RACING HULL PREPARATION

PE epoxy primer - A4TSpeed & A9TSpeed Antifouling

Step	Product	Number of layers	Color	Optional	WFT/DFT* (µm)	Covering with roller (m²/L)	Overcoating min. at 15°C after	Overcoating max. at 15°C after	Thinner
1	Degreaser SD	Cloth	Colourless						
2	PE	1	Grey / Ivory	No	120/60	12	5H Without sanding	10H Without sanding	DE
3	Watertight		Pink	Yes	-	-	Sandable after 6H		
4	PE	1	Grey/Ivory	No	120/60	12	5H Without sanding	10H Without sanding	DE
5	A4T.Speed	2	6 colors	No	100/60	10	3H	3 months	DA
6	A9T.Speed	2	Yellow/Orange/ Red/Pink	Yes	100/60	10	3H	3 months	DA

* WFT : Wet film thickness / DFT : Dry film thickness

SUBSTRATE PREPARATION

- Wash the surface and degrease with Nautix **Degreaser**
- Remove old paints and rough sand with 120 grit paper
- Rinse with fresh water and let dry thoroughly

Work in a well-ventilated area.
Wear appropriate protective clothing, gloves, glasses and mask.
Replace the cloth every m²

PE EPOXY PRIMER (1rst layer)

PE: hard & thin epoxy primer

- Homogenize each part separately before mixing
- Dilute after mixing with Nautix **DE** (roller: 10% max, spray gun: 25% max)
- Application: roller, spray gun (2.0-2.5 bars, 1.8-2.0 mm nozzle)
- **Thickness per layer : 80µm wet / 40µm dry**
- If repair with Nautix **Watertight** filler is needed, let dry **PE** coating, and apply epoxy filler.

Drying / Overcoating information (WFT=80µm per layer)

	10°C	15 °C	20°C	25°C
Pot life	12 h	8 h	6 h	3 h
Dry to touch	3 h	2 h	1 h 30	1 h
Overcoated by itself (min.)	6-12 h	5-10 h	3-6 h	2-5 h
Sand after (min.)	24 h	20 h	12 h	8 h
Dry	96 h	72 h	30 h	24 h

Mixing ratio: 3 for 1 in volume
85g base / 15g hardener in weight
Covering : 12m²/L with roller, 8m²/L with spray gun.
Pack sizes: 0.75L / 2.5L / 5L

REPAIR/FAIRING WITH WATERTIGHT FILLER (OPTIONAL)

WATERTIGHT : solvent-free fast-drying finishing epoxy filler.

- Fill uneven areas with Nautix **Watertight**
- 1st quick sanding job of filler with P40/P80 paper grade between 6h and 48h at 15°C after repair.
- 2nd sanding job with P120 paper grade to adjust the outline.
- Rinse and let dry thoroughly before overcoating

Drying / Overcoating information

	10°C	15 °C	20°C	30°C
Pot life	60min	45min	20min	10min
Sandable/Overcoating	9 h	6 h	4 h	3 h
Dry	96 h	72 h	36 h	18 h

Mixing ratio: 1 for 1 (weight or volume)
Pack sizes: 0.25L (tube or tin) / 1L / 5L

PE EPOXY PRIMER (2nd layer)

PE : hard & thin epoxy primer

Resume the preparation of point 2.

Application :

- Once 2nd **PE** layer applied, antifouling can be applied wet on wet for chemical bonding. (Please refer to overcoating time: between 5-10h at 15°C).
- Or sand using 120 grit before application of 1st layer of **A4T.Speed** (Please refer to sanding time: from 20h at 15°C) and rinse with fresh water and let dry thoroughly.

