



SEA-SPEED V 10 X Application guide for FRP/Gel-Coat hulls

(Hard film fluorinated polysiloxane foul release coating).

SCOPE

This guide, together with the Product Data Sheet, defines the minimum requirements for the cleaning, removal of old antifouling paint and application of **SEA-SPEED V 10 X** for professional and non-professional. The proper removal of old coating and surface preparation are the most important part of a successful application. Keep in mind that hull roughness has a tremendous impact on speed and fuel economy (a variation in smoothness of 0.1 mm can reduce speed by 1%). In order to obtain the maximum benefits and lifecycle of **SEA-SPEED**; we recommend that as a minimum all previous antifouling paint be removed.

PREPARATION (previously coated surfaces)

Surface Preparation for all Immersed gel coat / fiberglass Surfaces

1. 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 and remove old paint.
4. Remove any existing anti-fouling (AF) paints to:
 - Solid underlying epoxy barrier coat. If the Epoxy barrier coat is questionable, it is advised to remove it entirely.
 - or
 - The base gel coat surface.
5. Soda blasting is an efficient and environmentally sound means of removing old AF and barrier coats. If Soda blasting is not available, thoroughly sand surface with an orbital sander using thirty-six (36grit) to forty (40 grit) sanding disks to remove old coatings. Finish off sanding with 60 / 80 grit paper to the point where the hull is smooth. Chines and waterline are critical areas and special care should be taken to insure those areas in particular are properly prepared.

PLEASE NOTE: Surface preparation is the key to a quality and successful finish.

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.

PREPARATION (New hulls)

1. Using MEK (Methyl Ethyl Ketone) or de-waxing agents to clean the area to be coated to remove any residual mold release compounds remaining on the surface. Apply solvent and follow by rubbing and wiping down towards the keel. This may take several applications.
2. Remove all accessories from the hull such as trim tabs.
3. Thoroughly sand surface with eighty grit (80) sandpaper to the point where no glaze or shine is visible. Chines and waterline are critical areas and special care should be taken to insure those areas in particular are properly prepared.

PLEASE NOTE: Surface preparation is the key to a quality and successful finish.

4. All surfaces must be washed to be free of dust, salt, dirt, oil and grease. Use compressed air to remove residual dust. Use MEK (Methyl Ethyl Ketone) or other NON AROMATIC high flash solvent.

Safety

Anti-fouling paints are toxic. It is important to protect yourself and the environment while undertaking removal of previous bottom coatings.

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 the collect residual paint dust and dispose of it according to local regulations.

Prior to applying any coating a survey of the bottom should be performed to check for cracks, leaks, blisters or grounding damage. Repair as necessary or contact a professional for an assessment and repair. If a new barrier coat is needed due to hull condition, a new epoxy should be applied. Refer To Seacoat's **SEAPOXY 73** imersion grade epoxy. Two coats of 5 mils (175 microns) wet each should be applied totaling 10 mils (250 microns) DFT

(Dry film thickness. Please contact Seacoat for technical assistance.

PROCEDURE AND TIMING:

Day 1

- Apply one coat of SEAPOXY 73 Anticorrosive Primer to the hull by airless spray.
- Apply at 7 mils (175 microns) wet film thickness.
- Allow to cure overnight

Day 2

- In the morning apply one coat of SEAPOXY 73 Anticorrosive primer alternate color
- (Supplied either in Black, light grey or white).
- Apply at 7 mils (175 microns) wet film thickness.
- Allow 4-6 hours to cure to very firm thumbprint stage. (This is the point where SEAPOXY 73 can be thumb printed with 30 pounds pressure.
- Apply one coat of SEA-SPEED V 10 X with the airless sprayer. One coat at 9-10 (225-250 Microns) wet film thickness.

Protect the vessel from moisture (rain) and check the weather forecast. 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

Pneumatic Airless spray pump (45:1 ratio) or larger

Two paint mixers

Clean new Polyethylene or steel mixing containers

4" solvent resistant phenolic core foam rollers (1/4" thick maximum) Roller pans

Clean up solvent (Sherwin Williams R7K15 or C 50 only

NOTE: Do Not use Acetone, LACQUER THINNER or Xylene.

Disposable solvent resistant gloves.

