

MarineMend Repair System Kit Procedure

For MarineLine Coated Tanks

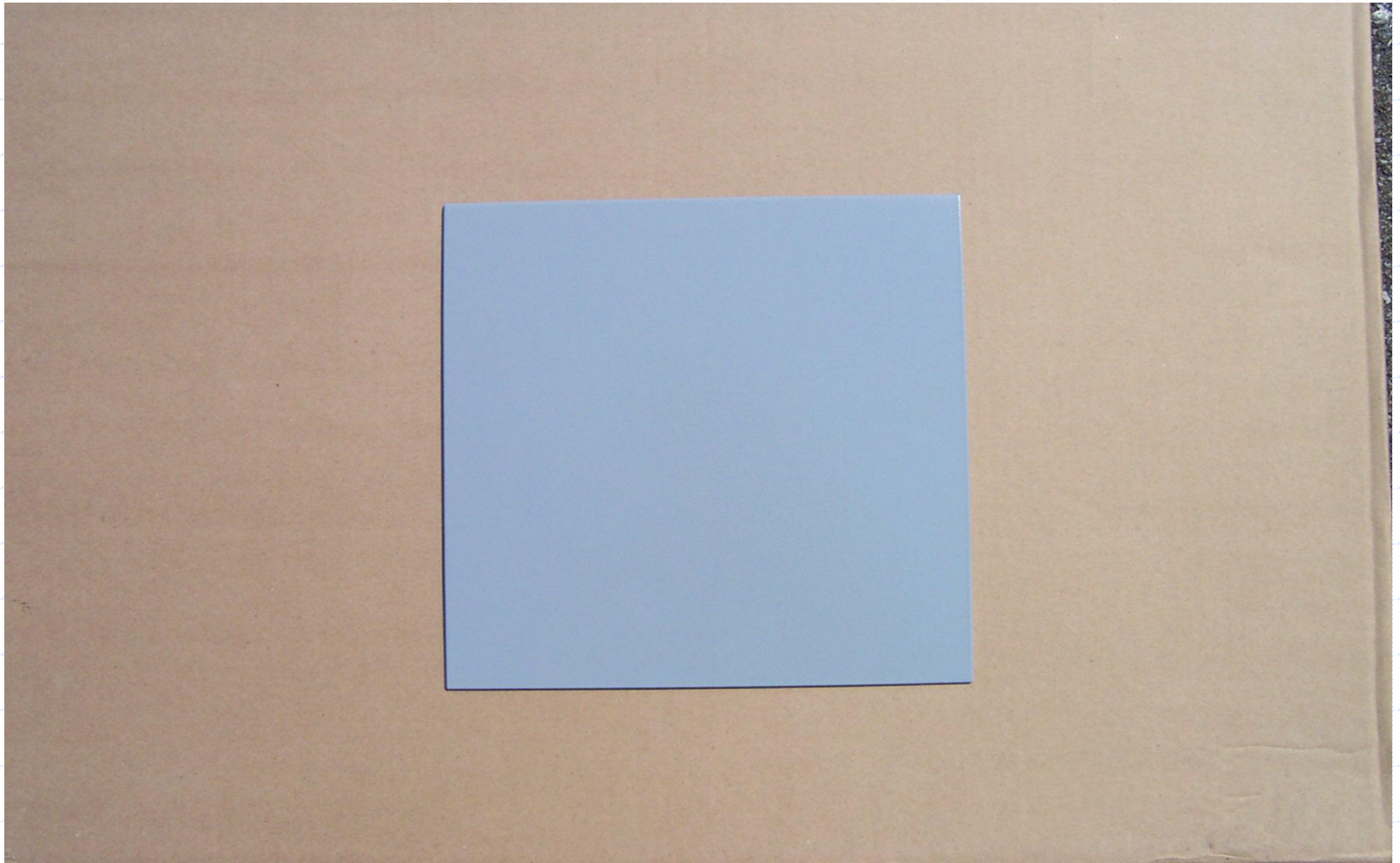
Purpose

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).

Safety

- ◆ Observe ALL safety requirements during this procedure, including wearing all appropriate personal protective equipment as detailed in Material Safety Data Sheets.

Steel Plate coated with MarineLine



Steel plate pending
mechanical damage
with a hammer.



Pre-Surface Preparation

- ◆ Pre-Surface Preparation includes a detergent wash and chemical cleaning of all surfaces to be repaired.
- ◆ All surfaces must then be dried

Surface Preparation

- ◆ If the damaged areas are small and independent (separate) from each other, the small damaged areas may be hand sanded with a medium grit aluminum oxide sandpaper. Sand the topcoat (grey) of the MarineLine coating, and any rust spots must be removed.

