



SEA-SPEED V 10 X ULTRA CLEAR

Application guide for FRP/Gel-Coat & Aluminum hulls

(Previously Painted)

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

SEA-SPEED V 10 X 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 3 microns.

SEA-SPEED V 10 X ULTRA CLEAR may also be applied to hulls that previously have had traditional ablative or self polishing AF. The following procedure shall be used to prepare the hull and apply the SEA-SPEED V 10 X ULTRA CLEAR to previously painted hulls.

PREPARATION

Surface Preparation for all Immersed gel coat / fiberglass Surfaces

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. The existing AF paint should be completely removed by soda blasting and or sanding.
5. For Aluminum hulls, grit blast to SA 2.5 profile. Use Garnet media

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

6. For FRP/Gel-coat hulls inspect the existing epoxy barrier coat under the old AF Paint. If the Epoxy barrier coat is solid and in good condition, finish sanding the surface by hand or with an orbital sander using one eighty (180 grit) sanding disks to obtain a smooth surface. Chines and waterline are critical areas and special care should be taken to insure those areas in particular are properly prepared. Proceed to next step (8) to apply a new coat or coats of epoxy barrier coat in color of choice.
7. If the epoxy barrier coat(s) are soft, brittle and poorly adhered or if osmosis is present the epoxy should be completely removed to bare gel coat surface. If Osmosis is present it should be addressed by a skilled professional prior to proceeding with any further application.
8. 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.

Safety

It is important to protect yourself and the environment while the hull 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 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.

9. If the existing barrier coat is in good condition, proceed to apply one or more coats of Epoxy 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 epoxy barrier coating to achieve a minimum 10 mil (250 micron) dry film thickness (DFT) in order to ensure long term protection of the hull.
10. Allow adequate cure times between coats of epoxy per manufacturers documentation.
11. After the last coat of epoxy 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 V 10 X ULTRA CLEAR**.

PROCEDURE AND TIMING:

- Apply one coat of SEA-SPEED V 10 X ULTRA CLEAR to the hull by airless spray or pressure pot with HVLP gun. A 1.4 or 1.6 mm tip should be used for 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. 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)

Please note the airless sprayer should be compatible with hot solvents for cleaning purposes.

Tip: A fine finish tip is best suited. 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 (Sherwin Williams R7K15 or C 50 only)

NOTE: Do Not use LACQUER THINNER or Xylene.

Disposable solvent resistant gloves.

Face protection and mask/ respirator

A wet film gauge.

Mixing and application of SEA-SPEED V 10 X ULTRA CLEAR

IMPORTANT: Substrate temperature must be above 41 ° F (5° C) and at a minimum must be 5 ° F (3 C) above the dew point.

The **SEA-SPEED V 10 X CLEAR** is supplied in 1 gallon (3.785 liter) Kits. It is a 3:1 ratio mix ratio Part B to Part A by volume.

DO NOT THIN THE MATERIAL

- Mix the necessary amount of **SEA-SPEED V 10 X CLEAR** to coat the underwater hull area with

5 mils (125 Microns) wet.

Coverage is as follows:

at 5 mils (125 microns): 305 square feet per gallon (7.48 sq. meters per liter)

Account for loss when spraying.

- Pre mix part b until smooth. keeping mixer blade submerged as to not entrain air.
- Mix PART A & 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.
- **An Induction time of 5-8 minutes is required before applying.**
- Spray tip should be a Graco FFLP type fine finish .208, .308,
- Remove pump filter.
- Remove gun filter.
- Check wet film thickness with a gauge to ensure proper thickness.

Once the SEA-SPEED 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 1-2 inches with 180/220 sand paper.

Mix an appropriate amount of SEA-SPEED and apply by solvent resistant foam brush 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.

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** 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.