Face protection and mask/ respirator

A wet film gauge.

Mixing and application of SEAPOXY 73

IMPORTANT: Substrate temperature must be above 50 ° F (10° C) and at a minimum must be 5 ° F (3 C) above the dew point.

The SEAPOXY 73 is supplied in 2 gallon (7.57 liter) and 5 gallon (20 liter) Kits.

- Use the 45: 1 airless spray pump.
- Mix the necessary amount of SEAPOXY 73 to coat the underwater hull area with

7 mils (175 Microns) wet. Total primer requirement for two coats is usually 1 gallon (3.785 liters) per ten feet of length. Divide this number in half. EXAMPLE: 50 ' vessel would require 5 Gallons (19 liters). Mix 2.5 gallons or 9.5 liters.

- Mix PART A & PART B together for 3-4 minutes until smooth and homogenous.
- **An Induction time of 8-10 minutes is required before applying.**
- Spray tip should be .417, .419, .517 or .519. Pressure should be 2,800-3,000 psi to eliminate fingering.
- Check wet film thickness with a gauge to ensure proper thickness.

Mixing and Application of *SEA-SPEED V 10 X*

IMPORTANT: Substrate temperature must be above 50°F (10°C) and at a minimum must be 5°F (3°C) above the Dew Point.

The best method for application is by using an airless spray pump. A 45:1 ratio pump or larger is recommended. Spray tip should be 0.417, .419 – 0.517, 0.519.

1. Mix each component separately with a high - speed rotary mixer attachment for 5 minutes.
2. **DO NOT THIN THE MATERIAL without consulting technical service: Mix equal parts by volume of Part A and Part B. Using the drill and mixer, thoroughly mix components for five minutes until a homogeneous mixture is achieved. If a thinner is utilized, (Sherwin Williams R7K15 or C 50 shall be used), a maximum of 2% of mixed volume of SEA-SPEED may be added. If thinner is used, An induction time of 20 minutes is required after thinner is introduced. If that is the case, allow induction time after thinner is mixed in. Mix with rotary mixer just prior to start of spraying.**

It may be advisable to mix only a fraction of the kit at one time due to the pot life of the product. (1 hour @77 degrees F)

3. If you are using this product for the first time it is advisable to apply a light wetting coat 3 - 4 mils (75 – 100 microns) wet film thickness to the hull on a first pass. Go back to the original starting point and apply another coat of 6 – 7 mils (150 – 175 microns). **Spraying the**

product will give the best results in terms of smoothness and correct film thickness.

Measure thickness with a wet film gauge. The necessary thickness in total should be 8 – 10 mils (200 – 250 microns) wet film thickness.

Once the SEA-SPEED has cured 24 hours or is sufficiently hard not to be damaged, the blocks may be moved:

4. If existing coating has not previously been removed and hull prepared, remove the old coating in the pad and block areas and clean per the instructions detailed above
5. Apply SEAPOXY 73 primer in two coats as specified previously. **Apply primer only to bare hull area. Do not apply primer on to new exiting SEA-SPEED surrounding the pad spots.** Once the last coat of primer has cured 4-6 hours or is firm enough, you can apply the SEA-SPEED.
6. Mix an appropriate amount of SEA-SPEED and apply by roller on the pad spots being sure to feather the newly applied material on to the sanded area of SEA- SPEED on the perimeter.

Vessel may be placed into the water no sooner than twenty four (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 77°F additional time may be required before being re-floated. **For each 10°F under 77°F (6.25°C under 25°C) add 6 hrs to re-float time.**

The coated vessel may be left out of the water indefinitely. **SEA-SPEED** is inert once cured and does not contain any cuprous oxide or biocides that degrade.

Safety

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** that sit idle for extended periods will foul as will conventional toxic cuprous oxide bottom paints. Hulls with **SEA-SPEED** should be maintained by regular cleaning as are conventional paints.

Cleaning the **SEA-SPEED** 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. Normal underwater brush carts with medium soft poly bristles may be specified for larger vessels.

SAFETY:

Proper attire, such as air masks, goggles and gloves must be worn during application. Avoid ingesting the coating through nose and mouth. Refer to MSDS (SDS) sheets and hygiene procedures.