

## System VIII

### Osmosis treatment



In principle, the damaged gelcoat or the possibly defective laminate has to be removed. Adequate methods are rasping or sandblasting, for the latter a special wet jet procedure has proven to be particularly effective ( more information on demand ). Afterwards clean carefully with high-pressure water at a distance of approx. 10 cm to remove all traces of salts and decomposition products. **The following penetrating, thorough drying must be observed above all.** We recommend to tent the boat in ( apron from boot top on ) and to work with dry pots or air dehumidifiers. The surface must be free from loose particles, dust and fat. For large-surface removal of laminate, it must be tested whether the constructive solidity ( object stability ) is still guaranteed and corresponds to the safety regulations. The punctual sanitation in some places is not recommendable, as later on in not machined places osmosis may reappear.

Painting sequence	Coating material	Mixing ratio by weight	Theoretical cover-age approx. m <sup>2</sup> / l	Application	Application surface temperature	Drying time at 20° C, 80 % rel. humidity		Overcoating interval	max. days	Thinner / cleaner for tools	Recommended number of coatings	Comments to the system
						dust-dry	resistant to rain	min. h.				
1	D 53 antorit epoxy primer	10+1	13,7	P/R/AS/LS	10-30	1	12	3	180	809	1	lightly polish before further filling and smoothing
1a	Only if object stability has to be re-established ! D 55 epoxy-resin M 9026	2+1	1 kg per 500	P / R	10-30	1	3	3	1**	809	2-3	The additional (acc. to the construction calculation necessary) glass insert is laminated on top, if the lamination is done in several layers, wet in wet. Attention: Only use glass with skim fit for epoxy
2	D 87 Epoxy- fine filler until to 1 mm thickness per layer	2+1	as required	filler	10-30	3-4*	no	8	1**	809	as required	Fill holes and bubbles up to max. 3 mm total thickness of layer (3 operations)
	alternatively: D 84 Epolith- fine filler until to 2 cm thickness per layer	2+1	as required	filler	10-30	4*	no	8	1**	809***	as required	Fill all over up to max. 4 cm total thickness of layer (2 operations)
3	D 87 Epoxy-fine filler	2+1	1	filler	10-30	3-4*	no	8	1**	809***	1	Apply the material with smoothing trowel/spattle. Polish all over and finish if necessary until a smooth surface results.
4	D 80 Universalgrund 6055		11	P/R/AS/LS	5-30	1	2	3	90	799	1	
2	D 53 antorit epoxy primer	10+1	13,7	P/R/AS/LS	10-30	1	12	3	180	809	2	
5	antifouling / type acc. to area of journey see table of antifouling										2	

P = brush , R = roller , AS = airless spraying , LS = air spraying

\* polishable

\*\* afterwards polishing is necessary

\*\*\* only for cleaning the tools

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