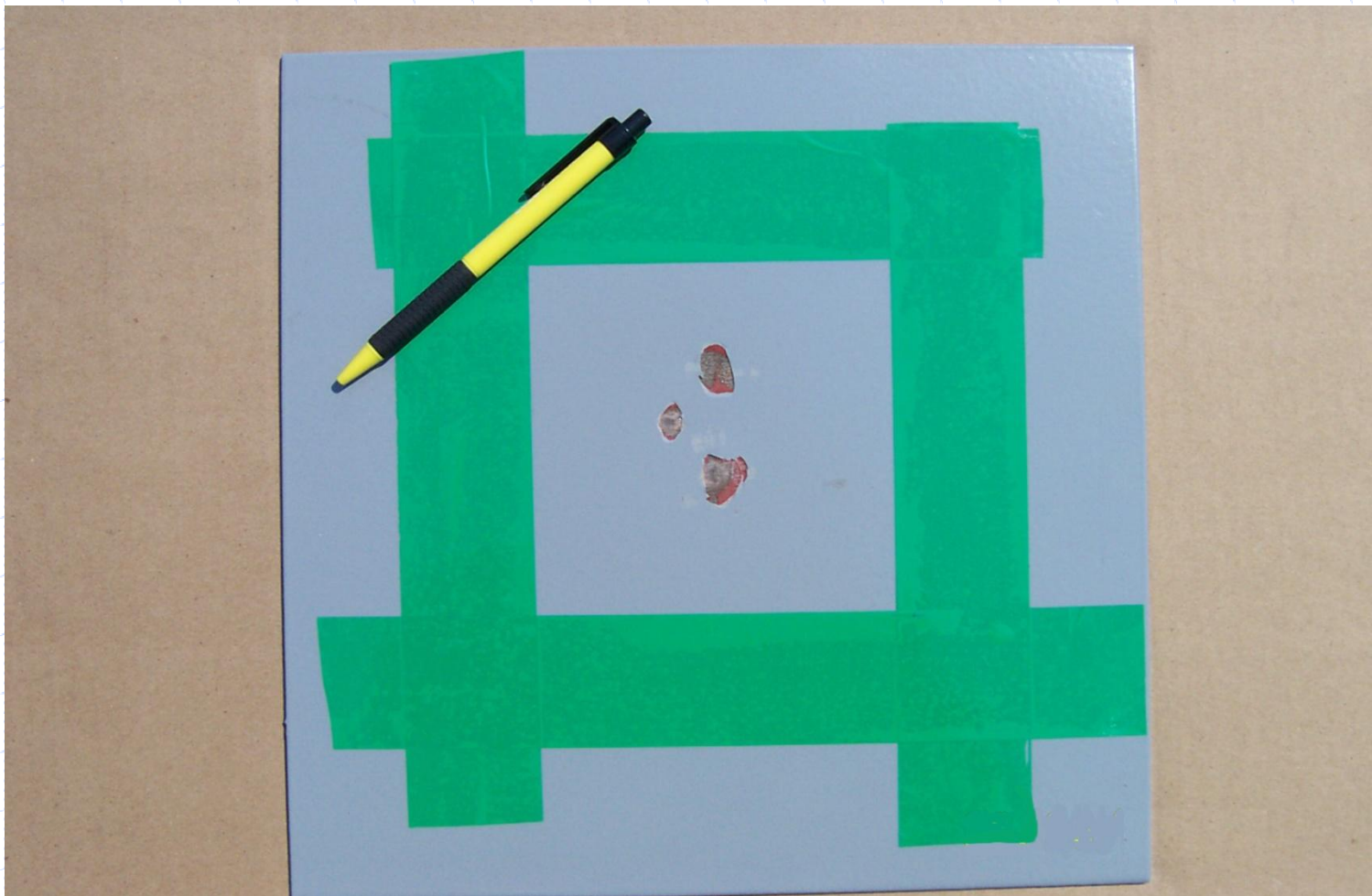
Close-up damaged MarineLine



Surface Preparation

- ◆ 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 a near white metal, must have an area of 25 mm around it's periphery. MarineLine coating topcoat (grey) removed to a feathered edge.*

Masked area – 25mm periphery



Orbital Sander



Sand masked area



- ◆ Feather edge the sanded area so that no loose or sharp edges of existing coating are observable

