



ENDURA

PAINT

PAINT that
OUTLASTS & OUTPERFORMS

Marine Coating System

Paint Specification: July 2014 rev1



::Below the Water Line::

System 1 - Aluminum Substrate

| Pre Treatment | | Additional Requirements |
|--|--|---|
| Sandblast Near White Metal Blast SSPC-SP10 | | Recommended blasting grit size is 12/50 mesh The Blast profile should not exceed 3.0 mils. All blasted areas to be blown off using clean compressed air prior to painting. Must be primed within 8 hours of blasting |
| Product Name | Dry Film Thickness | Additional Instructions |
| Primer: Intermix 3:1 Epoxy Primer 3:1 mix ratio Or EP-521 Epoxy Primer Tinted 5:1 mix ratio | 3.0 – 4.0 mils 3.5 – 4.5 mils | Thin up to 15 % For Airless, less thinner is required Wait 1 - 72 hours before top coating Thin up to 15 % For Airless, less thinner is required 1 - 2 coats - Wet Film Thickness 6.0 – 7.5 mils Wait 3 - 72 hours before top coating |
| Midcoat: Guardian Epoxy 4:1 mix ratio Or EP HiBuild Epoxy 4:1 mix ratio | 6.0 mils 10 mils | Thin up to 10 % Apply in one or two coats Wet Film Thickness 6.0 to 9.0 mils Wait 4 - 72 hours Reduce as required Apply in one or two coats Wait 3 - 72 hours subject to ambient conditions. |
| Topcoat: Endura Sub-C Single Component | 15.0 mils | |
| | | |
| Notes: | | |

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::Below the Water Line::

System 2 - Aluminum Substrate

| Pre Treatment | | Additional Requirements |
|---|--|--|
| Degreaser 10 | | Keep surface wet for 5 to 10 minutes. Use a nylon scuff pad with the soap and water to scuff the aluminum surface. |
| Neutralizer 20 | | Keep surface wet for 5 to 10 minutes. Use a nylon scuff pad with the soap and water to scuff the aluminum surface. Must be primed within 8 hours of Neutralizer 20 application |
| Product Name | Dry Film Thickness | Additional Instructions |
| Primer: EP-Sealer 1:1 mix ratio Or EP-2C Primer Sealer 1:1 mix ratio | 1.0 – 2.0 mil 1.0 – 2.0 mil | Thin up 15 % For Airless, less thinner is required Wait 1 - 72 hours before top coating Wait 1 - 72 hours before top coating |
| Midcoat: Guardian Epoxy 4:1 mix ratio Or EP HiBuild Epoxy 4:1 mix ratio | 6.0 mils 10 mils | Thin up to 10 % Apply in one or two coats Wet Film Thickness 6.0 to 9.0 mils Wait 4 - 72 hours Reduce as required Apply in one or two coats Wait 8 - 72 hours subject to ambient conditions. |
| Topcoat: Endura Sub-C Single Component | 15.0 mils | |
| | | |
| Notes: | | |

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System 3 - Aluminum Substrate

| Pre Treatment | | Additional Requirements |
|---|--|--|
| Degreaser 10 | | Keep surface wet for 5 to 10 minutes. Use a nylon scuff pad with the soap and water to scuff the aluminum surface. |
| Scuff Sand | | Scuff sand with 280 Grit |
| MetaLink | | Follow Manufacturer's application instructions. <i>The prepared surface must not be wiped, washed or wetted in any way after sanding and before application of MetaLink.</i> Metal link must be applied within 3 hours after scuffing |
| Product Name | Dry Film Thickness | Additional Instructions |
| Primer: EP-Sealer 1:1 mix ratio Or EP-2C Primer Sealer 1:1 mix ratio | 1.0 – 2.0 mil 1.0 – 2.0 mil | Thin up 15 % For Airless, less thinner is required Wait 1 - 72 hours before top coating Wait 1 - 72 hours before top coating |
| Midcoat: Guardian Epoxy 4:1 mix ratio Or EP HiBuild Epoxy 4:1 mix ratio | 6.0 mils 10 mils | Thin up to 10 % Apply in one or two coats Wet Film Thickness 6.0 to 9.0 mils Wait 4 - 72 hours Reduce as required Apply in one or two coats Wait 8 - 72 hours subject to ambient conditions. |
| Topcoat: Endura Sub-C Single Component | 15.0 mils | |
| Notes: | | |

