

PAINT SYSTEM**WOOD**

TYPE: two-pack

PRE-TREATMENT: see relevant TDS on nautical substrate preparation.

ABOVE WATER LINE

LAYERS: 2

BUILD COAT: S68030 VERNICE POLIURETANICA 910
or S68050 VERNICE POLIURETANICA TIX .UV

TOP COAT: S31753 VERNICE STARGLOSS CLEAR U.V.

**BELOW WATER LINE**

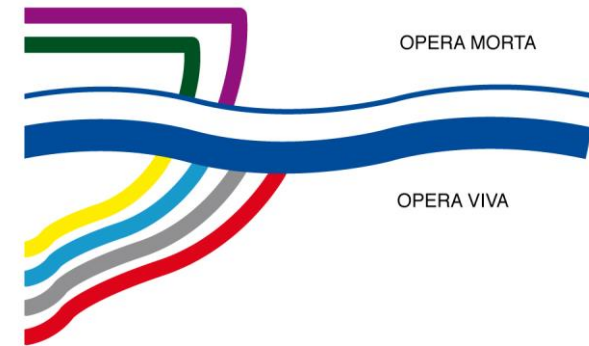
LAYERS: 4

PRIMER: S24124 EPOBLOK IMPREGNANTE

BUILD COAT: S24130 EPOBLOK SYSTEM












PRIMER: S74158 EPOXY PLUS

ANTIFOULING: STOPPANI COLOR CARD

















We recommend you to carefully read the technical and safety data sheets of the single products before starting working. These documents are always available on our web site www.lechler.eu and are integral part of this document. Please make sure to have at your disposal the suitable equipment and operational conditions to carry out your work in safety and quality conditions.














PAINT SYSTEM

ABOVE WATER LINE WOOD	 MIXING RATIO	THINNER % (A+B)		 THICKNESS		 SANDING	SOLIDS (A+B)	THEOR. SPREADING RATE (A+B)	 OVERCOATING														
									Volume A+B					WET μ	DRY μ	%	m ² /l	10°C		20°C		35°C	
										min	max	min	max					min	max				
IMPREGNATING AGENT																							
S68030 VERNICE POLIURETANICA 910	2	S70030 50 % COATS 1**	S70060 15-30 % COATS 1**	ND	ND	P280-320	45	2.3		6h	32h	3h	16h	1,5h	8h								
S68031 VERNICE POLIURETANICA 910 HARDENER	1										2h	8h	1h	4h	30'	2h							
BUILD COAT																							
S68030 VERNICE POLIURETANICA 910	2	S70030 10-15 % COATS 3+3**	S70060 15-20 % COATS 3+3+3**	600*	200*	P280-320	45	2.3		6h	32h	3h	16h	1,5h	8h								
S68031 VERNICE POLIURETANICA 910 HARDENER	1										2h	8h	1h	4h	30'	2h							
TOP COAT																							
S31753 VERNICE STARGLASS CLEAR U.V.	3	S70030 10-30 % 2 COATS***	S70060 5-10 % 3 COATS***	180*	50*		35	7.0		32h	48h	16h	24h	8h	12h								
S31751 STARGLASS CLEAR U.V. BRUSH HARDENER	1																						
NOTES	<p>* approximate thickness, not detectable on wood</p> <p>** Apply three coats according to indicated overcoating intervals, allow drying at least 24h at 20°C and sand before applying the following three coats.</p> <p>*** For brush applications it is recommended, after the first coat application, to allow drying at least 24h at 20°C and sand with abrasive paper P 360 before lacquering. By higher thickness it is recommended to prolong the drying time before sanding, so as to allow paint to consolidate and avoid solvent absorption of the following coats.</p>																						

PAINT SYSTEM

ABOVE WATER LINE WOOD	 MIXING RATIO	THINNER % (A+B)		THICKNESS		 SANDING	SOLIDS (A+B) %	THEOR. SPREADING RATE m ² /l	 OVERCOATING										
		 Volume A+B	 		WET				DRY	10°C	20°C		35°C						
					μ				μ		min	max	min	max	min	max			
IMPREGNATING AGENT Alternative 1																			
S68050 VERNICE POLIURETANICA TIX U.V.	2	S70030 50 % COATS 1**	S70060 15-30 % COATS 1**	ND	ND	P280-320	45	2.3	 	6h	32h	3h	16h	1,5h	8h				
S68050 VERNICE POLIURETANICA TIX U.V. HARDENER	1									2h	8h	1h	4h	30'	2h				
BUILD COAT Alternative 1																			
S68050 VERNICE POLIURETANICA TIX U.V.	2	S70030 15-30 % COATS 3+3**	S70060 20-40 % COATS 3+3+3**	600*	200*	P280-320	45	2.3	 	6h	32h	3h	16h	1,5h	8h				
S68051 VERNICE POLIURETANICA TIX U.V. HARDENER	1									2h	8h	1h	4h	30'	2h				
TOP COAT																			
S31753 VERNICE STARGLASS CLEAR U.V.	3	S70030 10-30 % 2 COATS***	S70060 5-10 % 3 COATS***	180*	50*		35	7.0	 	32h	48h	16h	24h	8h	12h				
S31751 STARGLASS CLEAR U.V. BRUSH HARDENER	1																		
NOTES	<p>* approximate thickness, not detectable on wood</p> <p>** Apply three coats according to indicated overcoating intervals, allow drying at least 24h at 20°C and sand before applying the following three coats.</p> <p>*** For brush applications it is recommended, after the first coat application, to allow drying at least 24h at 20°C and sand with abrasive paper P 360 before lacquering. By higher thickness it is recommended to prolong the drying time before sanding, so as to allow paint to consolidate and avoid solvent absorption of the following coats.</p>																		

PAINT SYSTEM

BELOW WATER LINE WOOD	MIXING RATIO Volume A+B	THINNER % (A+B)		THICKNESS		SANDING 	SOLIDS (A+B) %	THEOR. SPREADING RATE (A+B) m ² /l	OVERCOATING 						
				WET	DRY				10°C		20°C		35°C		
				μ	μ				min	max	min	max	min	max	
PRIMER															
S24124 EPOBLOK IMPREGNANTE	1	S70171 0-5 %		140*	50*	P240-P280	37	7.35		6h	16h	3h	8h	1.5 h	4h
S24125 EPOBLOK IMPREGNANTE HARDENER	1	2 COATS													
BUILD COAT															
S24130 EPOBLOK SYSTEM	2	S70171 0-5%		250*	225*	P80-P120	90	4		24h	48h	12h	24h	6h	12h
S24131 – S24129 EPOBLOK SYSTEM HARDENER STANDARD – SPEEDY	1	4 COATS													
PRIMER															
S74158 EPOXY PLUS SOL.A	9	S70171 10-15 %	S70171 15-25 %	160*	60*	P240-280	45	7.5		16h	96h	8h	48h	4h	24h
S74156 EPOXY PLUS SOL.B	1	2 COATS	3 COATS							2h	96h	1h	48h	30'	24h
ANTIFOULING (1+1 COATS)															
STOPPANI COLOUR CARD															
NOTES	*approximate thickness, not detectable on wood. In order to ensure a better antifouling adhesion to the dried epoxy primer, it is possible to apply a tie coat of S28060 Resolution Primer.														

All information contained in this data sheet is the result of carefully controlled tests and is correct to the best of Lechler's knowledge at the time of issue. Since conditions of use are beyond the control of the manufacturer, information contained herein is without warranty, implied or otherwise, and final determination of the suitability of any information or material for the use contemplated and the manner of use is the sole responsibility of the user. FOR PROFESSIONAL USE ONLY.



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