Technical Data Sheet

Pitakote Hi-Build Epoxy Coating

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Description

PITAKOTE is a high build epoxy coating. It is a two-pack solvent free epoxy coating, formulated for use where chemical and abrasive resistance is necessary. It gives a smooth, high gloss epoxy finish to properly prepared surfaces and is suitable where hygienic, easy-clean surfaces are required.
Pitakote Hi-Build Epoxy Coating is tough and is designed for use in areas where chemical resistance, abrasion resistance, and durability are important.

Why Use Pitakote Hi-Build Epoxy

- Two-pack solvent free epoxy coating.
- Excellent adhesion to concrete, fibreglass, or steel swimming pools.
- High build, tile-like gloss finish.
- Seamless and hygienic.
- Suitable where high standards of hygiene are required.
- Resists chemicals, mineral oils, and petrol.
- May be applied to wet surfaces, but not running water.
- Available in white and a range of factory tinted colours.
- May be over-coated with solvent or waterborne topcoats.

Limitations

All epoxy films will chalk over a period of time when exposed to UV light. This is a natural degradation of the top surface of the epoxy film.
Please read and understand application instructions thoroughly before use.
Pitakote Hi-Build Epoxy Coating has moderate heat resistance: dry 120ºC and wet 60ºC.
Pitakote Hi-Build Epoxy Coating has only casual spillage resistance to concentrated acids and vegetable oils.
Do not apply at temperatures below 13ºC. Do not exceed the recommended application rate. Proper surface preparation is essential.
Do not apply if rain is forecast within 6–8 hours after application. Rain or moisture may affect the top layer of fresh paint film and may cause white bloom or surface marking.

Technical Data

Property	Data
Resin Type	Epoxy polyamine
Pigments	Titanium dioxide and inert fillers
Colour	White and a range of factory tinted colours
No. of Coats	2 coats @ 250 microns usually
Dry Time	8–10 hr handle
Over-coat	16–24 hr overcoat
Coverage	See coverage guide
Packaging Sizes	Part A 5 kg / Part B 1 kg
Flash Point	Flammable when mixed 14ºC
Thinner	Pitakote Thinner 6.03
Heat Resistance	Dry: 120ºC, Wet: 60ºC

New Concrete Plastered Pools

New concrete plaster pool surfaces should be left to cure for 28 days prior to coating and acid washed. The surface prior to painting with Pitakote Hi-Build Epoxy Coating should not be perfectly smooth. A slight texture is preferable to give the epoxy coating a good key.

Previously Painted Concrete or Plastered Pools

Previously painted concrete or plastered pools should be abraded so the surface is not smooth and glossy, but matt.
Acid etching is a good way to help remove grease, slime, and contamination from the pool surface. This can help increase adhesion to the old surface.
When the pool has been abraded, vacuum up all dust, then thoroughly clean with detergent. Follow this with a good water blast to remove the final dust layer.
A surfactant such as dish washing liquid should be used to remove fatty scum from around and above the water line of the pool. A stiff bristle brush is a good tool to use.

Fibreglass Pools

A light grade sand paper such as 30–60 grit should be used to remove the smooth gelcoat surface of the pool. The entire pool should be completely sanded to a flat finish using an orbital sanding machine.
Do not over sand the surface or break through to the fibreglass, as this may create an uneven surface.
Cracked areas must be repaired and sanded back with an approved fibreglass swimming pool repair kit.

Compatibility

The existing paint on previously painted surfaces of a pool or spa should be determined before painting. If the existing surface is unknown, a sample should be submitted for testing to determine the type of existing surface.
Aged concrete plaster should be checked for integrity. Check for hollow or weak/crumbling plaster by using a ball-peen hammer or any comparable method. Perform repairs to the plaster before painting.

Cleaning Products

Concrete etch solution.
Surfactant cleaning liquid or grease remover.
All above chemicals, when purchased, will have material safety data sheets and technical data sheets. These must be read and understood prior to use.

Condensation Test Material

Several two-foot square transparent pieces of plastic.
Duct tape.

Abrasion Material

A belt sander or disk sander using 30–60 grit for concrete and fibreglass gel coat. Take care not to gouge into the gel coat or concrete surface of the pool.

Saltwater Pools

It is the sole responsibility of all pool owners or caretakers to achieve and, more importantly, maintain a pH level between **7.4 and 7.8** on all saltwater pools painted with **Pitakote Hi-Build Epoxy Coating**. Failure to adhere to these guidelines may affect the epoxy coating due to excessive alkalinity or acidity.

Pitakote Hi-Build Epoxy Coating will not tolerate the application of dry concentrated pool sanitisation salts being poured directly into the pool, where they may settle to the bottom of the pool and remain undissolved and in concentrated form for an extended period of time in contact with the coating. Doing so may cause colour change or fading of the coating.

Strong acids may damage the surface of the epoxy coating on repeated application if spilled.

Painting Supplies

10 mm non-shedding premium quality roller sleeves are recommended if rolling.
A paint brush for detailing.
Pitakote Thinner 6.03 for thinning paint and cleaning up tools and spills.

Joint or Crack Filler

A sandable two-component epoxy filler is recommended. This can be solvent free or water based epoxy filler.

