

## **Steel boats**

### Painting instructions



## 1. Painting untreated steel surfaces

### Washing

Remove grease and dirt with e.g. RENSA STEEL washing agent and rinse the surface thoroughly with clean fresh water.

### Steelwork

Remove welding slag and spatters carefully, sharp edges are rounded.

### Surface preparation

Blast-clean the body of the boat to grade Sa 2½ to bare steel.

### 1.1 PAINTING THE SHIP BOTTOM

Stripe coat sharp edges, corners and welded seams with a brush before the actual painting with TEKNOPLAST PRIMER 5 epoxy primer.

#### TEKNOPLAST PRIMER 5

3 x 80 µm

Application is performed in a way that the recommended dry film thickness is achieved and the paint coat is uniform and dense.

### Antifouling paint

If needed use antifouling paint. Film thickness by manufacturer's recommendations. The antifouling paint needs to be compatible with the epoxy primer.

### 1.2 PAINTING INNER PARTS OF THE BOTTOM

Parts behind the lining  
**TEKNOPLAST PRIMER 5**  
 2 x 60 µm

Bilge  
**TEKNOPLAST PRIMER 5**  
 3 x 80 µm

### 1.3 PAINTING THE SIDES ABOVE THE WATERLINE, THE DECK AND THE SUPERSTRUCTURE

Priming  
**TEKNOPLAST PRIMER 5**  
 2 x 60 µm

Top coating  
**TEKNODUR 0190**  
 2 x 40 µm

If needed sand the top coat between layers with sandpaper no. 280–320.

## 2. Maintenance painting

### Washing

Remove slime, vegetation and dirt with high pressure washing, brushing and scraping. Wash surfaces with RENSA STEEL washing agent and rinse thoroughly with clean fresh water.

### Surface preparation

Remove loose old paint e.g. by scraping, solid paint surfaces are to be roughened by sanding. Damages reaching the steel surface are blast-cleaned to grade Sa 2½ to bare steel. Remaining paint and fringe areas of the bottom are feathered by sanding.

### 2.1 PAINTING THE SHIP BOTTOM

#### Touch up painting of damaged parts

**TEKNOPLAST PRIMER 5**

3 x 80 µm

First application by brushing.

### Antifouling paint

If needed use antifouling paint. Film thickness by manufacturer's

recommendations. The antifouling paint needs to be compatible with the epoxy primer.

### 2.2 PAINTING THE SIDES ABOVE THE WATERLINE, THE DECK AND THE SUPERSTRUCTURE

#### Touch up painting of damaged parts

**TEKNOPLAST PRIMER 5**

1 x 60 µm By brushing

Top coating  
**TEKNODUR 0190**  
 2 x 40 µm

**Note!** Recommended film thickness is usually reached only by airless spraying. When applied by brush or conventional spray additional coats might be needed. If needed stop up pits and corrosion with TEKNOPOX FILL epoxy stopper. Before stopping blast-clean the surface.

TEKNODUR 0190 can be tinted with Teknos' tinting systems.

When the object is required to have excellent gloss and colour retention, it's recommended to use TEKNODUR 0290 Polyurethane Varnish as a top coat.

More information about the painting work can be found from the technical data sheets of the paints from Teknos Group's website [www.teknos.com](http://www.teknos.com).

**[www.teknos.com](http://www.teknos.com)**