System
Surface treatment

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Painting sequence	Cleaning material / painting material	Mixing ratio by weight	Theoretical coveage approx. m² / l	Application	Application surface temperature	Drying time at 20° C, 80 % rel. humidity in hours		Overcoating intervall		Thinner / cleaner for tools	Recommended surface preparation for different boat building material			
						dust-dry	resistant to	min. h.	max. days		glass-fibre rein-forced plastic	nordic wood	hard and tropical wood	galvanized steel, stainless steel, sea-water resistant aluminium, non-ferrous metals
1	D 49 Cleaner 350		15 *	big brush	5-30	./.	./.	./.	./.	**W**	X			X
1a	D 23 Thinner 990		10 *	P/big brush	5-30	./.	./.	./.	./.	./.			X	
1b	D 04 wood preservative impregnating oil, only with 1-k systems		10 *	P	5 -30	5	8	72	180	799		X		

date 2009

P = brush , R = roller , AS = airless spraying , LS = air spraying **W = water**

* according to degree of soiling or absorbency of the ground.

After surface treatment, paint according to the chosen system. Observe the data sheets !

Important Hints !

Coating interval
For all 1 and 2 component products a "minimal" and a "maximal" coating interval has absolutely to be taken into consideration. The coating interval not only indicates the coatability of the product with itself, but also with other subsequent products. Too "early" coating causes inclusion of solvents and hardening disturbances. The consequence of water load is blistering. Too "late" coating prevents the adhesion to the ground, because e.g. with 2 component products the material is already hardened. For the exceeding of the indicated "maximum" coating interval in any case, even with 1 component products, a dull-grinding of the ground before re-coating is absolutely necessary (mechanical clinging of the following coats to the ground) .

Drying time
The drying time depends largely on the temperature - and here always the surface temperature in the drying phase is decisive. Low temperatures decelerate, high temperatures accelerate. Each 10° C change in the temperature causes a substantial change of the drying time. The chemical hardening with 2 component products requires in general a minimum hardening temperature of +10° C, as with low temperatures the hardening stops. The second important point in the drying process is the relative humidity of the air. The more humid the air, the slower the drying. Relative humidities above 80% are critical (dimming of the surface, in places exceeding of the dew point is possible). Furthermore, blasts and insolation are to be considered. When working in closed spaces, good aeration has to be provided, as solvent vapours are heavier than air and can cause drying delays and dimming. Besides, "danger hints and safety advice" on the label of the packing drums have to be observed.

Dew point
Formation of dew and hair-frost are generally known. The reason for this is the solubility of water in air that differs with the different temperatures (until to saturation at -18° C about 1 g and at 0° C around 5 g, at +23° C approximately 20 g and at +30° C about 30 g water per m^3 air dissolve). If the maximum quantity of water that is soluble at the corresponding temperature is absorbed by the air, the relative humidity of the air is 100%. Cooler surfaces are covered by a partially invisible film of dew, which is e.g. caused by wind, night cool, filled tanks or dried rain resp. drying colours. When water and solvents evaporate, warmth is withdrawn from the ambiance, i.e. the latent heat causes cooling of the surface. For this reason in practice it is assumed that painting must only be done at temperatures that are 3° C above the dew point or at a relative humidity of the air of maximum 80%.

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These system and product informations are not binding planning aids.

The previous data sheet editions herewith lose their validity.