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**SHIMICOAT**  
SURFACE SOLUTIONS



# Pond Epoxy

## Ice Bath Liner *An Application Guide*

### Direction / Pond Epoxy

Pond Epoxy / Ice Bath Liner provides major functional benefits and added values through enhanced performance of impervious surface coating:

- Durability,
- Easy cleaning feature, Easy Mop, Easy Wipe.
- Enhanced Mechanical and chemical resistant properties,
- Fire resistant properties,

### Usage:

Typical Pond Epoxy applications may require 2 – 3 coats.

Multi-coats of Epoxy can always be recommended for longevity and better performance due to underwater conditions.

Ice Bath Volume	Application	Kit Sizes
Up to 500Lt	Single Coat	2 Lt
Up to 500Lt	Double Coats	4 Lt

Do NOT store any leftovers, it is OK to apply additional coats.

### Temperature & Humidity:

Ideal Temperature	Ideal Humidity
24°C – 30°C	Below 50%

SHIMICOAT recommends indoor applications where possible. If outdoors, try to apply; when minimum wind and no rain expected, as they both may have detrimental effects on your surface coating. Wind may blow leaves and dust over your wet epoxy surface. Rain may cause whitening effects on your epoxy surface.

### Surface Preparation:

- Sand the surface with 80 or 120grit sandpaper prior to commencement of Epoxy application. Ice Bath walls can be sanded manually to avoid any damage to the surface.
- For corners and those hard-to-reach surfaces, you may consider using wire brush with extra care to ensure no damage on walls.
- Remove all loose surface materials including any possible rust or corrosion.
- After sanding, wipe the entire surface with Xylene, Acetone or IPA (Isopropyl Alcohol) using a microfiber cleaning cloth. Solvents should not be in contact with skin, please use PPE as advised on MSDS of the product used.

 **MATERIALS**  **CHEMICALS**  **RESINS**  **EQUIPMENT**

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## Seal the Seams

Seal all seams and the compressor fold with 2-part epoxy putty. Once cured and solid (8-12 hours), sand the surface with 80 grit sandpaper. Vacuum the dust, and using microfiber cloth wipe with Xylene, EpoDil, IPA (Isopropyl Alcohol) or Acetone. Commence Pond Epoxy application.

Do *not* seal the seams with silicone, moisture-cure polyurea, marine adhesive, or caulking of any kind because Pond Epoxy may not adhere to the surface, and delamination may occur overtime.

## Pond Epoxy Application:

- Use brushes for corners and edges.
- Use rollers for wide areas, microfiber rollers are idea:
  - Mini Micro-Rollers 4mm Nap, or
  - Standard 230mm Miro-Rollers 10mm Nap
- Consumables such as brushes and roller sleeves are disposable, use a different brush or roller for each coat.
- Switching between brush and rollers can result in more even finish surface.
- Apply a minimum of two coats, or as many coats as you wish.
- Subsequent coats shall be applied within 72 hours, for longer intervals, sanding may be required.
- Focus on walls and Apply walls first, multi coats.
- Apply rich on corners using paint brush.
- Polyurethane Topcoat shields the surface against any possible discoloration, caused by chemicals present in water, such as pool chlorine Sodium Hypochlorite.
- Always monitor the surface for an hour or two after application. If there is any visible imperfection or bubble, use hair dryer or mist spray IPA (Iso Propyl Alcohol or Ethanol) to eliminate possible surface abnormality.
- The finish surface shall be glass mirror finish with high gloss.
- If desirable, Matting agent can be added into Epoxy to achieve Matte Finish Surface.
- SHIMICOAT Epoxy has a great coverage ability and can be applied to both floors and walls easily.
- Mix thoroughly for a minimum of 1-2 minutes manually or with mechanical mixer at low speed (750rpm Max). If mixing smaller portions, mix at a ratio of 3A:1B by volume. For example, to prepare 2Lt mix, add 500mL of Part B (Hardener or Curing Agent) into 1.5Lt of Part A (Resin). Mix for 2 minutes.
- Ensure surface to be coated is dry, run moisture test. Moisture can cause blooming and delamination.
- Pot life is approximately 30 minutes, work within 20min to ensure easy flow application.
- Use steady long strokes and avoid overworking the roller or pushing your roller too quickly as this may trap air bubbles in the coating.
- If outdoors, do not apply if rain is expected within 24 hours of application.
- Keep the containers closed & sealed when not in use. Avoid application on hot surfaces.
- If applying Polyurethane/Chemical Resistant Clear Epoxy Top Shield, mix the product UVthane PLUS/Epoxy at the right ratios as stated on label, mix for 2-3min, roll over the surface evenly using brush or rollers.

## Drying Times

Pond Epoxy / Ice Bath Liner cures in 8-16 hours at 25°C. High temperatures and windy conditions may speed up the curing process.

Full hardness is achieved after 7 days. Pond can be filled with water after 48 hours of application.

Temp °C	Pot Life (min)	Surface Dry (Hours)	Initial Cure (Hours)	Recoat Time (Hours)	Fill the Pond (Hours)	Fully Cured (Days) UNDER WATER
10°C	45	12	24	24	48	7 Days
20°C	40	10	18	18	36	7 Days
30°C	35	8	16	16	24	7 Days

## WARNING

- Direct sunlight and UV radiation may result in chalking, colour variations and yellowing effect over time. This kit is designed for underwater conditions and out of direct sunlight.
- If using pool chemicals, the surface MUST be shielded with Polyurethane or Chemical Resistant Clear Epoxy to ensure no discoloration or chalking effect.

## Storage

The products shall be stored out of direct sunlight and heat. The shelf life of the product is 24 months, mix individual components uniformly for 3 minutes prior to use to avoid any possible settlement/precipitation and ensure uniformity of your product.

## DISCLAIMER

Material Safety Data Sheet, Technical and Environmental Data Sheet can be provided upon request.

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