NAUTIX TECHNICAL SPECIFICATIONS

GRP- HULL PREPARATION

RACING APPLICATION

STEP **1**

PREPARATION:

Work in a well ventilated area. Wear suitable protective clothing, gloves, glasses and eye/face protection. The surface must be cleaned with degreaser Nautix SD and dry. It should be sanded (grade 150).

STEP **2**

FILLING WORKS EVALUATION

If some filling work has to be done, Nautix Watertight fast epoxy filler should be used . We recommend to apply it between 2 coats of epoxy primer.
Mixing ratio: 1/1 volume & weight – easy to apply and to sand (up to P80) – 100% solvent free.

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Temperature	10°C	15 °C	20°C	25°C
Pot life when mixed	60 mn	45 mn	20 mn	15 mn
Sandable / Overvcoating	9 h	6 h	4 h	3 h
Dry	96 h	72 h	48 h	36 h

STEP **3**

EPOXY PRIMER SELECTION

Nautix PE or U2 White are high quality primer with thin application. Nautix HPE high built epoxy primer is recommended for roller application.

	PE or U2 White	*HPE high built*
Adhesion only:	1 coat 120µ wet / 62µ dry	1 coat 160µ wet / 80µ dry
Adhesion and Protection :	3 coats / 186µ dry	2 coats / 160µ dry
Adhesion and osmosis protection:	5 coats / 310µ dry	4 coats / 320µ dry
Coverage	10 m² / litre	8 m²/ litre

STEP **4**

EPOXY PRIMER APPLICATION

Do not apply under 10°C and over 35°C. To avoid any condensation between support and paint coats, support, ambient air, and paint temperatures must be the same (Dew-Point).
Mixing ratio in volume : 3 part base/ 1 part hardener. Two-pot product must be mixed just before use. Mix only the quantity to be used. Application method : brush, roller or spray gun (nozzle 1.8-2mm).
Thinner - Cleaner : Nautix DP - Maximum dilution 10 %.

FAST DRYING SYSTEM (PE—U2 White—HPE)

Temperature Air & substrate	10°C	15 °C	20°C	25°C
Hand dry	3h	2h	1h30	1h
Wet Wet Overcoating	6h to 12h	5h to 10h	3h to 6h	2h to 5h
Sand after (P180-P220)	24h	20h	12h	8h

SLOW DRYING SYSTEM (PE) —recommended for spray gun application

Temperature Air & substrate	10°C	15 °C	20°C	25°C
Hand dry	9h	6h	3h30	2h
Wet Wet Overcoating	10h to 30h	8h to 24h	6h to 12h	4h to 15h
Sand after (P180-P220)	40h	30h	24h	18h

Note: Over a new boat, we recommend to let evaporate solvent 3 to 4 days minimum before antifouling or enamel application

STEP **5**

A4 TSPEED ANTIFOULING APPLICATION

Select and apply the recommended volume of antifouling (for 2 coats: A4Tspeed = 6m²/l). If you use A4Tspeed fluo for keel and rudder, always apply it over a A4Tspeed white or PE Grey
Application by roller: - Select a good tool. Dilute at 5 to 10 % with Nautix DA
Application with air mix spray gun – regatta application: nozzle : 1,4 to 1,6 mm - air pressure : 2 bars. Dilute at 15 to 25% with Nautix DA, depending on the air temperature

Antifouling drying time	10°C	15 °C	20°C	35°C
Hand dry	2 h	1 h 30	1 h	30 mn
Overcoating time	4 h	3 h	2 h	1 h
Minimum drying time before launching (maximum 6 months)	4 h	3 h	2 h	1 h

STEP **6**

FINISH

This optional step gives the hull the best glide properties and to make the last small defects disappear. When antifouling is completely dry (after 3 to 4 hours), sand the surface with wet sand paper 800 to 1000. For leading edges of keels and rudders: apply A4 T.SPEED fluorescent over A4Tspeed white or PE grey (3 coats). Wet sand (800 to 1000) after 3 to 4 hours.

Nautix – Z.I. des 5 chemins – 56520 Guidel – France
Tel: +33.(0)2.97.65.32.69
Fax: +33.(0)2.97.65.03.54
info@nautix.com — www.nautix.com