Drying / Overcoating information (WFT=80µm per layer)

	10°C	15 °C	20°C	25°C
Pot life	12 h	8 h	6 h	3 h
Dry to touch	3 h	2 h	1 h 30	1 h
Overcoated by itself or antifouling (min.)	6-12 h	5-10 h	3-6 h	2-5 h
Sand after (min.)	24 h	20 h	12 h	8 h
Dry	96 h	72 h	30 h	24 h

Mixing ratio: 3 for 1 in volume
85g base / 15g hardener in weight
Covering: 8m²/L (spray gun), 12m²/L (roller)
Pack sizes: 0.75L / 2.5L / 5L

Nautix – Z.I. des 5 chemins
56520 Guidel, France
Tel: +33.(0)2.97.65.32.69
info@nautix.com — www.nautix.com

A4T.Speed ANTIFOULING

A4T.Speed : Hard matrix antifouling with T.Speed (gliding-effect components)

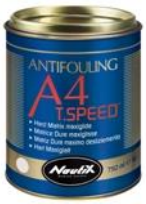
Wet-on-wet application (chemical bonding): overcoating (between 5-10h at 15°C).

If the overcoat window is exceeded, sand the surface with P80-120 before applying the 2nd coat from 20h at 15°C. Rinse with fresh water and allow to dry.

Methods of application:

- Spray gun (recommended): 1,6 or 1,8 mm nozzle, 2.0–2.5 bars pressure. Thinner Nautix DA 10 to 20% depending on T° and nozzle.
- Roller: To get the best results, use a solvent-resistant mohair type roller. Thinner DA: 5% maximum
- To ensure a good antifouling efficiency over time, apply a minimum of 120µm dry film (total) in 2 or 3 layers.

When fully dried, lightly wet-sand the surface with 400 or 600 grit (depending on initial surface roughness), then with 800 or 1000 wet paper. This optional step will get rid of small imperfections and optimize flow along the hull.



Drying / Overcoating information (WFT=100µm per layer)

	10°C	15 °C	20°C	30°C
Dry	2 h	1 h 30	1 h	30 min
Overcoating (min.)	4 h	3 h	2 h	1 h
Immersion (min.)	5 h	4 h	3 h	2 h

Covering: 6m²/L (spray gun), 10m²/L (roller)
Pack sizes: 0.75L / 2.5L / 20L
Colours : White, black, Blue France, Navy blue, red, grey

A9T.Speed ANTIFOULING (OPTIONAL)

A9T.Speed : Hard matrix fluorescent antifouling with gliding-effect components for appendages

- Application : roller, spray gun (P=2.0-2.5 bars, 1.6-1.8 mm nozzle).
- Thinner : Nautix DA (roller : 5% max, spray gun : 20% max).
- *Hull* : Once antifouling to be dried (wait minimum 4h at 15°C), lightly wet-sand the surface with 400 or 600 grit (depending on initial surface roughness), then with 800 or 1000 wet paper. This optional step will get rid of small imperfections and optimize flow along the hull.

Top Tip: Use soft sponge to clean antifouling if necessary.

Drying / Overcoating information (WFT=100µm per layer)

	10°C	15 °C	20°C	30°C
Dry	2 h	1 h 30	1 h	30 min
Overcoating (min.)	4 h	3 h	2 h	1 h
Immersion (min.)	5 h	4 h	3 h	2 h

Covering: 6m²/L (spray gun)
Pack sizes: 0.75L
Colors: orange fluo, yellow fluo, pink fluo

GENERAL INFORMATIONS

- If fairing is required, **Watertight** filler must be applied between 2 layers of **PE**.
- Nautix epoxy filler should be systematically abraded before overcoating.
- If epoxy primer overcoating time cannot be respected, it's strongly recommended to sand the surface with P120 grit before overcoating.
- Additional paint thickness should be applied to areas of high wear e.g. rudders, waterlines, leading edges, …

WORKERS PROTECTION

- Antifouling paints are considered as hazardous products. Use antifouling paints carefully. Always read the label and product information before use.
- Work in a well-ventilated area. Wear appropriate protective clothing, gloves, glasses and mask.

Nautix – Z.I. des 5 chemins
56520 Guidel, France
Tel: +33.(0)2.97.65.32.69
info@nautix.com — www.nautix.com