

FREQUENTLY ASKED QUESTIONS ABOUT DOUBLE COAT

Category	Problem	Answer
<i>Adhesion</i>	Can I apply Double Coat to a non-slip surface?	This is possible, clean the existing non-slip surface with a scotch brite sanding pad and clean with Double Coat Degreaser. When an existing non-slip surface is coated with Double Coat it will result in a slippery surface when wet. Add to the last layer of Double Coat Double Coat Anti-slip Powder to restore the non-slip properties.
<i>Adhesion</i>	Can I apply several layers of Double Coat without sanding?	This is possible provided the next layer is applied after 24 hours but within 48 hours. If not, sanding with grit paper is recommended.
<i>Adhesion</i>	Can I repaint GRP with Double Coat?	Double Coat gives an excellent adhesion to GRP, provided the GRP is dry, clean and free from contamination and loose particles. For best adhesion the GRP should be grit sanded and cleaned with Double Coat Degreaser.
<i>Adhesion</i>	Can I repaint previous coatings with Double Coat?	Double Coat can be applied on top of old layers of two component paints after proper surface preparation such as sanding. Always check the quality of the previous layer. When this layer does not dissolve or softens when exposed to Double Coat Degreaser, then you can repaint with Double Coat.
<i>Anti-slip properties</i>	How do I remove a one component paintsystem from an GRP anti-slip profile?	Put some Double Coat Spraythinner or Double Coat Degreaser on a piece of cloth and leave on the surface for 30 minutes. The old paint can easily be removed by brush or pad.
<i>Anti-slip properties</i>	How do I apply Double Coat over an existing anti-slip profile?	Clean the surface thoroughly with a Scotch Brite pad. Clean with Double Coat Degreaser and allow to dry. Applying a coat of Double Coat to the surface will make the surface slippery. By adding Double Coat Anti-slip powder to Double Coat prior to application, it is possible to restore the profile again.
<i>Application</i>	How much Double Coat should I prepare?	Do not prepare more material as can be applied in one to two hours time. Larger volumes of prepared paint will reduce the potlife as temperature will increase due to the reaction between base and hardener. At higher temperatures potlife will be shorter.
<i>Application</i>	Should I apply a clear varnish on top of Double Coat?	It is not necessary to apply a clear (two component) varnish on top of Double Coat. Double Coat has a high gloss, a good colour retention and is scratch resistant.
<i>Application</i>	How can I clean brushes and rollers used for Double Coat?	You may use Double Coat Brushthinner or Double Spraythinner for cleaning tools used for Double Coat. Rollers are in general used only once and are not cleaned.
<i>Application</i>	What is the correct mixing ratio of Double Coat?	The mixing ratio of Double Coat is always 2 parts (by weight) base component and 1 part (by weight) hardener. Double Coat Dubbel UV and Double Coat Karaat have a mixing ratio of 3 parts (by weight or volume) with 1 part (by weight or volume) hardener.
<i>Application</i>	What is the correct procedure when various colours Double Coat	When different colours of Double Coat are applied, it is important to use a good quality of

