## *Application guide for Aluminium hulls*

(Hard film CLEAR COAT Silane - Siloxane Nano foul release coating).

***SEA-SPEED V10X ULTRA CLEAR*** is designed and engineered to be applied on new hulls or hulls of vessels that have previously been painted with epoxy barrier coats and or antifouling paint. Can be applied to pleasure craft, racing sailboats, powerboats and personal watercraft. Properly applied, the coating will be glass smooth with a surface roughness of less than 5 microns.

***SEA-SPEED V10X ULTRA CLEAR*** may also be applied to hulls that previously have had traditional ablative or self-polishing Anti Foul. The following procedure shall be used to prepare the hull and apply the ***SEA-SPEED V10X ULTRA CLEAR*** to previously painted hulls.

## PREPARATION

| | **Preparation for all immersed surfaces** |
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| 1. | If the craft has been in the water, remove the boat from the water and immediately high-pressure water blast in order to remove fouling. |
| 2. | Mechanically remove fouling by scraping followed by high-pressure water cleaning. |
| 3. | Remove all accessories from the hull such as trim tabs. |
| 4. | For best results and an exceptionally smooth hull the existing Anti Foul paint and barrier coats should be completely removed by soda blasting and or sanding. |
| 5. | For best results and full removal of old paint grit blasting is the preferred method. Aluminium hulls, grit blast to SA 2.5 profile. Use Garnet media. |
| 6. | All surfaces must be washed to be free of dust, salt, dirt, oil and grease. Use compressed air to remove residual dust. If latent oils or grease are present, use MEK (Methyl Ethyl Ketone) or other high flash solvent to remove any contamination. |
| 7. | Mask off the surrounding areas to protect from over spray. |
| 8. | If the existing barrier coat is in good condition, proceed to apply one or more coats of ***Seapoxy 73*** barrier in order to achieve a dry film thickness (DFT) of 5 mils (125 microns). If all epoxy barrier coats have been removed, apply multiple coats of ***Seapoxy 73*** barrier coating to achieve a 10 mil (250 micron) dry film thickness (DFT) in order to ensure long term protection of the hull. |
| 9. | Allow adequate cure times between coats of ***Seapoxy 73*** per manufacturers documentation. |
| 10. | After the last coat of ***Seapoxy 73*** barrier is applied the epoxy shall be allowed to cure to a “Firm Thumbprint” stage. This is usually 4-8 hours. The last barrier coat should be cured to the point where you can press your thumb on the paint with 25-30 psi (.2 MPa) and barely leave a fingerprint. At that point you are ready to apply the ***SEA-SPEED V10X ULTRA CLEAR***. |
| ***NOTE****: If grit blasting is not possible, proceed with a DA type rotary sander using 180 grit pads. Prior to sanding the surfaces should be prepared per # 6.* | |

***PLEASE NOTE:* Surface preparation is the key to a quality and successful finish. If you are not clear on the instruction, please call us.**

## SAFETY PRECAUTIONS

- It is important to protect yourself and the environment during preparation.
- Proper clothing such as disposable paper suits, goggles, a charcoal filter mask, a balaclava cotton hood and good quality dishwashing or chemical resistant disposable gloves.
- Protect the ground where you are working so that you can contain and collect residual paint dust and dispose of it according to local regulations.
- Prior to applying any coating a survey of the hulls should be performed to check for cracks or grounding damage. Repair as necessary or contact a professional for an assessment and repair prior to applying the coating.

## PROCEDURE AND TIMING

- Apply one coat of ***SEA-SPEED V10X ULTRA CLEAR*** to the hull by airless spray or pressure pot with HVLP gun. Please review ***SEA-SPEED V10X ULTRA CLEAR*** Technical data sheet and MSDS prior to use.
- For airless spray application a Graco RAC X FFLP (Fine Finish Low Pressure) tip should be utilized, use tip size .308
- For HVLP gun use a 1.4 - 1.6 mm tip should be used for the best results.
- Apply at 5 mils (125 microns) wet film thickness.
- Allow to cure a minimum of 24 hours prior to moving the vessel or blocks.

Protect the vessel from moisture (rain) and check the weather forecast. The ***SEA-SPEED V10X ULTRA CLEAR*** will be tack free and water resistant in 3 – 3.5 hours at 25°C. Prior to applying any paint, you should protect all areas not to be coated. Apply a good quality masking tape or “Fine Line” for the waterline / boot top.

