

# BILGE PAINT

## PRODUCT INFORMATION

**Coating type:**  
Modified alkyd

**Typical uses:**  
Fast drying primer for the protection of various bilge substrates. Can be over coated with a wide range of finishing coats including hammer finishes.

**Appearance:**  
Low sheen

**Colours available:**  
Grey

**Features and benefits:**

- Excellent corrosion resistance
- Fast drying
- Oil resistant

## TECHNICAL INFORMATION

**Theoretical coverage:**  
10m<sup>2</sup> per litre at 40 microns dry film thickness

**Film thickness:**

	Wet film thickness	Dry film thickness
<b>Typical:</b>	100 microns	40 microns
<b>Range:</b>	60-125 microns	25-50 microns

**Sag tolerance:**  
140 microns wet film thickness

**V.O.C.:**  
556gm/ltr EPA Method 24  
488gm/kg calculated from formulation to satisfy EU Solvent Emissions Directive.

**% Volume solids:**  
40% calculated from laboratory formulation

**Drying time:**

Temp.	Touch dry	Firm dry	Overcoat
5°C	75 mins	150 mins	See below
10°C	60 mins	120 mins	See below
15°C	45 mins	90 mins	See below
20°C	30 mins	60 mins	See below

*Drying time will vary with temperature, air movement, etc. May be overcoated after 45 minutes or as soon as 'firm-dry' with all white spirit based finishing coats. Fast-drying finishing coats based on stronger solvents should be overcoated when primer is firm dry but within 1 hour, or allow primer to dry overnight.*

## SURFACE PREPARATION

**Paint preparation before use:**  
Make sure that the paint is stirred well before use, making sure the bottom of the can is stirred as well to ensure the paint is mixed well until the paint is homogenous and has a good consistency

**Surface preparation:**  
All surfaces to be coated should be clean, dry and free from contamination. Prior to paint application all surfaces should be assessed and treated in accordance with ISO 8504:2000.  
Preferred method is abrasive blast to ISO 8501-1 SA2.5.

**Manual clean:**  
Chip, scrape and wire-brush to remove all loose millscale, rust etc. Degrease with detergent and rinse thoroughly.

## APPLICATION

**Application conditions:**

This material should preferably be applied at temperatures in excess of 10°C. Relative humidity should not exceed 90% and in these conditions good ventilation is essential. Substrate temperature should be at least 3°C above the dew point and always above 0°C.

At application temperatures below 10°C, drying and curing times will be significantly extended, and spraying characteristics may be impaired.

**Airless spray:**

Tip size: 13-15thou (0.330-38mm)  
Tip pressure: Minimum 2000psi (137bar)

**Conventional spray:**

Tip size: 55 thou (1.4mm)  
Tip pressure: 40-60psi (2.76-4.14bar)

**Brush application:**

Small areas and sections can be brush applied. Apply with full wet brush. Do not attempt to 'brush out' or 'lay off'.

**Roller application:**

Preferably small areas only, multiple coats may be required to achieve required film thickness.

**Thinning:**

Up to 10% of SML Xylene Thinner may be required when spraying the product to achieve optimum spray characteristics.

**Clean-up:**

Clean all equipment after use with SML Xylene Thinner. Do not allow product to remain in hoses, guns or spray equipment. All surplus product should be disposed of in accordance with appropriate regional regulations/legislation.

---

## STORAGE AND PACKAGING

**Storage:**

Under cover within temperature range of 5°C to 32°C. Keep containers dry and tightly sealed to avoid moisture contamination.

**Shelf life:**

2 years or longer in unopened containers when stored under cover within a temperature range of 5°C to 32°C.

**Pot life (at 20°C):**

N/A

**Packaging:**

2.5 litre tins

---

## HEALTH AND SAFETY

*All work involving the application and use of this product should be performed in compliance with all relevant national, health, safety & environmental standards and regulations*

---

## ADDITIONAL NOTES

The application and spray information given above is intended as a guide only. As conditions vary from job-to-job, it is the applicators responsibility to ensure all equipment in use has been set up to give the best results.

---

## IMPORTANT INFORMATION

*The information detailed in this datasheet is liable to modification from time to time in the light of experience and of normal product development, and before using, customers are advised to check with SML Marine Paints, quoting the issue number and date at the bottom of the data sheet, to ensure they possess the latest issue.*

*For further information consult*

*SML Paints and Coatings,  
The Downs, South Cerney,  
Cirencester, Gloucestershire  
GL7 6DD*

*Telephone: 01285 862132*