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	are applied?	masking tape, such as Scotch Fine Line Tape or Kleen Edge tape. Apply the tape, paint the surface and remove the tape. Wait for 24 hours before applying masking tape to fresh layers of Double Coat.
<i>Application</i>	Can I apply Double Coat over previous layers of one component paint?	It is not possible to apply Double Coat to previous layers of one component paint. Remove old layers one component paint first before applying Double Coat.
<i>Application</i>	What solvent to use for Double Coat?	Use only Double Coat Brushthinner or Spraythinner. Do not use mineral spirits, thinner or solvents from other suppliers. Other solvents may not be compatible with Double Coat.
<i>Application</i>	How can I tell the difference between one and two component paint?	Put a piece of cloth soaked in Double Coat Degreaser, acetone or other strong solvent on the surface. Leave for 15 minutes on the surface. Next, remove the piece of cloth and inspect the surface. When dissolved, damaged, softened or blistered, the surface was painted with a one component product. When in good condition, the surface is most probably painted with a two component product.
<i>Application</i>	Should I first apply Double Coat by brush and then finish by roller or the other way round?	Double Coat may be applied by roller or brush. The application method depends on the preference of the painter. When a freshly applied layer of Double Coat is finished by brush or roller, this should be done immediately and preferably by a second person.
<i>Below the waterline</i>	Can I use Double Coat for areas below the waterline?	We do not recommend Double Coat below the waterline, especially when the boat is permanently immersed in water. When the boat is taken out of the water after a day sailing and put on a trolley, Double Coat may be applied also on areas below the waterline.
<i>Curing and drying</i>	Can I cure Double Coat at elevated temperatures?	This is possible after a flash-off time of approx. 30 minutes. After this period it is possible to force cure at 40 to 50°C. At higher temperatures it is possible that air bubbles in GRP may break and cause damages in the surface.
<i>Maintenance</i>	Should I apply a wax or polish Double Coat?	It is not required to apply a wax or polish to a surface painted with Double Coat, but a wax or polish may increase the durability. When a wax or polish is used, please make sure the material is free from silicones. Silicones may cause problems when the boat has to be repainted.
<i>Recoating</i>	How soon can Double Coat be applied over an epoxy laminate?	An epoxy laminate should be fully cured before Double Coat is applied, especially when recoating with Double Coat Dubbel UV. Most epoxies are fully cured after 14 days. Always sand the epoxy laminate before applying Double Coat.
<i>Recoating</i>	How soon can Double Coat be applied over a polyester laminate?	A polyester laminate may be recoated with Double Coat after 24 hours. Make sure mould release agents or paraffin wax deposits are fully removed prior to painting.
<i>Recoating</i>	How soon can Double Coat be applied over IJmopox products?	IJmopox ZF primer may be recoated after 16 hours with Double Coat. IJmopox HB coating may be recoated after 8 hours.

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<i>Sanding</i>	What is best: dry or wet sanding?	The best choice is dry sanding. Wet sanding will give the risk of moisture entrapment in the surface, especially when fillers or porous gelcoat is sanded.
<i>Sanding</i>	What gritpaper should be used for sanding Double Coat?	Use between each layer of Double Coat a finer grain of grit paper, e.g. 280-320-400. Never use a too coarse grit paper as the scratches will remain visible in the final coat.
<i>Surface defects</i>	Why do blisters appear in fresh Double Coat?	Blisters may occur due to several reasons, a.o.: a too high air or surface temperature, a microporous polyester surface, a too high relative humidity, wrong rollers or a too high filmthickness. The problem may be solved by applying a new coat under more favourable conditions or applying a lower filmthickness with more suitable equipment.
<i>Surface defects</i>	Why is the gloss so low?	Probably the gloss of a freshly painted surface is low due to early exposure to moisture. This happens particularly when is painted close to the waterfront. At the end of the day the temperature may drop and condensation may occur on the freshly painted surface. This may result in loss of gloss and/or a white discolouration. Loss of gloss may also occur when the paint is directly applied to coarse fillers or to a surface sanded with a coarse gritpaper. Correct the problem by: applying a new coat of Double Coat under more favourable conditions, or sanding the surface with fine grit paper (P320) or by applying a barrier coat (IJmopox ZF primer).
<i>Surface defects</i>	Why do yellow stains appear in fresh Double Coat?	When after a short time yellow stains appear in Double Coat, this may be caused by previous layers of filler. When epoxy or polyester fillers are recoated too soon, residue of the hardener or peroxide might migrate through the fresh Double Coat, resulting in a yellow stain (discolouration by UV exposure). The problem may be solved by applying a barrier coat first, e.g. IJmopox ZF primer.
<i>Surface defects</i>	Why do craters appear in fresh Double Coat?	Craters may appear when the surface is contaminated with silicones or when the surface is microporous. The problem may be solved by sanding the surface and clean thoroughly with Double Coat Degreaser followed by a coat of IJmopox ZF primer.
<i>Surface defects</i>	How can I remove dust from fresh Double Coat?	Dust which settled into a curing layer of Double Coat may be removed by sandpapering followed by a new coat of Double Coat or by sanding with very fine grit paper followed by polishing to high gloss. Polishing is possible after Double Coat is fully cured.
<i>Temperature</i>	At what temperature should I apply Double Coat?	A temperature between 15 and 25 °C is required for good levelling. At higher temperatures curing will be too quick and levelling will be poor so brush marks will remain visible. At lower temperatures curing will be too slow with risk of gloss reduction due to exposure to moisture.

