

# Painting Running Gear



Ensure you are using the proper personal protective equipment (PPE).

## BARE METAL (BRONZE, STEEL & STAINLESS STEEL)



1. It is imperative to remove all grease, oil, dirt or other foreign contaminants by wiping down the surface with Interlux Fiberglass Solvent Wash 202 using the 'Two-Rag' method.



2. **Grit blast or disc grind surface** to a uniform 3-4 mils (75–100 microns) clean surface profile. For a grit blast use medium mesh silica sand or other nonmetallic blast media, for disc grind use a 24 to 36-grit abrasive disc.



3. **Remove all blasting or grinding residue by brushing the surface with a stiff brush** along with using clean (oil and water free) compressed air or alternatively the surface can be vacuumed.



4. **Within one hour of grit blasting or disc grinding, (make sure during this time the surface stays clean and dry with no condensation or dew) apply a minimum of 2 coats of InterProtect® 2000E** directly to the bare metal, thinning the 1st coat with 2316N or 2333N thinner, up to 15% by volume. Apply 2nd coat of InterProtect 2000E, allowing for the appropriate overcoat time as per label. **To protect against metal corrosion a 10 mil barrier of InterProtect 2000E is required. A 10 mil barrier is achieved by applying 4-5 unthinned coats of InterProtect 2000E.**



5. **Apply 2-3 coats of Interlux Antifouling Paint** following the appropriate overcoat times as per product labels.

## PREVIOUSLY PAINTED METAL (BRONZE, STEEL & STAINLESS STEEL)

### Unknown Antifouling Paint – Good Condition



1. **Remove all surface contaminants by wiping down the surface** with Special Thinner 216 using the 'Two-Rag' method.



2. **Sand surface with 80-grit sandpaper.** Remove all sanding residue with Special Thinner 216 using the 'Two-Rag' method.



3. If bare metal is present:
  - a. **Disc grind any areas with exposed bare metal** with 24 to 36-grit abrasive disc to a uniform 3-4 mils (75–100 microns) clean surface profile.



- b. **Remove all grinding residue by brushing the surface with a stiff brush** along with using clean (oil and water free) compressed air or alternatively the surface can be vacuumed.



- c. **Within one hour of disc grinding, (make sure during this time the surface stays clean and dry with no condensation or dew) apply two coats minimum, of Primocon YPA984** using a multi-layer process and following the appropriate overcoat times as per product label.



4. **Apply 2-3 coats of Interlux Antifouling Paint** following the appropriate overcoat times as per product labels.



AkzoNobel

# Painting Running Gear



Ensure you are using the proper personal protective equipment (PPE).

## PREVIOUSLY PAINTED METAL (BRONZE, STEEL & STAINLESS STEEL)

### Unknown Antifouling Paint – Poor Condition



1. Remove all previous coatings, down to bare metal.



2. It is imperative to remove all grease, oil, dirt or other foreign contaminants by wiping down the surface with Interlux Fiberglass Solvent Wash 202 using the 'Two-Rag' method.



3. Grit blast or disc grind surface to a uniform 3-4 mils (75–100 microns) clean surface profile. For a grit blast use medium mesh silica sand or other nonmetallic blast media, for disc grind use a 24 to 36-grit abrasive disc.



4. Remove all blasting or grinding residue by brushing the surface with a stiff brush along with using clean (oil and water free) compressed air or alternatively the surface can be vacuumed.



5. Within one hour of grit blasting or disc grinding, (make sure during this time the surface stays clean and dry with no condensation or dew) apply a minimum of 2 coats of InterProtect® 2000E directly to the bare metal, thinning the 1st coat with 2316N or 2333N thinner, up to 15% by volume. Apply 2nd coat of InterProtect 2000E, allowing for the appropriate overcoat time as per label. To protect against metal corrosion a 10 mil barrier of InterProtect 2000E is required. A 10 mil barrier is achieved by applying 4-5 unthinned coats of InterProtect 2000E.



6. Apply 2-3 coats of Interlux Antifouling Paint following the appropriate overcoat times as per product labels.

## PREVIOUSLY PAINTED METAL (BRONZE, STEEL & STAINLESS STEEL)

### Known Antifouling Paint



1. Refer to the Interlux antifouling compatibility chart for compatibility and surface preparation recommendations.

2. If bare metal is present:



- a. Disc grind any areas with exposed bare metal with 24 to 36-grit abrasive disc to a uniform 3-4 mils (75-100 microns) clean surface profile.



- b. Remove all grinding residue by brushing the surface with a stiff brush along with using clean (oil and water free) compressed air or alternatively the surface can be vacuumed.



- c. Within one hour of disc grinding, (make sure during this time the surface stays clean and dry with no condensation or dew) apply two coats minimum of Primocon YPA984 using a multi-layer process and following the appropriate overcoat times as per product label.



3. Apply 2-3 coats of Interlux Antifouling Paint following the appropriate overcoat times as per product labels.