

Bilge Topcoat

Technical Data Sheet (TDS)

Product Description

Bilge Topcoat is a high performance, chemically resistance polyurethane coating for interior or exterior service. It is Formulated for brush and rolling bilge compartments and areas that require long term, low maintenance life cycles.

Product features:

- High gloss and color retention
- Superior DOI – Depth of Image
- Outstanding resistance to chemicals and impact
- Standard solid colors

Not for use below the waterline.

Recommended Uses

Bilge Topcoat is suitable for all types of watercrafts, metal components and machinery where a high-performance polyurethane coating is required. This product is intended for professional use.

Mix Ratio

2 parts by volume of component A [MBAXXXX]
1 part by volume of component B [MBB0100]

The optimal finish is obtained when RH is 80% or less. Thin as required using Marine Medium Urethane Reducer.

Product Characteristics

Gloss: ASTM D2457	High: 90+ GU at 60°
Slight gloss variations will occur depending on color.	
Volume Solids Mixed:(Unreduced) White	56% ± 1%
Volume solids will vary by color	
Pot Life: (77°F (25°C) and 50% RH)	8-10 Hours
Note: This will vary depending on converter used and addition of SuperCatalyst II	
VOC Mixed (Unreduced): EPA Method 24: Typical	401 g/l (3.37 lb/gal)
VOC content will vary with each color Contact your Endura representative for exact VOC of each individual color	
Shelf Life:	2 years unopened
Available Sizes:	Gallons , 5 Gallon pails

Surface Preparation

Bilge Topcoat can be applied over all recommended Endura Marine Epoxy and Urethane primers and sealers.

If the primer topcoat window has been surpassed, the primer should be sanded with 240 – 280 grit sandpaper or 3M™ red abrasive pads to achieve inter-coat adhesion. All sanding dust must be blown off prior to application of the topcoat.

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Application

Bilge Topcoat can be applied by brush, roller or spray using most spray-painting systems.

Ensure that any solvent absorbent primer surfacers are properly sealed with a primer sealer prior to application of the topcoat.

Spraying: Apply two single wet coats. It is recommended that a thinner first coat be applied at 1.5 – 2.0 mils wet, followed by a second wet coat of 2.0 - 3.5 mils wet. Recommended 30 – 40 minutes between coats.

Brushing or Rolling: For brushing use a natural hair bristle brush or for rolling a short (1/8") pile solvent resistant roller. Apply 1-2 coats as required to achieve the desired film build. Allow sufficient flash time between coats (20-30 minutes).

Be aware when more than three coats of paint are applied in any given 12-hour shift (including primer, topcoats, and clear coat). If more than 3 coats have been applied, wait 10-12 hours is recommended to allow for proper solvent evaporation.

After 16 hours Bilge Topcoat must be sanded prior to applying another coat to achieve inter-coat adhesion. Mechanical sanding with 220 – 320 grit is recommended before reapplication.

Dry Times

Bilge Topcoat	68°F (20°C)	86°F (30°C)	104°F (40°C)
Dust Free	2 Hours	1 Hour	30 Minutes
Full Cure	7 Days	5-6 Days	3-4 Days

Note: Dry Times are subject to ambient conditions (temperature and humidity), good airflow and film build of the topcoat.

Film Build

Bilge Topcoat has a recommended film build thickness of:

Wet: WFT Unreduced	2.5 – 4.5 mils	64 – 114 microns
Dry: DFT	1.5 – 2.5 mils	38 – 63 microns

Theoretical coverage at 1.0 mil (25 microns) average DFT: 675 ft² per gallon at 100% transfer efficiency.

Clean Up

Clean all equipment immediately after use with a High Strength Gun Wash, Endura Marine Epoxy Reducer or Endura Marine Urethane Reducer. Follow manufacturer's safety recommendations when using any solvent.

Environmental Conditions

For optimum coating performance product, substrate and ambient temperature should be between 68°F-77°F (20°C-25°C). To prevent condensation during application the surface temperature must be 5°F (5°F) or more above the dew point at all times. For use outside this range contact your Endura Representative.

Safety Precautions

Please refer to all Safety Data Sheets (SDS) before using this product. SDS sheets can be found on our website at www.endurapaint.com/marine