two-towels-methode: keep one towel well saturated and wipe in one direction on the fibreglass surface. Use the second towel to remove the collected contamination. Always work in one direction. Do not wipe back and forth. Replace towels regularly.

Sanding

Before continuing, first check the status of the fibreglass surface. If the gelcoat shows fully intact and smooth with just discolouration and/or loss of gloss, lightly sand the surface with dry abrasive paper P240. Remove all dust by vacuum cleaner and degrease once more as described.

Damaged gelcoat

If the gelcoat shows cracks, astric diamonds, holes or other defects, always check what has caused this. If the construction of the fibreglass laminate has weakened in time, first make reinforcements. This can be done using i.e. West System Epoxy resin. We refer to the West System documentation. Only once the construction has been strengthened, damages/imperfections may be filled with Epifanes Epoxy Filler 1500 or Epifanes Finishing Filler. Make sure all imperfections are well filled. Cut out smaller cracks before filling. Sand astric diamonds and holes deep into the laminate, before filling. Do not exceed recommended maximum filmthickness. After fully cure, degrease to remove amine blush. Only after degreasing filled areas, sand with dry abrasive paper P240. After sanding degrease once more.

Micro-porosity

Fibreglass gelcoats may be micro-porous. Especially older gelcoats may be affected by this. By drawing felt tip pen lines and quickly wiping them with a (paper) towel saturated with Epifanes Fiberglass Prep Cleaner, microporosity becomes visible as small spots in the gelcoat. In case of micro-porosity after degreasing, sand the surface with P150 dry to open all micro-porous spots. Remove sanding dust. And degrease once more. Clustered, clearly visible spots may be filled with Epifanes Epoxy Filler 1500, prior to applying one coat Epifanes Epoxy Primer to fill all spots and create a smooth surface.

Working conditions

All surfaces to be painted must be 100% dry. The relative air humidity should not exceed 70%. Temperature of paint, object and work area during application and drying should Temperature of the paint/varnish, the object/surface and working area should be more or less the same. Large temperature differences may have repercussions on adhesion, drying and hardening. Recommended temperature range of application and curing : 12 – 20°C.

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System build up brush/roller application

Coat #	Product	Thinning %	filmthickness			Recoatibility in hours			Sandability
			wet	dry		12°C.	20°C.	28°C.	
1.*	Poly-urethane Primer	5-10%	80-120µm	40-60µm	brush/roller	10	6	4	24 uur
2.	Poly-urethane Yachtpaint	0-5%	60-70µm	30-35µm	brush/roller	36	24	18	24 uur
3.**	Poly-urethane Yachtpaint	0-5%	60-70µm	30-35µm	brush/roller	36	24	18	24 uur
4.	Poly-urethane Yachtpaint	0-5%	60-70µm	30-35µm	brush/roller	36	24	18	24 uur

Recommended thinners:

Poly-urethane Primer	Poly-urethane Jachtlak
Poly-urethane Brushthinner	Poly-urethane Brushthinner or PU Slow Reducer when applying above 18°C ***

Remarks :

- * The PU primercoat is not necessary if gelcoat is intact and smooth. Sand PU Primercoat after 24 hours with P220. Poly-urethane Primer is standard in white and grey. On request also available in green, blue, red and yellow.
- ** If applied between 24 -48 hours Poly-urethane Yachtpaint coats may applied without intercoat sanding. If applied after 48 hours, always sand. Sand second-last coat Poly-urethane yacht paint with wetordry abrasive paper P400.
- *** When applying above 18°C. use Epifanes PU Slow Reducer. This slow evaporating thinner provides a longer open time allowing a better flow.

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