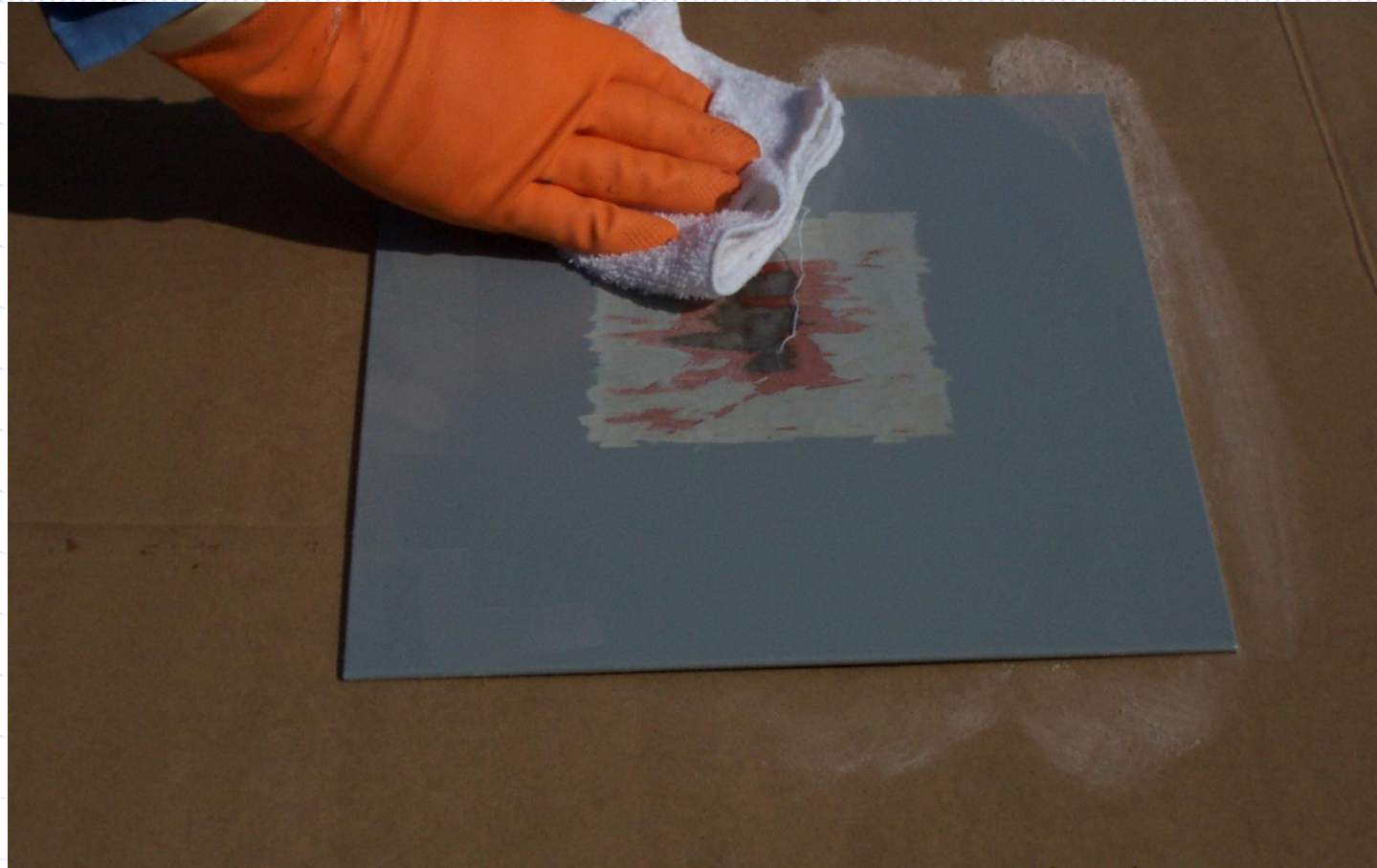
Surface Preparation

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

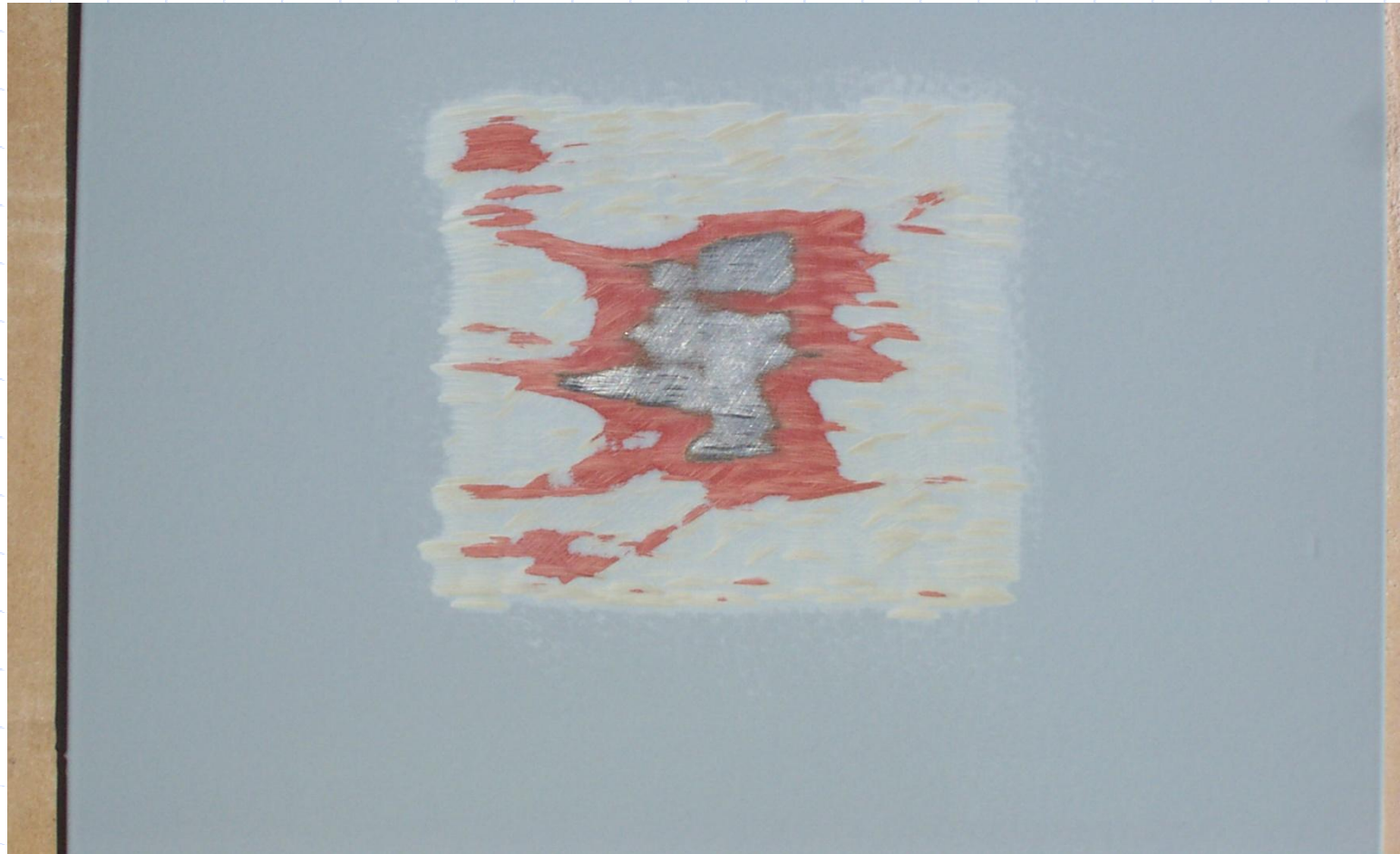


Repair Area Cleaned With Acetone

Note: Always use clean white cloth – Do not use shop rags.



Finished Surface Prep



MarineMend Repair Kit



Part B



Part A



Mixing Part A and Part B

Each MarineMend Repair System Kit consists of:

MarineLINE 784 Base Coat Components

(NOTE: Be sure to mix MarineLine 784 Part A with MarineLine 784 Part B)

1 jar MarineLine 784 (Part A)

1 bottle MarineLine 784 Basecoat hardener (Part B)

MarineMEND Top Coat Components

(NOTE: Be sure to mix MarineMend Part A with MarineMend Part B)

1 jar MarineMend (Part A)

1 bottle MarineMend Topcoat hardener (Part B)

Base Coat – MarineLine 784 - Mixing

When all preparation work is completed, pour the entire contents of MarineLine 784 Part B catalyst bottle into Part A container, mix thoroughly for 2 to 3 minutes and allow 10 minutes induction time before applying to prepared surfaces.

Note: The pot life of the MarineLine 784 base coat kit is 30 minutes maximum @ 20°C

Make sure all surface preparation is completely finished before mixing the kit.

Coating The Repair Spots

- ◆ Use a small brush or roller to apply the mixed components of MarineLine 784 base coat to the properly prepared surface.
- ◆ Apply a wet film thickness of 160-200 microns

MarineLine 784 Applied With Brush



Coating The Repair Spots

- ◆ Allow basecoat to B-stage with good ventilation until coating has tacked up but released all solvent (coating leaves a fingerprint but does NOT come up on finger -- this may take up to 24 hours depending on temperature and air flow).

