

Substrate temperature	5 - 40	°C
Relative Humidity (RH)	10 - 85	%

The following restrictions must be observed:

- Only apply the coating when the substrate temperature is at least 3°C above the dew point
- Do not apply the coating if the substrate is wet or likely to become wet
- Do not apply the coating if the weather is clearly deteriorating or unfavourable for application or curing
- Do not apply the coating in high wind conditions

Product mixing

Product mixing ratio (by volume)

Single pack

Thinner/Cleaning solvent

Thinner: Jotun Thinner No. 7

Application data

Airless Spray Equipment

Pump ratio (minimum) :	32:1
Pump output (litres/minute) :	1.3-2.2
Pressure at nozzle (minimum) :	150 bar/2100 psi
Nozzle tip (inch/1000) :	17-23
Filters (mesh) :	70

Material hose length :

Several factors influence, and need to be observed to maintain the recommended pressure at nozzle. Among factors causing pressure drop are:

- long paint- and whip hoses
- low inner diameter hoses
- high paint viscosity
- large spray nozzle size
- inadequate air capacity from compressor
- wrong or clogged filters

Other application tools

Brush application

Suitable for application with brush. Use a high quality, clean natural or synthetic bristle brush with proper shape and size. When used as primer coat, a stiff brush is recommended to secure proper substrate wetting. When used as a finish coat a more long haired brush is recommended to improve flow and appearance. To achieve specified dry film thickness it may be necessary to apply multiple coats.

Roller application

Suitable for application with roller. Use a properly sized, high quality, clean roller with natural or synthetic cover. Pre-wash new rollers in proper thinner to remove loose fibres. Roller is not recommended for application of primer coat. Addition of small volumes (5-10 %) of thinner will improve appearance when used as finish coat. To achieve specified dry film thickness it may be necessary to apply multiple coats.

Recommended film thickness per coat

Film thickness and spreading rate	Dry film thickness	Wet film thickness	Theoretical spreading rate (m ² /l)
	(µm)	(µm)	
Minimum	40	120	8,5
Maximum	60	180	5,7
Typical	50	150	6,8

Wet film thickness (WFT) measurement and calculation

To ensure correct film thickness, it is recommended to measure the wet film thickness continuously during application using a painter's wet film comb (ISO 2808 Method 1A). Use a wet-to-dry film calculation table to calculate the required wet film thickness per coat.

A wet to dry film thickness chart is available on the Jotun Web site.

Dry film thickness (DFT) measurement

When the coating has cured to hard dry state the dry film thickness can be checked to SSPC PA 2 or equivalent standard using statistical sampling to verify the actual dry film thickness. Measurement and control of the WFT and DFT on welds is done by measuring adjacent to and no further than 15 cm from the weld.

Ventilation

Sufficient ventilation is very important to ensure proper drying/curing of the film.

Coating loss

The consumption of paint should be controlled carefully, with thorough planning and a practical approach to reducing loss. Application of liquid coatings will result in some material loss. Understanding the ways that coating can be lost during the application process, and making appropriate changes, can help reducing material loss. Some of the factors that can influence the loss of coating material are:

- type of spray gun/unit used
- air pressure used for airless pump or for atomization
- orifice size of the spray tip or nozzle
- fan width of the spray tip or nozzle
- the amount of thinner added
- the distance between spray gun and substrate
- the profile or surface roughness of the substrate. Higher profiles will lead to a higher "dead volume"
- the shape of the substrate target
- environmental conditions such as wind and air temperature

Pre-commissioning considerations

The dry coating film will be gradually softer as temperature increases. Correct procedures for handling and stacking must be established, depending on environmental conditions. Protective properties will not be influenced.

Drying and Curing time

Substrate temperature	5 °C	10 °C	23 °C	40 °C
Surface (touch) dry	1 h	45 min	30 min	15 min
Walk-on-dry	10 h	9 h	7 h	4 h
Dry to over coat, minimum	5 h	4 h	2 h	1.5 h

Drying and curing times are determined under controlled temperatures and relative humidity below 85%, and at the typical DFT for the product.

Surface (touch) dry: The state of drying when slight pressure with a finger does not leave an imprint or reveal tackiness. Dry sand sprinkled on the surface can be brushed off without sticking to or causing damage to the surface.

Walk-on-dry: Minimum time before the coating can tolerate normal foot traffic without permanent marks, imprints or other physical damage.

Dried to over coat, minimum: The shortest time allowed before the next coat can be applied.

Maximum over coating intervals for atmospheric exposure

Substrate temperature	5 °C	10 °C	23 °C	40 °C
Itself	extended	extended	extended	extended

Other conditions that can affect drying / curing / over coating

Adding anti-skid to the coating system

Anti skid aggregate should only be added in the final coat, and should not be used in single coat systems. Spread the aggregate evenly on the surface before half of time to Surface dry. Use Jotun Anti-skid, fine particle size (180 - 250 µm), for coatings applied in 50 to 150 µm DFT. The recommended usage is 1.5 - 2.0 kg per 10 litres of paint.

Water contamination

If the wet coating is exposed to relative humidity above 85% or to moisture before the coating is at least Walk-on-dry, then blushing may occur. Blushing will cause fading of bright colours, and will affect the gloss. Provided the coating is fully dried/cured the protective properties will not be affected. All affected areas should be lightly sanded, cleaned and recoated.

Repair of coating system

Damages to the coating layers:

Prepare the area through sandpapering or grinding, followed by thorough washing. When the surface is dry the coating may be over coated by itself or by another product, ref. original specification.

