Painting GRP/FRP

Surface Preparation for - Bare GRP/FRP

All GRP/FRP substrates should be thoroughly degreased and cleaned, with a suitable surface cleaner and degreaser to remove traces of mould release agents or other traces that may be present, which could represent a problem for the subsequent coating system. The surface should be lightly sanded with medium to -fine abrasive paper (180-220) to provide a keying pattern for the subsequent coating system. All dust and sanding residues should be thoroughly removed from the substrate. It is also important that the laminated has had time for its resin to sure before the application of a coating system. Any imperfection in the gelcoat surface for example, pinholes, blisters, cracks should be treated before the application of the coating system.

Previously Painted Surfaces - Topsides

If the existing coating is in good condition and adhesion is still good, with no blisters, or flaking, proceed with thoroughly degreasing and cleaning the existing coating (possible to use Space SP – Anti-silicone clearer) followed by sand papering the surface with medium -fine abrasive paper (180-240). All dust and sanding residues should be thoroughly removed from the substrate. Apply the appropriate undercoat/primer or topcoat as required, following the products application guide.

If the existing coating is in poor condition, blistering, flaking with loss of adhesion to the substrate, it is recommended to remove the old coatings from the substrate, with either a remover such as Skipper's Line Stripcarena (water thinnable remover) or by sand papering. And then proceed with the preparation as described for bare substrates.

Previously Painted Surfaces - Below the waterline

If the existing coating is in good condition, it is generally enough to remove any powdering or loose parts of the old antifouling and apply 2 coats of the new antifouling which is compatible with the existing one. If the antifouling is unknown it is recommended to apply 1-2 coats of Skipper's Line Solver Primer before the application of the new antifouling.

If the existing coating is in poor condition, cracking, flaking and loss of adhesion, or blistering from the substrate, it is recommended to remove the old antifouling with a suitable antifouling remover such as Skipper's Line Stripcarena. All dust and residues should be thoroughly removed from the substrate. Then proceed with preparation as described for bare substrates.

One – Component Indicative Coating Systems

1. Bottom Coating System – Below Waterline

No of Coats	Product Name	Thinner		Coverage (m2/Lt)	Recoating (at 20˚C)
1-2	**Unifiber Primer**	0-5% Brush 765	10-20% Spray 765	10	Min 6 hours
1-2	**Solver Primer**/intermediate coat	10-25% Brush 400	15-30% Spray 400	4-6	Min 6 hours
2	**Standard Plus** Antifouling	Max 5% Brush 400	10% Spray 400	10-12	18-24 hours

2. Topside Coating System – Above Waterline

No of Coats	Product Name	Thinner		Coverage:(m2/Lt)	Recoating (at 20˚C)
1-2	**Unifiber Primer**	0-5% Brush 765	10-20% Spray 765	10	Min 6 hours
2-3	**Sottofondo** Undercoat	10-20% Brush 107	20-30% Spray 900	9-10	18-24 hours
2	**Topkapi** Yacht Paint or **Topkapi Satin** Yacht Paint	10-20% Brush 107/109 10-20% Brush 107/109	10-25% Spray 900 10-25% Spray 900	11-13 11-13	18-24 hours 18-24 hours

Two – Component Indicative Coating Systems

1. Bottom Coating System – Below Waterline

No of Coats	Product Name	Thinner		Coverage (m2/Lt)	Recoating (at 20˚C)
1-2	**Polifiber Primer**	15-30% Brush 205/203	25-35% Spray 203	10	18-24 hours
1-2	**Solver Primer**/intermediate coat	10-25% Brush 400	15-30% Spray 400	4-6	Min 6 hours
2	**Standard Plus** Antifouling	Max 5% Brush 400	10% Spray 400	10-12	18-24 hours

2. Bottom Coating System – Below Waterline

No of Coats	Product Name	Thinner		Coverage (m2/Lt)	Recoating (at 20˚C)
1-2	**Epofond AM/9** Epoxy Primer	10-15% Brush 765	15-25% Spray 765	8-9	12-24 hours
1-2	**Solver Primer**/intermediate coat or **Unifiber Primer**	10-25% Brush 400 0-5% Brush 765	15-30% Spray 400 10-20% Spray 765	4-6 10	Min 6 hours Min 6 Hours
2	**Standard Plus** Antifouling	Max 5% Brush 400	10% Spray 400	10-12	18-24 hours