Top Coat – MarineMend - Mixing

When the base coat has reached proper B-stage, pour the entire contents of MarineMend Catalyst Part B into the part A container, mix thoroughly for 2-3 minutes.

Apply one coat in wet film thickness of 160-180 microns.

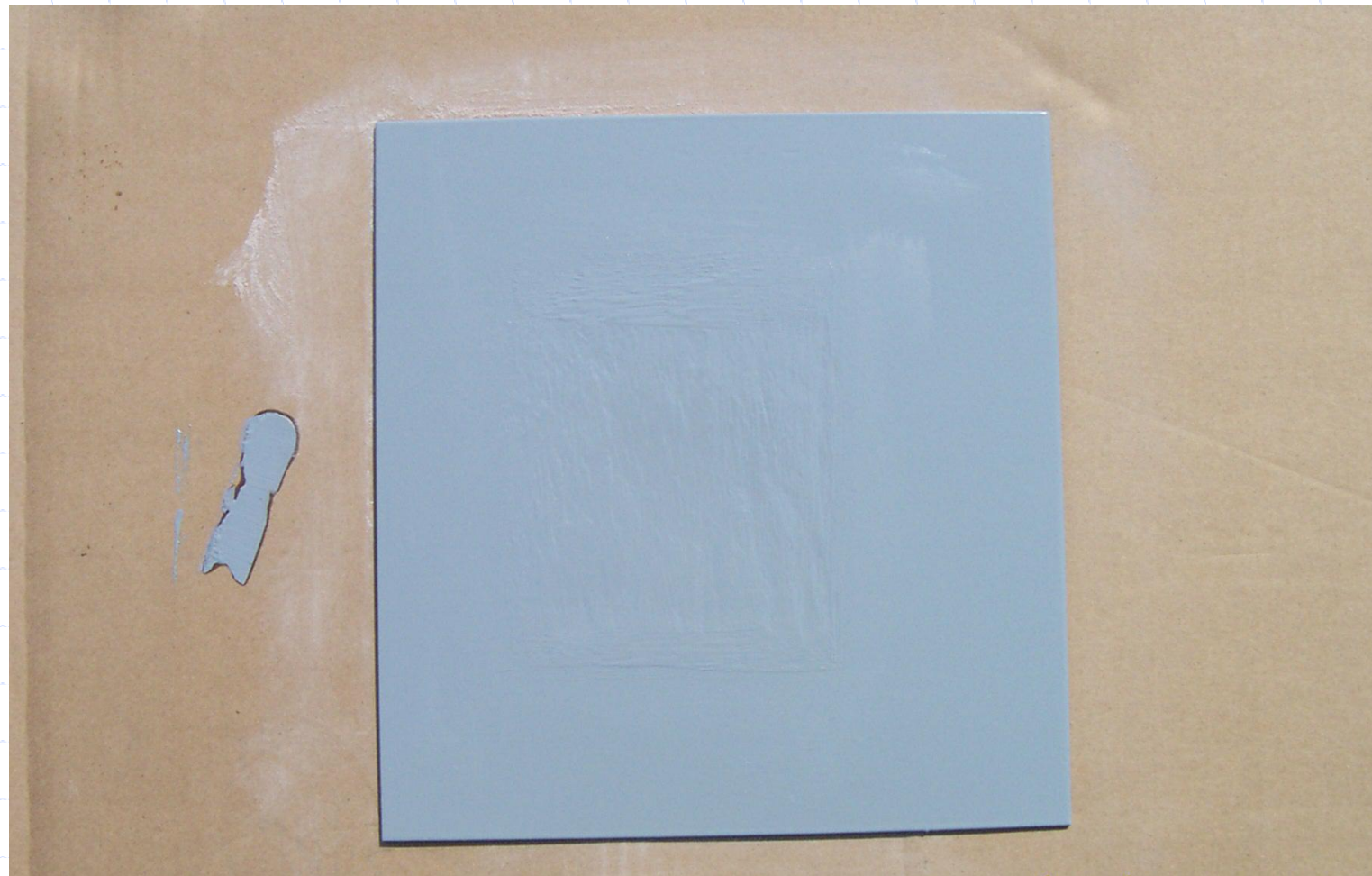
Note: The pot life of the MarineMEND Repair Kit is 15 minutes maximum @ 20°C

Make sure all surface preparation is completely finished before mixing the kit.

MarineMend Applied With Brush



Finished MarineMend Patch



Curing Requirements

◆ **Post cure MarineMend System with steam coils at a minimum substrate temperature 60°C for 24 hours.**