General Surface Preparation

The key to a successful pool paint job is proper surface preparation and correct application.
Ensure the hydrostatic valve is in working order.
All surfaces to be coated should be tested for integrity and soundness. Pitakote Hi-Build Epoxy Coating is not a repair coating for weak surfaces.
Water blast the surface to remove loose paint and dirt. Care needs to be taken when recoating epoxy surfaces to remove all tightly adhering residual chalk.
Previously painted epoxy or bare fibreglass surfaces need to be abraded to a 30–60 grit profile. Be sure not to miss any small areas or adhesion blistering problems can occur.
Scrub the entire pool with a soap or tri-sodium phosphate solution to remove all dirt, oils, loose or peeling paint, and chalk. Rinse the pool with water to remove trace cleaning chemicals.
Should any minor repairs need to be made, such as hydraulic cement patch or crack joint filling, do them at this time. Follow the manufacturer's recommendations.
All surfaces should then be acid etched with a concrete etch solution to remove mineral deposits on previously painted epoxy surfaces. Be sure the water line is free from grease and grime by cleaning with a surfactant solution. Rinse the pool with water and wipe dry.

Concrete Condensation Test

After all cleaning is completed, allow the pool surface to dry.

It is recommended to wait five dry days and then perform a condensation test to determine surface dryness.
Duct tape 2' x 2' pieces of transparent plastic to the deep end wall and floor, and on several other areas of the pool.
Wait three hours to determine if condensation has formed underneath the plastic.
If condensation has formed underneath the plastic, the surface is not dry enough to paint. Remove the plastic and wait 24 hours to perform the test again.
Continue with the test until no condensation forms underneath the plastic after the three-hour wait period.

When Should I Paint

Do not apply at temperatures below 13ºC.
If rain occurs during any part of the paint process, allow extra dry time and perform the concrete condensation test to be sure.
Rain or moisture may affect the top layer of fresh paint film by causing a slight flat finish or white patches.
It is recommended to use a non-skid additive to the paint for shallow pools to help reduce liability from slips and falls. Epoxy paint surfaces can be very slippery and caution should be used in the application steps without a non-skid additive.

Painting Your Pool

When preparation is complete, the temperature of the day and surface to coat are correct, and no rain is forecast within 6–8 hours, painting may begin.
Be sure to finish painting before dew is likely to appear.

1. Thinned primer coat where required.
2. 250 micron first coat.
3. 250 micron second coat.

16–24 hours should be left between coats.
Use a short nap brush for cutting in.

Mixing the Paint

Mix 5 kg Part A with 1 kg Part B when preparation is complete.
Mix Part A and Part B thoroughly, then let the paint stand for 10 minutes prior to use.
The pot life of the product is approximately 4–6 hours and painting must be completed within this time for each kit mixed.
The hotter the day, the faster the epoxy will cure or go hard in the pot.
Material is flammable, especially when mixed. Keep away from naked flame. Avoid breathing vapours, especially when mixed. Avoid as much contact with skin as possible, as it will irritate sensitive skins which may become sensitised. Always use neoprene gloves.
If spilled in eyes, seek medical attention immediately.
KEEP OUT OF REACH OF CHILDREN.

Application

May be applied by stiff bristled brush, short nap roller or airless spray.
Apply coating at recommended spread rates.

Do not apply at temperatures below 13ºC.
Do not exceed the recommended application rate. Proper surface preparation is essential.
If bad weather prevents application of following coats for more than 5 days, sand the first coat before application to open up the epoxy coating for proper keying of the subsequent coat.

Health and Safety

Please refer to the Material Safety Data Sheet before using.
Material is flammable, especially when mixed. Keep away from naked flame.
Avoid breathing vapours, especially when mixed.
Avoid as much contact with skin as possible. It will irritate sensitive skins, which may become sensitised.
Always use neoprene gloves.
If spilled in eyes, seek medical attention immediately.
KEEP OUT OF REACH OF CHILDREN.

Spray Application Recommendation

Thin the product 5% with Pitakote Thinner 6.03 and mix well. This will give an even spray pattern and good coverage.

Spray Detail	Recommendation
Spray Unit	Wagner Finish 207, Everspray 4500, 700H
Tip Size	Maxi Tip MT621 or Std Tip 009621
Gun Filter	White, 50 mesh
Operating Pressure	3500 p.s.i.

Coverage Guide

Surface	Coverage
Smooth steel or fibreglass	Up to 36 m² per 6 kg kit
Sandblasted steel	Up to 32–34 m² per 6 kg kit
Acid etched smooth concrete	Up to 32–34 m² per 6 kg kit
Scabbled concrete, pitted steel and rough swimming pool	Up to 28 m² per 6 kg kit
Previously painted concrete blocks	Up to 30 m² per 6 kg kit
Timber	Up to 24 m² per 6 kg kit
New concrete blocks	Up to 20 m² per 6 kg kit

Common Problems and Cures

Blushing, Fading, Chalking

The cause:

The pool is filled too soon before the paint is completely cured, causing a blush over the surface which looks like fading or chalking.

Super-chlorinated water may cause a bleached-out look.

The shock of calcium hypochlorite can cause a white bleached look to the paint film, leaving a whitish deposit.

Iron in the water from rust in the filter system may leave deposits and stain the film.

All epoxies will chalk to some degree due to exposure to UV rays of the sun.

The solution:

Scrub surface using a solution of soap and water. This will remove surface dirt and deposits.

Wet with a weak 2–3% solution of muriatic acid. Acid will remove iron stains without damaging the paint film.

Solvent wipe affected areas with Pitakote Thinner 6.03.

Check pool water chemistry daily or weekly for calcium hardness, total alkalinity, and balanced pH.
Be sure the newly painted pool surface dries at least five dry, sunny days before filling.

Blistering

The cause:
Using a nap roller larger than 10 mm draws air into the paint film.
Over application of paint beyond its recommended coverage rate.
Painting on a damp surface.
Filling the pool before the paint is cured.
Incompatible paints.
The solution:
Apply at recommended coverage rates.
All paintable surfaces must be suitably prepared prior to painting with epoxy.
Epoxy paint must cure before filling.
If in doubt as to the type of coating that is on the pool now, take a paint chip to your local CCM dealer for analysis.

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