TECHNICAL SPECIFICATIONS

▷ RACING HULL PREPARATION

PE Epoxy primer - A4T.Speed/A9T.Speed Antifoulings

INFORMATION

- If fairing is required, **Watertight** filler must be applied between 2 layers of **PE**.
- Nautix epoxy filler should be systematically abraded before overcoating as recommended in the TDS.
- If any fairing is required in the hull, apply 2 layers of **PE** without any filler to improve adhesion before antifouling application.
- If 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,…

PREPARATION

- Wash the surface and degrease with **Nautix SD**
- If necessary, remove old paints
- Rough sand with 120 grit paper to improve mechanical adhesion
- Rinse with fresh water and let dry thoroughly

Work in a well ventilated area.
Wear appropriate protective clothing, gloves, glasses and mask.

PE : EPOXY PRIMER (1st layer)

PE : hard & thin epoxy primer for finishing (recommended before **A4T.Speed** application)

- Homogenize each part separately before mixing
- Dilute after mixing with Nautix **DE** (roller : 10% max, spray gun : 25% max)
- Application : roller, spraygun (2.0-2.5 bars, 1.8-2.0 mm nozzle)
  - ➢ Thickness per layer : 120µm wet / 60µm dry
- If repair with Nautix **Watertight** filler is needed, let dry **PE** coating, and apply epoxy filler.
- If you don't need to repair with epoxy filler, there are 2 options :
  - ➢ **PE** layers 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 2nd layer of **PE** (Please refer to sanding time : from 20h at 15°C) and rinse with fresh water and let dry thoroughly.

Drying / Overcoating information (WFT=120µm 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

h=hours min=minutes

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

REPAIR / FAIRING WITH WATERTIGHT FILLER (OPTIONAL)

Fill uneven areas with Nautix **Watertight** (solvent-free fast-drying finishing epoxy filler).

- 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.
- Epoxy filler must be applied between 2 layers of primer.

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

h=hours min=minutes

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

PE : EPOXY PRIMER (2nd layer)

PE : hard & thin epoxy primer for finishing (recommended before A4T.Speed application)

- Homogenize each part separately before mixing
- Dilute after mixing with **Nautix DE** (roller : 10% max, spray gun : 25% max)
- Method : roller, spray gun (2.0-2.5 bars, 1.8-2.0 mm nozzle)
  - ➢ Thickness per layer : 120µm wet / 60µm dry

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=120µm 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

h=hours min=minutes

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

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TECHNICAL SPECIFICATIONS

▷ RACING HULL PREPARATION

PE Epoxy primer - A4T.Speed/A9T.Speed Antifoulings

A4T.SPEED : ANTIFOULING

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

Methods of application :

- Spray gun (recommended) : 1,6 or 1,8 mm nozzle, 2.0–2.5 bars pressure. Thinning : 10 to 20%(Nautix **DA**) depending on T° and nozzle.
- Roller : To get the best results, use a solvent-resistant mohair type roller. Thinning : 5% maximum (Nautix **DA**)

To ensure a good antifouling efficiency over time, apply a minimum of 120µm dry film (total) in 2 or 3 layers.

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 : to get a better finishing, use more thinner for final layer.

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

h=hours min=minutes

Covering : 6m²/L (spray gun)
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 (keel, rudder,…)

Methods of application :

- Spray gun (recommended) : 1,6 or 1,8 mm nozzle, 2.0–2.5 bars pressure. Thinning : 10 to 20%(Nautix **DA**) depending on T° and nozzle.
- Roller : To get the best results, use a solvent-resistant mohair type roller. Thinning : 5% maximum (Nautix **DA**)

To ensure a good antifouling efficiency over time, apply a minimum of 120µm dry film (total) in 2 or 3 layers.

Application : 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 : Do not wet-sand the antifouling too frequently, otherwise the efficiency of paint will be spoiled.

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

h=hours min=minutes

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

Recommended system :

Step	Product	Application	Colour	Optional	WFT/DFT* (µm)	Coverage (m²/L)	Min. overcoating at 15°C	Max overcoating at 15°C	Pot life (at 15°C)	Thinner
1	PE	Spraygun	Ivory/grey	No	120/60	8	5 h without sanding	10 h without sanding	8 h	DE
2	Watertight	Trowel/batten	Light pink	Yes	-	-	Sandable from 6 h		45 min	-
3	PE	Spraygun	Ivory/grey	No	120/60	8	5 h without sanding	10 h without sanding	8 h	DE
4	A4T.Speed	Spraygun	To de defined	No	100/60	6	3 h	3 months	-	DA
5	A4T.Speed	Spraygun	To de defined	No	100/60	6	3 h	3 months	-	DA
6	A4T.Speed	Spraygun	To de defined	No	100/60	6	3 h	3 months	-	DA
7	A9T.Speed	Spraygun	Fluo	Yes	100/60	6	3 h	3 months	-	DA
8	A9T.Speed	Spraygun	Fluo	Yes	100/60	6	3 h	3 months	-	DA

*WFT : Wet Film Thickness / DFT : Dry Film Thickness

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