

APPLICATION GUIDELINE FOR VINYL ESTER LINING

Kam Teck Suan
Nippon Paint (Singapore)
Updated: 01 Sep 2020

Version 2.0

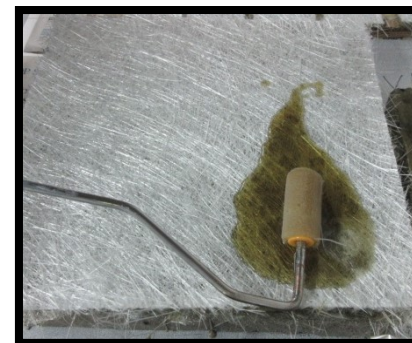
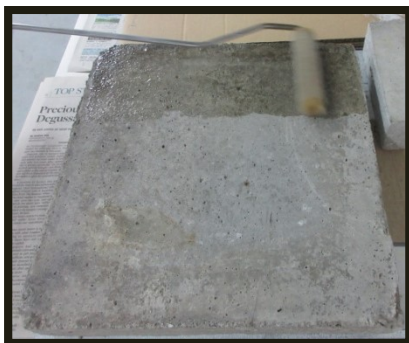
Living,
Breathing
LFG



Overview

	Lining System 1	Lining System 2
Type	Vinyl Ester	Novolac Vinyl Ester
[1] Primer	Hi-Pon 80-13 Vinyl Ester Primer	Hi-Pon 80-07 Novolac Vinyl Ester Primer
[2] Lining	Hi-Pon 80-14 Vinyl Ester Lining	Hi-Pon 80-15 Novolac Vinyl Ester Lining
[3] Accessories	<ul style="list-style-type: none"> I. Talcum Powder II. Chopped Strand Mat X2 III. Glassfibre Surface Mat IV. Air Dry Agent V. 844 Colorants (1% Max.) 	<ul style="list-style-type: none"> I. Talcum Powder II. Chopped Strand Mat X2 III. Glassfibre Surface Mat IV. Air Dry Agent V. 844 Colorants (1% Max.)

General Guide: Application of Lining Systems



STEP 1:

- Apply **Primer** over substrate
> 50 – 100 μm DFT

STEP 2:

- Mix **Lining** resin with Talcum Powder
> **Wt. Ratio = 45 (Resin) : 55 (Talc)**
- Apply using trowel
> 1300 – 1700 μm DFT

STEP 3:

- Apply Chopped Strand Mat by pressing into basecoat
- Then apply **Lining** resin
> ~ 100 μm DFT

General Guide: Application of Lining Systems



STEP 4:

- Degas with Spike Roller



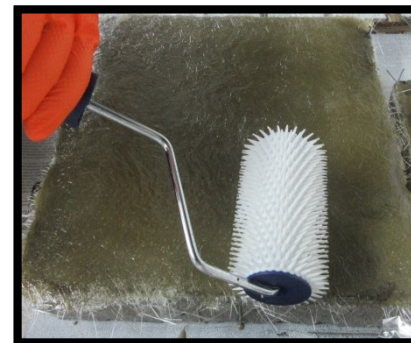
Repeat Step 3 to 4
For another layer of
Chopped Strand Mat



STEP 5:

- Wet with **Lining resin**
> ~ 100 μm DFT

General Guide: Application of Lining Systems



STEP 6:

- Lay Glassfibre Surfacing Mat into the surplus resin from Step 3 - 5

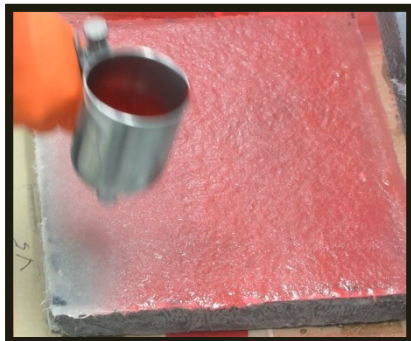
STEP 7:

- Apply **Lining** resin
> ~ 100 μm DFT

STEP 8:

- Degas with spike roller
- Allow drying before overcoat

General Guide: Application of Lining Systems



STEP 9:

- Apply **Lining** resin with colorants (1% Max.)
> ~ 100 µm DFT



STEP 10:

- Apply **Lining** resin with colorants (1% Max.) and air dry agent
> Wt. Ratio = 41.3 (Resin) : 1 (Agent)
> ~ 100 µm DFT



**Allow curing for
5 - 7 days**

Example: Vinyl Ester Lining System

