



## COATING SPECIFICATION FOR ALUMINIUM BOATS 625 – ABOVE WATERLINE

Bare aluminium surfaces should be thoroughly cleaned using AA-6822 Protec Heavy Duty Wax & Grease Remover before sanding, if necessary use a high grade scouring pad to remove heavy areas of grease and imperfections, all this is to be done in a wipe on wipe off motion using clean rags.

Once dry, thoroughly abrade the surface using P240 grit on an orbital sander or by hand rubbing using P320.

Once sanded the aluminium should be thoroughly blown down then cleaned with a 1:1 solution mix of R207 Methylated Spirits and clean water, using a wipe on wipe off action this must be repeated until no residue shows on the cleaning clothes.

\*NOTE: The prepared aluminium must be primed within 6 hours after the preparation process; failure to do this will allow the aluminium to re-oxidise.

- Apply 2 coats EPO-N14 Epotec Primer White

MIX:        4 parts EPO-N14    Epotec Primer White pack "A"  
              1 part EPH20        Epotec Primer Hardener pack "B"

May be thinned up to 15% with: EXR20 Epoxy Reducer Normal,

EXR30 Epoxy Reducer Slow

EXR40 Epoxy Reducer Extra Slow

Sand 408 Epoxy primer by mechanical means within a 3 day period from application.

Thoroughly blow clean with clean compressed air and clean rags, then clean the surface with AA-6822 Protec Heavy Duty Wax & Grease Remover.

### Health and Safety

Please refer to Material Health and Safety Datasheets for full health and safety details.

This product is for professional use only.

The information given in this sheet is for guidance only. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

Drying times quoted are average times at 20°C/68°F. Film thickness, humidity and shop temperature can all affect drying times.



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- Mix 625 Polythane colour then allow to stand for 10 minutes

MIX: 2 parts Polythane AU-625 pack "A"

1 part 625-9225 Standard Hardener pack "B"

May be thinned up to 15% with: PUR20 Polyurethane Reducer Normal  
PUR30 Polyurethane Reducer Slow  
PUR40 Polyurethane Reducer Extra Slow

Apply 2 coats of colour allowing at least 10 minutes flash off time between coats.

The boat may then be force dried for 1 hour at 60°C or allow to air dry for 7 days.

This system is only suitable for use on boats above the waterline. Do not immerse the boat for at least 14 days @ 25°C after applying the final coat of colour.

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