



# 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.

Temperature	10 °C	15 °C	20 °C	25 °C
Pot life when mixed	60 mn	45 mn	20 mn	15 mn
Sandable / Overcoating	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 m <sup>2</sup> / litre	8 m <sup>2</sup> / 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 = 6m<sup>2</sup>/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