



PAINTING SYSTEMS FOR Aluminium Vessels

ABOVE WATERLINE

MINIMUM SURFACE PREPARATION

- Loose paint and heavy corrosion to be removed by scraping. Oil, grease, salts and other contaminates etc to be removed with a suitable detergent and high pressure fresh water wash.
- All existing topcoat to be removed back to sound primer, ensuring that this remaining primer is sanded to a minimum 36g profile.
- Corroded and damaged aluminium areas, and areas where the existing primer is not stable to be power-tool cleaned to minimum St. 2 (ISO 8501-1:2007), grinding with 24g-36g discs to remove this and expose fresh aluminium. Edges to remaining intact primer to be feathered, if not removing system completely.
- Blow down surface with dry, filtered air to remove filings from aluminium, and solvent wipe the sanded paint surface. Commence initial primer application to exposed, clean aluminium before surface is contaminated, and in any event within 6-8 hours.

Present System	Primer Coat to exposed aluminium	Coats x DFT um	Intermediate Coat to whole surface	Coats x DFT um	Finishing Coat	Coats x DFT um
Epoxy	Jotacote 605	1 x 200	Jotacote 605	1 x 200		
Epoxy / Polyurethane	Jotacote 605 or Penguard HB or Penguard Special	1 x 200 1 x 150 1 x 150	Penguard HB	1-2 x 150	Imperite 300 or Hardtop Ultra/AS	2-3 x 40 2-3 x 40
Epoxy / Acylic Enamel	Jotacote 605	1 x 200	Penguard HB or Alkyd Primer	1-2 x 150 3 x 50	Pioner Topcoat or Pilot II	2 x 50 2 x 40

Finishing coat may be deleted if colour and gloss retention is not of high importance.

Jotun Non-Skid/Non-Spark Additive may be used at the applicator's discretion between topcoats to achieve the desired level of non-skid textured finish for deck areas. The additive may be broadcast into the first wet coat of topcoat then sealed with the second coat. Alternatively spray additive with the second coat.

Typical Dry Film Thickness in Microns (DFT um) recommended to achieve by spray application. When brushing/rolling, extra coats may be required to achieve the specified film thickness. Brushing/rolling application achieves on average 80um DFT per coat.

The systems shown are minimum examples of the many options available. Jotun can further advise on the system which offers the most economical and effective solution to your needs. Contact Jotun per reverse-side details.



DESCRIPTION OF PRODUCTS

Products	Description
Alkyd Primer	<i>Alkydprimer is a single-pack alkyd based primer. As a primer for steel and aluminium structures as part of a suitable alkyd system.</i>
Hardtop Ultra/AS	<i>Hardtop is a two-pack polyurethane topcoat. As topcoat over an epoxy/epoxymastic system where a durable finish is required in aggressive atmospheric exposure.</i>
Imperite 300	<i>Imperite 300 is a high gloss two-pack polyester-polyurethane topcoat with excellent gloss and colour retention. As a topcoat over an epoxy system where a durable, high gloss finish is required in aggressive atmospheric exposure.</i>
Jotacote 605 Fast Cure	<i>Jotacote 605 is a two-pack high build, high solids surface-tolerant epoxy coating. For protection of steel, galvanized steel, aluminium and concrete in aggressive locations.</i>
Penguard HB	<i>Penguard HB is a high build, two-pack epoxy coating based on epoxy resin with high molecular weight. Easy to sand.</i>
Penguard Special	<i>Penguard Special is a high build, two-pack zinc phosphate pigmented epoxy coating based on epoxy resin with high molecular weight. As an anti corrosive primer and intermediate coating for corrosion protection. Easy to sand.</i>
Pilot II	<i>Pilot II is a single-pack alkyd based topcoat for both exterior and interior use. Topcoat in a traditional alkyd system suitable for steel and woodwork. Good weather and colour stability. Good hiding power.</i>
Pioner Topcoat	<i>Pioner Topcoat is a single-pack acrylic resin based topcoat. Finishing coat for protection of steel and concrete in a variety of climatic conditions, exterior and interior.</i>

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Please refer to relevant Technical Data Sheets (TDS) for further information, recoating and curing conditions, or contact Jotun for details. Unless otherwise agreed in writing, all product supplied and technical advice given by us are subject to our standard terms and conditions of sale. In the event that supplies are made and technical advice is given by one of our associated companies or dealers, then such supplies and technical advice shall be subject to the standard terms of sale of that company, a copy of which is available upon request. The given data must be considered as guidelines only.
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