Always observe the maximum over coating intervals. If the maximum over coating interval is exceeded the surface should be carefully roughened in order to ensure good intercoat adhesion. Damages exposing bare substrate:

Remove all rust, loose paint, grease or other contaminants by spot abrasive blasting, mechanical grinding, water and/or solvent washing. Feather edges and roughen the overlap zone of surrounding intact coating. Apply the coating system specified for repair.

Repair of damaged areas

Sags and runs can be caused by too high wet film thickness, too much thinner added or the spray gun used too close to the surface.

Repair by using a paint brush to smooth the film when still wet.

Sand down to a rough, even surface and re-coat if dry. Orange peel can be caused by poor flow/levelling properties of the paint, poor atomization of the paint, thinner evaporating too fast or the spray gun held too close to the surface.

This can be rectified by abrading the surface and applying an additional coat after having adjusted the application properties or the application technique. Dry spray can be caused by poor atomization of the paint, spray gun held too far from the surface, high air temperature, thinner evaporating too fast or coating applied in windy conditions. Physically drying paints can be solvent wiped and another coat applied. If area is too large to practically solvent wipe, consider sandpapering or grinding, followed by thorough washing. When the surface is dry the coating may be over coated by itself. Pinholes can be caused by entrapped solvents in the film or by incorrect application technique. Pinholes can be repaired as per procedure for damages to the coating layer or to

the substrate, ref. above.

Coating film continuity

When required by the specification, the coating shall be tested for film discontinuity according to ASTM D 5162, test method A or B as appropriate for the actual dry film thickness. All recorded defects shall be repaired by best practical means.

Quality assurance

The following information is the minimum recommended. The specification may have additional requirements.

- Confirm all welding and other metal work, whether internal or external to the tank, has been completed before commencing pre-treatment and surface preparation of the substrate
- Confirm installed ventilation is balanced and has the capacity to deliver and maintain the RAQ
- Confirm the required surface preparation standard has been achieved and is held prior to coating application
- Confirm that the climatic conditions are within recommendation in the AG and held during the application
- Confirm the required number of stripe coats have been applied
- Confirm each coat meets the DFT requirements of the specification
- Confirm the coating has not been adversely affected by rain or any other agency during curing
- Observe adequate coverage has been achieved on corners, crevices, edges and surfaces where the spray gun cannot be positioned so that its spray impinges on the surface at 90°
- Observe the coating is free from defects, discontinuities, insects, spent abrasive media and other contamination
- Observe the coating is free from misses, sags, runs, wrinkles, fat edges, mud cracking, blistering, obvious pinholes, excessive dry spray, heavy brush marks and excessive film build
- Observe the uniformity and colour are satisfactory

All noted defects should be fully repaired to conform to the coating specification.

Caution

This product is for professional use only. The applicators and operators shall be trained, experienced and have the capability and equipment to mix/stir and apply the coatings correctly and according to Jotun's technical documentation. Applicators and operators shall use appropriate personal protection equipment when using this product. This guideline is given based on the current knowledge of the product. Any suggested deviation to suit the site conditions shall be forwarded to the responsible Jotun representative for approval before commencing the work.

For further advice please contact your local Jotun office.

Health and safety

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not inhale spray mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

Accuracy of information

Always refer to and use the current (last issued) version of the TDS, SDS and if available, the AG for this product. Always refer to and use the current (last issued) version of all International and Local Authority Standards referred to in the TDS, AG & SDS for this product.

Colour variation

Some coatings used as the final coat may fade and chalk in time when exposed to sunlight and weathering effects. Coatings designed for high temperature service can undergo colour changes without affecting performance. Some slight colour variation can occur from batch to batch. When long term colour and gloss retention is required, please seek advice from your local Jotun office for assistance in selection of the most suitable top coat for the exposure conditions and durability requirements.

Reference to related documents

The Application Guide (AG) must be read in conjunction with the relevant specification, Technical Data Sheet (TDS) and Safety Data Sheet (SDS) for all the products used as part of the coating system.

When applicable, refer to the separate application procedure for Jotun products that are approved to classification societies such as PSPC, IMO etc.

Symbols and abbreviations

min = minutes

h = hours

d = days

°C = degree Celsius

° = unit of angle

µm = microns = micrometres

g/l = grams per litre

g/kg = grams per kilogram

m²/l = square metres per litre

mg/m² = milligrams per square metre

psi = unit of pressure, pounds/inch²

Bar = unit of pressure

RH = Relative humidity (% RH)

UV = Ultraviolet

DFT = dry film thickness

WFT = wet film thickness

TDS = Technical Data Sheet

AG = Application Guide

SDS = Safety Data Sheet

VOC = Volatile Organic Compound

MCI = Jotun Multi Colour Industry (tinted colour)

RAQ = Required air quantity

PPE = Personal Protective Equipment

EU = European Union

UK = United Kingdom

EPA = Environmental Protection Agency

ISO = International Standards Organisation

ASTM = American Society of Testing and Materials

AS/NZS = Australian/New Zealand Standards

NACE = National Association of Corrosion Engineers

SSPC = The Society for Protective Coatings

PSPC = Performance Standard for Protective Coatings

IMO = International Maritime Organization

Disclaimer

The information in this document is given to the best of Jotun's knowledge, based on laboratory testing and practical experience. Jotun's products are considered as semi-finished goods and as such, products are often used under conditions beyond Jotun's control. Jotun cannot guarantee anything but the quality of the product itself. Minor product variations may be implemented in order to comply with local requirements. Jotun reserves the right to change the given data without further notice.

Users should always consult Jotun for specific guidance on the general suitability of this product for their needs and specific application practices.

If there is any inconsistency between different language issues of this document, the English (United Kingdom) version will prevail.