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::Above the Water Line::

System 1 - Aluminum Substrate

| Pre Treatment | | Additional Requirements |
|---|--------------------|---|
| Degreaser 10 | | Keep surface wet for 5 to 10 minutes. Use a nylon scuff pad with the soap and water to scuff the aluminum surface. |
| Neutralizer 20 | | Keep surface wet for 5 to 10 minutes. Use a nylon scuff pad with the soap and water to scuff the aluminum surface. |
| Product Name | Dry Film Thickness | Additional Instructions |
| Primer: EP-Sealer 1:1 mix ratio | 1.0 – 2.0 mil | Thin up 15 % For Airless, less thinner is required Wait 1 - 72 hours before top coating |
| Or EP-2C Primer Sealer 1:1 mix ratio | 1.0 – 2.0 mil | Wait 1 - 72 hours before top coating |
| Topcoat: EX-2C Topcoat 1:1 mix ratio | 2.0 – 3.0 mils | Thin up to 10% with appropriate EX-2C Thinner 2 wet coats to achieve desired DFT |
| | | |
| Notes: | | |

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::Above the Water Line::
System 2 - Aluminum Substrate

| Pre Treatment | | Additional Requirements |
|---|--------------------|--|
| Degreaser 10 | | Keep surface wet for 5 to 10 minutes. Use a nylon scuff pad with the soap and water to scuff the aluminum surface. |
| Scuff Sand | | Scuff sand with 280 Grit |
| MetaLink or | | Follow Manufacturer's application instructions. <i>The prepared surface must not be wiped, washed or wetted in any way after sanding and before application of MetaLink.</i> Metal link must be applied within 3 hours after scuffing |
| Product Name | Dry Film Thickness | Additional Instructions |
| Primer: EP-Sealer 1:1 mix ratio | 1.0 – 2.0 mil | Thin up 15 % For Airless, less thinner is required Wait 1 - 72 hours before top coating |
| Or EP-2C Primer Sealer 1:1 mix ratio | 1.0 – 2.0 mil | Wait 1 - 72 hours before top coating |
| Topcoat: EX-2C Topcoat 1:1 mix ratio | 2.0 – 3.0 mils | Thin up to 10% with appropriate EX-2C Thinner 2 wet coats to achieve desired DFT |
| | | |
| Notes: | | |

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::Above the Water Line::

System 3 - Aluminum Substrate

| Pre Treatment | | Additional Requirements |
|--|--------------------------------------|---|
| Degreaser 10 | | Keep surface wet for 5 to 10 minutes. Use a nylon scuff pad with the soap and water to scuff the aluminum surface. |
| Sandblast Near White Metal Blast SSPC-SP10 | | Recommended blasting grit size is 12/50 mesh The Blast profile should not exceed 3.0 mils. All blasted areas to be blown off using clean compressed air prior to painting. |
| Product Name | Dry Film Thickness | Additional Instructions |
| Primer: Intermix 3:1 Epoxy Primer 3:1 mix ratio Or EP-521 Epoxy Primer Tinted 5:1 mix ratio | 3.0 – 4.0 mils 3.5 – 4.5 mils | Thin up to 15 % For Airless, less thinner is required Wait 1 - 72 hours before top coating Thin up to 15 % For Airless, less thinner is required 1 - 2 coats - Wet Film Thickness 6.0 – 7.5 mils Wait 3 - 72 hours before top coating |
| Topcoat: EX-2C Topcoat 1:1 mix ratio | 2.0 – 3.0 mils | Thin up to 10% with appropriate EX-2C Thinner 2 wet coats to achieve desired DFT |
| | | |

Notes:

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Additional Paint Procedures

This procedure applies to all aluminum surfaces that are to be painted.

Sandblasting:

All sandblasted steel substrates to be clean of all mil scale and surface impediments

Where possible the applicator will make 'best efforts' to brush in any difficult to reach areas and pockets prior to spray application.

