

Epoxy Coating Guidance

This Guidance Note is issued as a guide to established current practice on a "without prejudice" basis. The Class and Class Officers accept no liability for the outcomes for such work which is a matter between the owner(s) and their contractor

The following process is a tried and tested method which has been adopted by boatyards including Haines over almost three decades.

Please note that this is not a restoration process and assumes that a hull is in a basically sound condition with only minor preparation work required.

The hull will be dried to the minimum required to achieve a good bond between the epoxy and wood. Over drying will cause excess shrinkage and structural damage to the hull, once re-launched as the hull naturally rehydrates and expands to its original dimensions.

To receive Class agreement for the process a structural hull survey is required by the Class prior to hull splining and application of an epoxy coating. (See Class Rule 16).

The Procedure set out below assumes that a degree of hull refastening will be required, and any degraded timber replaced during the process-

1. Remove all boat gear, floorboards, gratings & cockpit joinery.
2. Raise boat in slings under gantry and support hull on trestles.
3. Remove all keel bolts and lower boat to floor.
4. Lift boat off lead ballast and move lead aside.
5. Lower hull to floor, attach slings and invert hull.
6. Raise and chock inverted hull to working height.
7. Remove all hull coatings back to bare wood.
8. Rake out all seams from sheer to keel.
9. Inspect and replace all suspect fastenings.
10. Inspect and replace all suspect timber.
11. Ensure all seams are correct width and router out or fill if required.
12. Machine and hand-fit spruce splines, bond into seams with epoxy.
13. Clean off splines and sand hull.
14. Fill hull with Epoxy & Microlight and fair hull by long-board sanding.
15. Apply first of four coats of coating epoxy resin.
16. Finish hull with a further three coats of epoxy resin and allow to fully cure.
17. Spot fill and fair epoxy and apply to coats underwater primer to all surfaces.
18. Alternatively, only apply primer to topsides and leave bottom for Coppercoat.
19. Right boat and place over ballast. Raise to fit keel bolts. Lower hull and chock.
20. Fair ballast into hull with epoxy & Microlight and sand to fair profile.
21. Finish ballast with primer or Coppercoat epoxy antifouling system.
22. Prepare, undercoat and gloss topside.
23. Refit interior joinery

Martin Evans, 27 March 2019