Osmosis Treatment – GRP / FRP Hulls

Once the vessel has been removed from the water, allow a **minimum drying period of 60 days** to ensure the hull is free from excess moisture. All osmotic blisters, air bubbles, and swellings must be completely removed by light abrasive blasting or mechanical sanding. Preparation should be extended into the surrounding sound laminate to ensure a smooth and uniform surface transition.
Remove all remaining residues of old paint and thoroughly wash the surface with fresh water. Allow the hull to dry for a further **30–60 days**. During this period, the surface should be washed regularly to remove water-soluble residues released from within the laminate. Before commencing the coating treatment, measure the moisture content using an appropriate moisture meter. **The substrate moisture level must not exceed 10%**.

Application of Anti-Osmosis Coating System

Once the surface is confirmed dry and free from moisture:

1. Apply the first coat of **Eposealer Anti-osmosis** using a stiff-bristle brush.
    - Work the product thoroughly into all cavities where blisters have been removed.
    - Multiple passes may be required to ensure complete penetration.
    - Achieve a minimum wet film thickness of **200 microns**.

2. Allow the coating to cure for **24 hours**, then lightly sand using wet abrasive paper.

3. Where cavities are particularly deep, mix **Tecnocel microfibres** into Eposealer Anti-osmosis at a ratio of **+100–200%** to create a high-density structural filler.
    - Press the material firmly into the cavities to eliminate voids and air pockets.
    - Allow to cure fully.

4. After **18–24 hours**, apply a second coat of Eposealer Anti-osmosis. A third coat may be applied if required, observing the recommended recoating intervals between coats.

Osmosis Prevention – New or Sound GRP / FRP Hulls

For new builds or sound existing fibreglass hulls, the application of a preventative epoxy barrier system is strongly recommended. The use of **EPOFOND H.B. two-component epoxy primer** provides effective long-term protection against osmosis.

Surface Preparation

- Thoroughly degrease the gelcoat surface.
- Abrade using medium-grit abrasive paper to provide a suitable mechanical key.

For new vessels, it is recommended to allow the laminate and gelcoat to cure for **a minimum of one month** before commencing preventative treatment.

Application

- Apply **2–3 coats of EPOFOND H.B.**, achieving a total dry film thickness of approximately **150–200 microns**.
- EPOFOND H.B. may be used as a basecoat or intermediate coat in below-waterline coating systems and does not require sanding between coats when overcoated within the recommended intervals.

Overcoating Guidelines

- When overcoated with **two-component paints** within **30 days**, excellent adhesion is achieved on all suitable substrates.
- When overcoated with **one-component paints**, including antifoulings:
- Allow **6–8 hours** at temperatures above **20°C**, or **12–24 hours** at temperatures between **10°C and 20°C**.

Osmosis Prevention Indicative Coating System

1. Bottom Coating System – Below Waterline					
No of Coats	**Product Name**	**Thinner**		**Coverage (m2/Lt)**	**Recoating (at 20˚C)**
2-3	**Epofond HB** High Build Primer	10-15% Brush 765	15-20% Spray 765	4-5	12-24 hours
2	**Solver Primer**/intermediate coat or **Unifiber Primer**	10-25% Brush 400 0-5% Brush 765	15-30% Spray 400 10-20% Spray 765	4-6 10	Min 6 hours Min 6 Hours
2	**Standard Plus** Antifouling	Max 5% Brush 400	10% Spray 400	10-12	18-24 hours

Osmosis Treatment Indicative Coating System

1. Bottom Coating System – Below Waterline					
No of Coats	**Product Name**	**Thinner**		**Coverage (m2/Lt)**	**Recoating (at 20˚C)**
4-5	**Eposealer** Epoxy Primer	15-20% Brush 765	20-25% Spray 765	5	18-24 hours
1-2	**Epofond AM/9** Epoxy primer	10-15% Brush 765	15-25% Spray 765	8-9	12-24 hours
2	**Solver Primer**/intermediate coat or **Unifiber Primer**	10-25% Brush 400 0-5% Brush 765	15-30% Spray 400 10-20% Spray 765	4-6 10	Min 6 hours Min 6 Hours
2	**Standard Plus** Antifouling	Max 5% Brush 400	10% Spray 400	10-12	18-24 hours

Note: *The product information is a general overview to help when deciding which product to use. Please see the product's technical data sheet for specific information.*