

1 SURFACE PREPARATION

- Clean all surfaces using water soluble detergent and high pressure fresh water.
- Remove rust manually or mechanically by use of power tools. Avoid smooth surfaces for best adhesion.
- Work to limit edges by feathering.
- Remove all particles and clean the surface prior to painting. Paint immediately after the surface is prepared.

IMPORTANT
Ensure surface is dry and free from contamination prior to application.

2 PAINT PREPARATION

- For one component paint, be sure to stir the paint using a mechanical mixer for minimum two minutes.
- For two component paint, check that you have the correct component A and B. Stir both component A and B separately with a mechanical mixer for minimum two minutes.
- Add components in correct mixing ratio slowly into a clean tin. Then stir with a mechanical mixer for minimum two minutes.
- Adhere to induction time and pot life stated in the TDS before applying the paint.

IMPORTANT
Consult the TDS for the correct mixing ratio and the correct hardener.

3 PAINT APPLICATION

- For larger jobs, we recommend to use a spray gun. Check equipment prior to application.
- Use paint brush for difficult to reach areas and for primer application direct on steel. Ensure that brushes are clean. Pitted areas should be touched up by brush before roller application. Dip brush often.
- Ensure that rollers are clean. Use a roller board. Phenolic rollers with short hair are recommended. Dip roller often. Over rolling can cause paint pick up with fast drying paint.
- Apply the last stroke in one direction to ensure a uniform finish.
- Do not paint under wet conditions: During rain, high humidity (above 85%), snow, mist and fog or surface wet with condensation.

IMPORTANT
Do not paint when the substrate temperature is under the minimum drying limit, or if dry to recoat maximum painting interval is exceeded.

HEALTH Avoid breathing in the vapours/fumes by working in ventilated areas, and if necessary use respirator mask. Use safety goggles or glasses. Avoid skin contact by wearing gloves and boiler suit.

SAFETY Store the paint in a dry shaded area, preferably in the paint locker. Assess and secure the area for flammable liquids or gases that may ignite when using mechanical power tools. Be sure to have good ventilation during painting operations. Remove all naked lights and unprotected electrical equipment while painting.

ENVIRONMENT Do not allow the spillage of paint residues to enter drains or water sources. Material and container must be disposed as hazardous waste.

RECOMMENDED PERSONAL PROTECTIVE EQUIPMENT:

- Boiler suit
- High visibility vest or jacket
- Ear protection
- Safety goggles or glasses
- Safety helmet
- Safety boots and gloves
- Respirator mask
- Safety harness

Consult the Safety Data Sheet (SDS), available for all products.

See Onboard Maintenance Paint Guide or jotun.com for more information.