Curing:

Protect painted equipment from rain, condensation, snow, frost, surface contamination or sudden exposure to heat for at least 24 hours after painting.

Do not pressure wash or steam clean freshly painted equipment for at least 30 days after painting

Touch Up Procedure:

All touch ups are to be confirmed and collectively agreed by the customer and applicators before any units are to be started.

NOTE: Please adhere to the specifications procedures for touch ups.

Quality Control Standards:

A QC Application Standards Form is included as part of the Specification.

The return of the completed form to the customer is representative of job completion.

Safety

Follow all government regulations for the spray application of paint materials.

Follow all Occupational Health and Safety recommendation and guidelines.

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Additional Information

The substitution of Paints and Primers supplied by other Paint Manufactures is not permissible. Endura Products can be obtained from:

Endura Manufacturing Company Ltd.
19340 94th Ave
Surrey, BC V4N 4E4
Phone: (604) 513-1456 (Toll Free (1-800-667-8994)

or

Endura Manufacturing Company Ltd.
12425 – 149th Street
Edmonton, Alberta, T5L-2J6
Phone: (780) 451-4242 (Toll Free (800) 661-9930)
Fax: (780) 452-5079
For your nearest Distributor please phone toll free (800) 661-9930

or

Polyglass Coatings Limited LLC
1616 N. Main Street
Pearland, Texas 77581
Phone: (281) 485-9553
Fax: (281) 485-9773

Primer Product Codes

| | |
|----------------------------------|---|
| Intermix 3:1 Epoxy Primer | FEA0170 mix 3:1 with FEB0180 |
| EP-521 Epoxy Primer | Varies by color mix 5:1 with FEB0850 |
| EP-Sealer White | FEA0082 mix 1:1 with FEB0081 |
| EP-2C Sealer | FEA0650 mix 1:1 with FUB0651 |
| Guardian Epoxy Primer | FEA0111 mix 4:1 with FEB0111 |
| EP-HiBuild Epoxy primer | FEA0274 mix 4:1 with FEB0275 |

Topcoat Color Codes

| | |
|--|--|
| Endura EX-2C | Varies by color mix 1:1 with FUB0100* |
| Endura Sub-C Anti Fouling Coating | IMI0014 |

**please note that other EX-2C B components are available (for different ambient conditions and application requirements) please contact your representative if you have any questions.*

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Endura Contacts: (office 1.800.667.8994 or 604.591.8224)

Surrey: Burns Grund: Cell – 604-788-8140

Calgary: Elissa Milner – Cell 403-200-1749

Customer Contact:

Spec Approved:

(revision # on Date -)

Signature: _____

Marine Inspection Report

| | | | |
|---|----------------------------|---|----------------------|
| Substrate being paint: | | Blast Profile: (Place tape here) | |
| Do you understand the Endura paint specification? | | | |
| Primer: | | Date/Time: | |
| Part A: | Name: | Batch number: | |
| Part B: | Name: | Batch number: | |
| Solvent: | Name: | Batch number: | |
| Surface preparation: | | Surface profile: | |
| Wet mils: | Dry mils: | RH: | Dew point: |
| Amount of paint used: (in Gallons) | Flash time before topcoat: | Material temperature: | Surface temperature: |
| Painters signature: | | Inspectors signature: | |
| Midcoat: | | Date/Time: | |
| Part A: | Name: | Batch number: | |
| Part B: | Name: | Batch number: | |
| Solvent: | Name: | Batch number: | |
| Colour: | | | |
| Wet mils: | Dry mils: | RH: | Dew point: |
| Amount of paint used: (in Gallons) | Flash time before clear: | Material temperature: | Surface temperature: |
| Painters signature: | | Inspectors signature: | |
| Topcoat: | | Date/Time: | |
| Part A: | Name: | Batch number: | |
| Part B: | Name: | Batch number: | |
| Solvent: | Name: | Batch number: | |
| Wet mils: | Dry mils: | RH: | Dew point: |
| Amount of paint used: (in Gallons) | | Material temperature: | Surface temperature: |
| Painters signature: | | Inspectors signature: | |
| Notes : | | Total dry mils: | |
| | | Total Amount of paint used: (in Gallons): | |
| | | Suppliers signature: | |