

### DESCRIPTION

This system describes how a polyester construction may be coated with a two component polyester dd paint system.

### PRINCIPAL CHARACTERISTICS

This system protects polyester constructions exposed to atmospheric exposure conditions in an industrial or coastal environment. Use this system to repair minor defects in a gelcoat. These defects may be caused by a poor quality mould, poor mould release, colour differences or air entrapment in the gelcoat. The coating is resistant to various chemicals, is scratch resistant and has an excellent gloss and colour retention.

### SURFACE CONDITION

Polyester gelcoat, free from loose particles and other contamination and foreign matter.

### SURFACE PREPARATION

1. Clean the surface with Double Coat Ontvetter;
2. Sand surface using grit paper P220-280;
3. Remove the dust thoroughly;
4. Clean the surface again with Double Coat Spuitverdunner.
5. Leave the surface 2 hours to dry.

### MATERIALS AND SPREADING RATES

The following materials are used in this paint system:

Poltix Vezelplamuur	spreading rate depends on condition surface
Poltix Super Plamuur	spreading rate depends on condition surface
IJmofix	spreading rate depends on condition surface
IJmopox HB coating	spreading rate approx. 0,15 l/m <sup>2</sup>
IJmopox Verdunner	spreading rate depends on application method
Double Coat	spreading rate approx. 0,3 kg/m <sup>2</sup>
Double Coat Spuitverdunner	spreading rate depends on application method
Double Coat Ontvetter	spreading rate depends on condition surface

### APPLICATION

1. When joints between separate parts should be repaired and filled, use Poltix Super Plamuur or IJmofix (see additional information);
2. When necessary, repair damages and cracks with Poltix Super Plamuur or IJmofix (see additional information);
3. Apply one coat of IJmopox HB coating at a total dry film thickness of 100 µm (minimum spreading rate approx. 0,15 l/m<sup>2</sup>). Sand surface where necessary;
4. Apply three coats Double Coat at a total dry film thickness of 120 µm (minimum spreading rate approx. 0,3 kg/m<sup>2</sup>). Sand surface between each coat where necessary;
5. When required, it is possible to force dry Double Coat at approx. 30 to 40 °C to accelerate curing.

### ADDITIONAL INFORMATION

- Repair joints  
Fill joints with Poltix Super Plamuur. Use IJmofix in stead of Poltix Super Plamuur when final colours are light shades. Use for wide and deep joints first Poltix Vezelplamuur.
  1. Sand surface with grit paper P120 and remove all dust;
  2. Fill joints with Poltix Super Plamuur. Use IJmofix in stead of Poltix Super Plamuur when final colours are light shades. Use for wide and deep joints first Poltix Vezelplamuur;
  3. Sand surface filled joints with grit paper P180, remove all dust and rinse surface with Double Coat Ontvetter.
  4. Apply one stripe coat Double Coat.

## P2: GELCOAT – WITH MINOR DEFECTS

- **Repair damages**  
Repair damaged areas with Poltix Super Plamuur. Use IJmofix in stead of Poltix Super Plamuur when final colours are light shades. Use first Poltix Vezelplamuur for repairs of deep and wide damages.
  1. Assure that every damage, including small damages, are filled;
  2. Open scratches and fill these with filler;
  3. Sand cracks up to the glass fibre laminate and apply filler;
  4. Sand surface filled joints with grit paper P180, remove all dust and rinse surface with Double Coat Ontvetter.
  5. Apply one stripe coat Double Coat.
- **Sanding**  
A durable adhesion will be achieved by a 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.

- **Silkgloss finish**  
When a silkgloss finish is required, the last coat of Double Coat may be replaced by Double Coat silk gloss.
- **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.

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

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