MarineMend Repair Kit Procedure
(For MarineLine Coated Tanks)

Advanced Polymer Coatings, Ltd. *Avon, Ohio, 44011 U.S.A.*

1. Purpose

a) The purpose of this procedure is to clearly explain what must be done in order to repair a tank for service. The repair procedure should be used when the coating has been misapplied, damaged or contains holidays (pinholes).

2. Pre-Surface Preparation

a) Pre-Surface Preparation includes a detergent wash and chemical cleaning of all surfaces to be repaired.

b) All surfaces must then be dried.

3. Surface Preparation

a) If the damaged areas are small and are independent (separate) from each other, then the small, damaged areas may be hand sanded with a medium grit aluminum oxide sand paper. The topcoat (Grey) of the MarineLine coating and any rust spots must be removed.

b) For areas that are larger, a disk sander with a medium grit aluminum oxide disk should be used. Remove topcoat (Grey) of the MarineLine coating and any rust spots down to a near white metal.

Note: All areas sanded down to near white metal must have an area of 25 mm around its periphery, MarineLine coating topcoat (Grey) removed to a feathered edge.

c) Feather edge the sanded area so that no loose or sharp edges of existing coating are observable.

d) The area should be vacuumed thoroughly to remove all dust particles and washed with solvent (MEK or acetone) to remove all contaminants.

4. Coating the Repair Spots

a) When all the preparation work is completed mix thoroughly the MarineMend Repair Kit – Part A (Resin) with Part B (Catalyst).

Note: The pot life of the MarineMend Repair Kit is 15 minutes maximum @ 20°C. (68°F.)

Make sure all surface preparation is completely finished before mixing MarineMend Repair Kit -- Part A (Resin) with Part B (Catalyst).

b) Use a small brush or roller to apply the mixed MarineMend Repair Kit.

c) Apply one coat of the MarineMend Repair Kit to the prepared surface area. The final average dry film thickness (DFT) should measure 300 microns. At NO TIME should the average DFT exceed 350 microns. If a second coat is required to reach the correct DFT follow reference (f) below.

d) The coating should cover all areas which have been prepared (sanded) including the feathered edge of the original MarineLine coating.

e) Allow to dry for 6 to 8 hours with good ventilation

f) If a second coat is required apply at this time following instructions (a) through (e) above.

5. No Heat Curing Required.

a) Using MarineMend Repair Kit no heat curing is required.

b) Chemical resistance for carrying clean products will develop in 7 days at 24°C.
Full chemical resistance per the chemical resistance guide will develop as follows: 30 days at 24°C.
40 days at 20°C.
60 days at 15°C.
90 days at 10°C.

Do Not Allow Temperature to drop below 10°C.

6. Observe ALL safety requirements during this procedure, including wearing all proper safety equipment.

Contact Advanced Polymer Sciences with any questions about this procedure.

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