FREQUENTLY ASKED QUESTIONS ABOUT VARIOPOX

Category	Problem	Answer
<i>Adhesion</i>	Does epoxy resin adhere to (new) polyester?	Yes, but only when the polyester resin has been sufficiently cured. The polyester laminate has to be at least two to three weeks old. Always degrease and sand the surface!
<i>Adhesion</i>	Can I use epoxy materials to repair polyester?	Yes, new polyester has to be at least two to three weeks old.
<i>Adhesion</i>	Can I bond the plywood with Variopox Thix/Flex 75 or Variobond directly?	No, it is better to apply one coat of Variopox Injectiehars first, to sand it with coarse gritpaper and, only after that, apply the bonding paste.
<i>Adhesion</i>	Can I repair epoxy with polyester?	No, polyester adheres very poorly on an epoxy laminate. This also applies for polyester filler.
<i>Adhesion</i>	Why have layers of Variopox Impregneerhars a poor intercoat adhesion?	After 24 hours at room temperature, an epoxy resin is quite hardened. Therefore, the next layer bonds insufficiently on this surface. Sand the previous layer before applying a new layer to achieve a good adhesion.
<i>Application</i>	Should I sand before applying the next layer?	Before applying the next layer, we recommend to degrease the epoxy materials after hardening. Next, sand it with a coarse grit paper and then degrease it again.
<i>Application</i>	How can I clean brushes, rollers and other equipment?	Clean the tools and equipment that are used for the application of epoxy materials with Double Coat Degreaser or acetone.
<i>Application</i>	Why are the materials so thick?	At a low temperature, the viscosity of the resin is higher. That is why the materials are difficult to work with. Make sure that the materials, the surface and the surrounding area have a temperature between 15 and 25 °C.
<i>Application</i>	How can I tell the difference between one and two component paint?	Put a piece of cloth soaked in Double Coat Degreaser, acetone or other strong solvent on the surface. Leave for 15 minutes on the surface. Next, remove the piece of cloth and inspect the surface. When dissolved, damaged, softened or blistered, the surface was painted with a one component product. When in good condition, the surface is most probably painted with a two component product.
<i>Application</i>	Why do I always need to repaint epoxy materials?	The UV resistance of epoxy materials is poor. Influenced by sunlight, yellowing and chalking will occur.
<i>Application</i>	What is the correct mixing ratio of epoxy materials?	The correct mixing ratio of epoxy materials is always in parts by weight. The mixing ratio can be found on the label and in the technical information sheet.
<i>Application</i>	What is the potlife of epoxy materials?	Apply the materials directly after the base and the hardener component have been mixed. The reaction between base and hardener will increase temperature and will reduce potlife. Therefore, always pour the mixed material in a tray so you can work with the materials for a significant longer period. The potlife can be found on the label and on the technical information sheet.
<i>Application</i>	What type of glass reinforcement can I use?	Various materials are considered to be suitable, for example: glass fabric, glass roving, glass