## SUPPLIES

- Electric or pneumatic driven Airless spray pump (30:1 ratio).
- Tip: A fine finish low pressure tip is required for airless spray. Tip size should be (.208/.308).
- Hose: 3/8 “i.d. (9.52 mm i.d.).
- ** If applied by Pressure pot with HVLP gun use a 1.4 or 1.6 mm tip.**
- Electric or pneumatic rotary paint mixers.
- Clean new Polyethylene or steel mixing containers.
- Clean up solvent (Wattyl L780) only.
- Disposable solvent resistant gloves.
- Face protection and mask/respirator.
- A wet film gauges.

***NOTE: The sprayer should be compatible with hot solvents for cleaning purposes.***
***Do Not use Lacquer Thinner or Xylene.***

## MIXING AND APPLICATION

***IMPORTANT:*** Substrate temperature must be above 5°C and at a minimum must be 3°C above the dew point.
***SEA-SPEED V10X ULTRA CLEAR*** is supplied in 1 gallon (3.785 liter) kits. It is a 3:1 ratio mix by volume.

- Mix the necessary amount of ***SEA-SPEED V10X ULTRA CLEAR*** to coat the underwater hull area with 5 mils (125 Microns) wet film thickness. Coverage is as follows at 5 mils (125 microns): 5.4 sq. meters per liter. Practical coverage including 30% spray loss.
- Pre-mix part B until smooth, keeping mixer blade submerged as to not entrain air.
- Mix PART A and PART B together for 3-4 minutes until smooth and homogenous keeping mixer blade submerged as to not entrain air.
- Material should be smooth with no solids. Material may be strained through a filter if desired.
- **An Induction time of 8 minutes is required before applying.**
- Spray tip should be a Graco FFLP type fine finish .208, .308 for airless.
- Remove pump filter.
- Remove gun filter.
- Frequently check wet film thickness with a gauge to ensure proper specify thickness.

***NOTE: Do Not Thin the Material Unless Applying with HVLP.***
***Maximum 5% Acetone by Volume for HVLP Application.***

Once ***SEA-SPEED V10X ULTRA CLEAR*** has cured 24 hours or is sufficiently hard not to be damaged, the blocks and pads may be moved. Around block and pad spots, lightly sand on to the new existing ***SEA-SPEED V10X ULTRA CLEAR*** 1-2 inches with 180/220 sandpaper.

Mix an appropriate amount of ***SEA-SPEED V10X ULTRA CLEAR*** and apply by 1) HVLP cup gun, or 2) good quality natural bristle brush on the pad spots being sure to feather the newly applied material on to the sanded area of ***SEA-SPEED V10X ULTRA CLEAR*** on the perimeter.

Vessel may be placed into the water no sooner than 24 hours after coating and as soon as the coating system has achieved a hardness that is not easily mechanically damaged. If temperatures are or fall below 25ºC additional time may be required before being re-floated. ***For each 6.25°C under 25°C add 6 hours to re-float time.*** The coated vessel may be left out of the water indefinitely. ***SEA-SPEED V10X ULTRA CLEAR*** is inert once cured it does not contain any cuprous oxide or biocides that degrade.

## SAFETY PRECAUTIONS

- Painters should avoid ingesting coating through the nose or mouth. Proper attire, such as adequate air masks and goggles must be worn during application. Refer to product data sheets and MSDS forms for full details.
- Please note that vessels coated with ***SEA-SPEED V10X ULTRA CLEAR*** that sit idle for extended periods will foul as will conventional toxic cuprous oxide bottom paints. Hulls with ***SEA-SPEED V10X ULTRA CLEAR*** should be maintained by regular cleaning as are conventional paints.
- **DO NOT USE SCOTCHBRITE PADS OR ANYTHING ABRASIVE TO CLEAN. Divers mitts, Poly bristle brushes and plastic paint scrapers are to be used.**
- Cleaning the ***SEA-SPEED V10X ULTRA CLEAR*** is the owners/operators responsibility and must be done with a non-abrasive brush, mitt or pad only (such as a piece of carpet or plastic paint scraper) and will not harm the coating.

*~~ We have your bottom covered ~~*