



GENERAL APPLICATION REQUIREMENTS FOR PAINTING STEEL VESSELS WITH POR-15 RUST PREVENTATIVE PAINT

Revised 28.5.09

*Note: this is only a general application guide, and may vary depending on age, materials / existing coatings / service use and time constraints. **Getting the metal DRY is Key to success.***

APPLICATION—For the best results

For most people slipway time is expensive and so it is a quick job and back in the water as fast as possible but **POR-15 needs a three to five days to cure before being immersed.**

1. **The best way** is a good white metal blast. Ideal, or grind back to clean metal.
2. You should paint *within 24 hours* of blasting, although this can be extended if humidity is in the medium to low range.
3. Any areas that are leaching e.g. salt water impregnated, porous metal, should be double sand blasted and dried with heat gun / blow torch (were possible), or left to leach as long as possible, (around a week).
The surface should then be re-blasted or prepped with Metal Ready (leave on and keep wet for 1/2 hr) and **dried thoroughly**. Water contains oxygen and moisture both the ingredients for rust.

Not Sandblasting (If you are unable to sand blast, wire brush, or grind and sand to remove all the loose rust. Drill operated wire brushes, are not suitable as they leave a polished surface, rough with sandpaper. If this preparation is used, sanding or roughing up the metal is essential. Use of Metal Ready (apply and keep wet for 1/2 hr) is important to promote paint adhesion.

4. Always apply a minimum of 3 coats. Apply, Black, Clear or Grey first, but not Silver. Use Silver in subsequent coats.
5. Apply subsequent coats of POR-15 Rust Preventative Paint within 12 hours, (ideal 3—5 hours is the *best method*). this *maybe* extended to 24 hours. Adhesion between the two coats will be less, but, it is still acceptable.
6. After the final coat of POR-15 Rust Preventative Paint is *touch dry*, any other topcoat, (except, Tie-coat/ Acid 8), **MUST** be applied within 12 hours. The best results can be obtained when painting after *3–6 hours of application*.
Tie-Coat or U POL Acid 8, however, may be applied (**thin coat**) at any stage (best within a week) over a cured POR-15, (as long as it is still clean). Tie-Coat needs at least 24hrs to cure Acid 8, 1-2 hrs. **Do not** leave the Tie-coat or Acid 8 exposed to the weather. Cover and top coat after allowing it to cure for at least 24 hours. (Acid 8, 1-2 hrs)

Internal Surfaces

The above applies although if it is unlikely you will sandblast.

- A. Sand/Grind brush off all loose rust.
- B. Spray on Metal Ready and leave on for 1/2 hour, keeping it wet. This gets off the surface rust.
- C. Wash off and dry, heat gun, blow torch, hair dryer etc.) this is a **key** part of this process.
- D. Paint on the first coat of POR-15 Rust Preventive Paint.
- E. **Second Coat, 3—5 hours**, later (up to 24 hours, maximum) and similarly with the third coat.

If there is going to be exposure to the sun and UV rays, a top coat needs to be applied, (as above)
Should any small rust bubbles appear after a few days then the surface was not dry. Rub them back, dry the area and re-apply in those areas.

A dry surface is the key to be good result

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