Two – Component Indicative Coating Systems continued

3. Bottom Coating System – Below Waterline – Osmosis Prevention					
No of Coats	**Product Name**	**Thinner**		**Coverage (m2/Lt)**	**Recoating (at 20˚C)**
2-3	**Epofond HB** Epoxy Primer	10-15% Brush 765	15-20% Spray 765	4-5	12-24 hours
1-2	**Solver Primer**/intermediate coat or **Unifiber Primer**	10-25% Brush 400 0-5% Brush 765	15-30% Spray 400 10-20% Spray 765	4-6 10	Min 6 hours Min 6 Hours
2	**Standard Plus** Antifouling	Max 5% Brush 400	10% Spray 400	10-12	18-24 hours

4. Topside Coating System – Above Waterline					
No of Coats	**Product Name:**	**Thinner**		**Coverage (m2/Lt)**	**Recoating (at 20˚C)**
2	**Polifiber Primer**	10-30% Brush 205/203	25-35% Spray 203	10	18-24 hours
2-3	**Polifond Undercoat**	15-30% Brush 205	25-35% Spray 203	14-15	12-24 hours
2	**Acriglass Finish** Yacht Paint or **Space Top Pro Finish** Yacht Paint or **Whitext Bucciato** Textured Finish	15-25% Brush 205 20-30% Brush 205/201 5-10% Brush 205	20-35% Spray 203 20-35% Spray 205/201 5-10% Spray 203	10 13-14 5-6	24 hours 18-24 hours 24 hours

5. Topside Coating System – Above Waterline					
No of Coats	**Product Name:**	**Thinner**		**Coverage (m2/Lt)**	**Recoating (at 20˚C)**
2	**Epofond AM/9** Epoxy Primer	10-15% Brush 765	15-25% Spray 765	8-9	12 -24 hours
2-3	**Polifond** Undercoat	15-30% Brush 205	25-35% Spray 203	14-15	12-24 hours
2	**Acriglass Finish** Yacht Paint or **Space Top Pro Finish** Yacht Paint or **Whitext Bucciato** Textured Finish	15-25% Brush 205 20-30% Brush 205/201 5-10% Brush 205	20-35% Spray 203 20-35% Spray 205/201 5-10% Spray 203	10 13-14 5-6	24 hours 18-24 hours 24 hours

Osmosis Prevention Indicative Coating System

1. Bottom Coating System – Below Waterline					
No of Coats	**Product Name**	**Thinner**		**Coverage (m2/Lt)**	**Recoating (at 20˚C)**
2-3	**Epofond HB** High Build Primer	10-15% Brush 765	15-20% Spray 765	4-5	12-24 hours
2	**Solver Primer**/intermediate coat or **Unifiber Primer**	10-25% Brush 400 0-5% Brush 765	15-30% Spray 400 10-20% Spray 765	4-6 10	Min 6 hours Min 6 Hours
2	**Standard Plus** Antifouling	Max 5% Brush 400	10% Spray 400	10-12	18-24 hours

Osmosis Treatment Indicative Coating System

1. Bottom Coating System – Below Waterline					
No of Coats	**Product Name**	**Thinner**		**Coverage (m2/Lt)**	**Recoating (at 20˚C)**
4-5	**Eposealer** Epoxy Primer	15-20% Brush 765	20-25% Spray 765	5	18-24 hours
1-2	**Epofond AM/9** Epoxy primer	10-15% Brush 765	15-25% Spray 765	8-9	12-24 hours
2	**Solver Primer**/intermediate coat or **Unifiber Primer**	10-25% Brush 400 0-5% Brush 765	15-30% Spray 400 10-20% Spray 765	4-6 10	Min 6 hours Min 6 Hours
2	**Standard Plus** Antifouling	Max 5% Brush 400	10% Spray 400	10-12	18-24 hours

Note: *The product information is a general overview to help when deciding which product to use. Please see the product's technical data sheet for specific information.*