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		twill fabric, kevlar and carbon. Laminating wood with glass twill fabric results in a reinforcement that is hardly visible.
<i>Application</i>	What solvent can I use for Variopox materials?	Do not use any solvent when processing epoxy materials.
<i>Curing and Drying</i>	Can Variopox materials be cured at increased temperatures?	Yes, but wait for at least 30 minutes after application of the final layer. Then increase the temperature up to 40 or 50 °C.
<i>Recoating</i>	How soon can I repaint Variopox Impregneerhars or Variopox Universele Hars met Double Coat Dubbel UV?	Variopox Impregneerhars or Variopox Universele hars have to be completely cured to achieve sufficient adhesion. At room temperature, this takes 14 days. Degrease and sand the Variopox Impregneerhars of Variopox layer before applying Double Coat Dubbel UV.
<i>Recoating</i>	How soon can I repaint Variopox Impregneerhars or Variopox Uiversele Hars with IJmopox HB coating or Double Coat?	After 24 hours, Variopox Impregneerhars or Variopox Universele Hars can be repainted with IJmopox HB coating or Double Coat. Degrease and sand Variopox Impregneerhars or Variopox Universele Hars before applying IJmopox HB coating.
<i>Sanding</i>	What is best: dry or wet sanding?	The best choice is dry sanding. Especially when a filler has to be sanded, it is better to use dry sanding. It takes quite some time before moisture has disappeared from the filler.
<i>Surface defects</i>	Why does a sticky greasy surface appear on the layer of Variopox Injectiehars, Variopox Impregneerhars or Variopox Universele Hars?	Several causes can give this result, for example: a wrong mixing ratio of basis and hardener or a too low temperature during the application and the hardening process.
<i>Surface defects</i>	Why do the layers of Variopox Injectiehars, Variopox Impregneerhars or Variopox Universele Hars become hazy?	When the first layer of epoxy becomes hazy, this means that it has been applied to a damp surface. The humidity of the wood should not exceed 12%.
<i>Surface defects</i>	Why does the layer Variopox Impregneerhars become dull?	The durability and gloss retention of epoxy materials is poor. Influenced by UV radiation, yellowing and chalking will take place, which causes the layer to become dull.
<i>Temperature</i>	At what temperature should I apply epoxy materials?	A temperature between 15 and 25°C is required, unless the label or the technical information sheet say differently.

