TECHNICAL DATA SHEET (TDS)

HI-BUILD EPOXY POOL COATING

DISCLAIMER

The following information provides general guidance for curing and filling a newly painted epoxy swimming pool to help ensure longevity and reduce the risk of blistering, particularly when using salt water. Actual curing times and procedures may vary depending on environmental conditions, ventilation, humidity, and manufacturer specifications, so always follow the epoxy paint manufacturer's instructions where applicable. For best results, allow sufficient curing time before filling: in summer or warm conditions wait at least 7–10 days after the final coat, while in winter or cooler conditions allow a minimum of 14 days. Indoor pools should also allow at least 14 days before filling. If rain occurs during the curing period, allow an additional day of drying time for each day of rain. In deep pools or areas with limited airflow, use fans or ventilation to help remove heavy solvents to ensure the epoxy cures properly. Once the curing period (7–14 days) has passed, the pool can be filled, including with salt water systems. When adding salt to freshly filled water, do not pour salt directly onto the painted surface; instead dissolve it in a bucket of water or add it gradually while the circulation system is running to ensure it is well diluted and does not sit on the coating. Salt can be added on the same day the pool is filled, however it is recommended to wait approximately 24–96 hours for the water to settle before adding other chemicals. Prior to filling, ensure the coating is fully cured, not tacky to the touch, and that all debris has been removed from the pool surface.

PRODUCT DESCRIPTION

Hi-Build Epoxy Pool Coating is a two-pack solvent-free epoxy coating with 100% solids and a high-gloss finish. It is designed for use in swimming pools and environments requiring high chemical resistance, durability, and hygienic surfaces. The coating is extremely tough and suitable for areas exposed to cleaning products used to sterilise and maintain sanitary conditions.

KEY FEATURES

- High build epoxy coating system

- High gloss finish
- Excellent chemical resistance
- Extremely durable and abrasion resistant
- Hygienic easy-clean surface
- Suitable for concrete, fibreglass, and steel swimming pools
- Compatible with common pool cleaning products
- Designed for long-term adhesion to concrete
- Available in a range of pool colours

RECOMMENDED USES

- Concrete swimming pools
- Fibreglass swimming pools
- Steel swimming pools
- Commercial aquatic facilities
- Residential pools
- Sanitary environments requiring chemical-resistant coatings

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TECHNICAL DATA

Property	Specification
Resin Type	Epoxy Polyamine

Pigments	Titanium Dioxide
Finish	High Gloss
Number of Coats	2 coats
Typical Film Thickness	250 microns per coat
Handle Dry	8–10 hours
Overcoat Time	16–24 hours
Full Cure	Approximately 7 days
Packaging	Part A: 5kg / Part B: 1kg
Flash Point	Flammable when mixed – 14°C
Thinner	Epoxy Pool Thinner
Heat Resistance	Dry: 120°C / Wet: 60°C

SURFACE PREPARATION

Proper surface preparation is critical for long-term adhesion and coating performance.

General Preparation

- Ensure hydrostatic valve is functioning before coating.
- Water blast surface to remove dirt, grease, chalk, and loose paint.
- Scrub the entire pool with detergent or trisodium phosphate (TSP) solution.
- Rinse thoroughly with clean water to remove cleaning residues.

New Concrete Pools

- New concrete or plaster must cure for **at least 28 days** before coating.
- Acid wash prior to painting.
- Surface should have a slight texture to ensure proper adhesion.

Previously Painted Concrete Pools

- Abrade surface using **30–80 grit sanding flap disc** to produce a matte profile.
- Remove all grease, slime, and loose coatings.
- Vacuum dust and pressure wash the surface thoroughly.

Fibreglass Pools

- Sand gelcoat surface using **30–60 grit sandpaper**.
- Use an orbital sander to create an even matte finish.
- Repair cracks using an approved fibreglass repair kit.

CONDENSATION TEST

After cleaning and drying the surface:

1. Tape **2 ft × 2 ft sheets of transparent plastic** to several areas of the pool surface.
2. Leave for **3 hours**.
3. If condensation forms under the plastic, the surface is too damp to coat.
4. Remove plastic and repeat the test after **24 hours** until no condensation forms.

This ensures the surface is dry enough for epoxy application.

APPLICATION CONDITIONS

- Ideal application temperature: **10°C – 30°C**
- Surface temperature must be **above 10°C**
- Do not apply if rain is forecast within **24 hours**
- If rain occurs during the painting process, allow an **extra day of drying time for each day of rain**

Epoxy coatings can become slippery when wet. The use of a **non-skid additive** is recommended for shallow pools to reduce slip hazards.

MIXING INSTRUCTIONS

1. Mix **5 kg Part A with 1 kg Part B**.
2. Mix thoroughly for **2 minutes**.
3. Allow mixture to stand **10 minutes before use**.
4. Pot life is approximately **4 hours**, depending on temperature.

Do not use material after pot life expires.

APPLICATION METHODS

Product may be applied using:

- Short-nap roller (recommended)
- Stiff bristle brush
- Airless spray equipment

Recommended roller: **10mm non-shedding roller sleeve**.

COATING SYSTEM

Typical application system:

1. Thinned primer coat (bare concrete only)
2. First coat – approx. **250 microns**
3. Second coat – approx. **250 microns**

Allow **24 hours between coats**.

COVERAGE GUIDE

Approximate coverage per 6 kg kit:

Surface	Coverage
Fibreglass	Up to 36 m²
Acid etched smooth concrete	32–34 m²
Rough concrete or steel	Up to 28 m²

New concrete blocks	Up to 20 m²

Typical spread rate:

- First coat: **3–6 m² per kg**
- Second coat: **7–9 m² per kg**

LIMITATIONS

- All epoxy coatings will gradually **chalk due to UV exposure**.
- Product is best suited **below the waterline**.
- Saltwater pools must maintain **pH between 7.4 and 7.8**.
- Concentrated pool salts must **never be poured directly onto the coated surface**.

Failure to follow these guidelines may cause colour change or coating damage.

COMMON ISSUES AND SOLUTIONS

Blistering

Causes

- Painting on damp surfaces
- Over-application of paint
- Filling the pool before the coating is cured
- Incompatible previous coatings

Solutions

- Apply coating at recommended coverage rates
- Ensure surfaces are completely dry before coating
- Allow full curing time before filling

Chalking or Fading

Causes

- Premature filling of the pool
- Excess chlorine or shock treatment
- UV exposure over time

Solutions

- Clean surface using soap and water
- Remove mineral stains with mild acid wash
- Maintain balanced pool water chemistry

HEALTH AND SAFETY

- Material is flammable when mixed.
- Avoid inhalation of vapours.
- Avoid contact with skin and eyes.
- Wear protective gloves and appropriate PPE during application.
- If product enters eyes, seek medical attention immediately.
- Keep out of reach of children.

Always read the product label and safety data sheet before use.