FREQUENTLY ASKES QUESTIONS ABOUT IJMOPOX

Category	Problem	Answer
<i>Adhesion</i>	Can I apply several layers of IJmopox ZF primer or IJmopox HB coating without sanding?	This is possible if the next layer is applied after 24 hours and within 48 hours. If not, sanding is recommended.
<i>Adhesion</i>	Can I apply several layers of IJmopox ZF primer or IJmopox HB coating wet-in-wet?	When you apply the next layer while the previous layer is still wet, solvent retention may occur. The solvent is being trapped within the layer, which may lead to blisters within the top layer.
<i>Adhesion</i>	Why do IJmopox ZF primer and IJmopox HB coating adhere so badly around the filler neck of the diesel oil tank?	Probably, the polyester is saturated with diesel oil. Degrease the polyester several times with Double Coat Ontvetter.
<i>Anti-foulings</i>	Can I apply an antifouling on top of IJmopox HB coating?	Most types of antifouling may be applied directly over recently applied IJmopox HB coating. When recoating an aged layer of IJmopox HB coating, grit sanding will be necessary to achieve good adhesion.
<i>Application</i>	What quantity of IJmopox ZF primer or IJmopox HB coating may I prepare before painting?	Prepare a quantity of paint which may be applied within one to two hours. The larger the volume of mixed paint, the higher the temperature will be and the shorter the potlife will be. At higher temperatures the potlife will be shorter.
<i>Application</i>	Can I apply IJmopox HB coating on top of tar epoxies?	It is possible to apply IJmopox HB coating on top of tar epoxies but bleeding may occur. Bleeding will have little effect on durability. We recommend to apply a small area first and check after 48 hours the adhesion.
<i>Application</i>	Should I repaint IJmopox HB coating?	Like any other epoxy IJmopox HB coating will give chaulking, a white deposit of powder, when exposed to sunlight. We recommend to recoat IJmopox HB coating with Double Coat.
<i>Application</i>	How can I clean tools and equipment used for IJmopox HB coating?	Tools and equipment used for the application of IJmopox ZF primer or IJmopox HB coating may be cleaned with IJmopox Verdunner.
<i>Application</i>	What is the correct mixing ratio for IJmopox ZF primer and IJmopox HB coating?	The mixing ratio is printed on the label of the can and in the technical datasheet. The mixing ratio for IJmopox ZF primer is 80 parts by volume base with 20 parts by volume hardener. The mixing ratio for IJmopox HB coating is 75 parts by volume base with 25 parts by volume hardener.
<i>Application</i>	What thinner should I use for IJmopox ZF primer and IJmopox HB coating?	The correct thinner for IJmopox ZF primer and IJmopox HB coating is IJmopox Verdunner. Do not use thinners from other suppliers as these thinners may give unpredictable results.
<i>Application</i>	Can I apply IJmopox ZF primer or IJmopox HB coating to old layers of paint?	IJmopox ZF primer and IJmopox HB coating can be applied to old layers of two component paint. Always check the quality of the previous layer. When this layer does not dissolve or softens when exposed to Double Coat Degreaser, then you can repaint with IJmopox ZF primer or IJmopox HB coating.
<i>Application</i>	Can I apply IJmopox ZF primer or IJmopox HB coating directly to polyester?	IJmopox ZF primer and IJmopox HB coating will give good adhesion to polyester provided the polyester is fully cured, clean and dry, free from

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		any contamination and sanded with grit paper. New polyester should be at least two to three weeks old.
<i>Below the waterline</i>	Can I use IJmopox ZF primer and IJmopox HB coating for areas below the waterline?	Yes.
<i>Curing and drying</i>	Can I cure IJmopox ZF primer and/or IJmopox HB coating at elevated temperatures?	This is possible after a flash-off time of approx. 30 minutes. After this period it is possible to force cure at 40 to 50 °C. At higher temperatures it is possible that air bubbles in GRP may break and cause damages in the surface.
<i>Surface defect</i>	Why does the layer IJmopox ZF primer or IJmopox HB coating become dull?	The durability and gloss retention of epoxy materials is poor. Influenced by UV radiation, yellowing and chalking will take place, which causes the layer to become dull.
<i>Recoating</i>	How soon can Double Coat be applied to IJmopox ZF primer or IJmopox HB coating?	Double Coat can be applied to IJmopox ZF primer at room temperature after 16 hours. Double Coat can be applied to IJmopox HB coating after 8 hours.
<i>Recoating</i>	How soon can I apply IJmopox ZF primer and IJmopox HB coating over a new epoxy laminate?	After 24 hours, IJmopox ZF primer and IJmopox HB coating can be applied over an epoxy laminate. Sand the epoxy laminate before applying IJmopox ZF primer or IJmopox HB coating.
<i>Recoating</i>	How soon can I apply IJmopox ZF primer and IJmopox HB coating to a fresh polyester surface?	The polyester needs to be completely cured. When working at a room temperature, the first layer can be applied after two to three weeks. Mind that polyester often consist of a paraffin top layer or can be contaminated by release agents.
<i>Sanding</i>	What is best: dry or wet sanding?	The best choice is dry sanding. Especially when filler has to be sanded, it is better to use dry sanding. It takes quite some time before moisture has disappeared from the filler.
<i>Temperature</i>	At what temperature should I apply IJmopox ZF primer and IJmopox HB coating?	IJmopox ZF primer and IJmopox HB coating can be applied at a temperature between 5 and 30 °C.

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

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