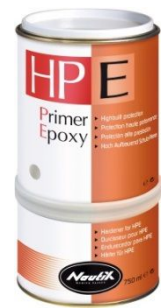
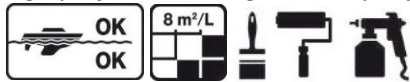


HPE

High performance High-build epoxy primer



The printing process may render some of the colour samples imperfectly. We recommend testing the paint before committing to a colour.

PRODUCT DESCRIPTION

HPE is a 2-part epoxy primer with a high built capacity providing outstanding adhesion and protection features over fibreglass or metal substrates. Easy to use, to apply and to sand, HPE can be applied in one thick layer as tie-coat to shape hulls and profiles.

HPE has been developed for underwater applications : 1 layer for antifouling adhesion, 2 layers for protection against abrasion, and 5 layers to prevent osmosis on a clean hull.

PRODUCT INFORMATION

Finish	Matt
Mixing ratio (volume)	3 base / 1 hardener
Mixing ratio (weight)	6 base / 1 hardener
Coverage	8m ² /L per layer (roller/brush)
Flash point	23°C <FP<55°C
Unit size	0.75L – 2.5L – 5L – 20L
Typical shelf life	5 years
Thinner/Cleaner	Nautix DE
Colours	white, grey

Drying / Overcoating Information

Temperature	10°C	15°C	20°C	25°C	30°C
Pot life	12h	8h	6h	3h	2h
Touch dry	3h	2h	1h30	1h	30min
Overcoated by itself*	6h-12h	5h-10h	3h-6h	2h-5h	1h-3h
Overcoated by antifouling*	6h-12h	5h-10h	3h-6h	2h-5h	1h-3h
Sand after	24h	20h	12h	8h	6h
Dry	96h	72h	30h	24h	20h

d=days h=hours min=minutes

*Overcoating time recommended for 1 layer (120µm wet thickness) – Please refer to *Application*

*If maximum overcoating time is exceeded, sand with 120 grade wet or dry paper

TYPE OF SURFACES

- GRP / Composite
- Steel (for more details, please refer to our technical specifications for “Steel boat”)
- Aluminium (for more details, please refer to our technical specifications for “Aluminium boat”)
- Rigid wood (for more details, please refer to our technical specifications for “Wood boat”)

SURFACE PREPARATION

New hull (epoxy or GRP)

- The surface should be degreased with Nautix SD and free of all contaminants (oil, grease, salt etc).
- Rinse with fresh water and let dry.
- Sand with P120 grade paper to improve adhesion of primer.
- Ensure the substrate to be dried, degreased, and free of dust.

Technical recommendation

On metal hull, it's recommended to apply this primer as soon as possible after having degreased and sanded the surface to get the best adhesion (for more details, please refer to our technical specifications for “steel” and “aluminium” boats)

Over antifouling or existing primer

- Remove the old antifouling :
 - 1 to 3 coats : Nautix STRIPPER.
 - More than 4 coats : air-blasting, high-pressure water blasting or scraper
- Check the condition of old primer : the former paint must not come unstuck from the support or must not crumble. Scrape with a brush to check support quality and remove any loosing paint
- Surface must be degreased with Nautix SD and dust free
- Rough sand with 120 grit to favour adherence
- Ensure the substrate to be dried, degreased, and free of dust

Compatibility

Important: 2-pack epoxy primer (hard finish) should not be used over any 1-pack product (soft finish).

It's recommended to control humidity rate of the hull before application of several coats of primer.

In case of doubts about old primer compatibility or quality, remove all the former primer.

SAFETY INFORMATION

- Work in well-ventilated area (ensure adequate ventilation during use), wear suitable protective clothing, gloves, glasses and eye/face protection. Unprotected person must be kept away from treatment area. Dispose of protective gloves and equipment after use.
- Read the label safety section for Health and Safety Information before application.

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HPE

High performance High-build epoxy primer

HINTS

- Application methods : brush, roller, spray gun , airless.
- Apply between 10 and 30°C (ideally inside with hygrometry rate no greater than 85%).
- Whilst curing in high humidity conditions and at lower temperatures, epoxies can develop an ‘amine bloom’ on the surface. This slightly sticky substance must be removed with Nautix SD. Failure to remove the bloom will also make sanding more difficult.
- Do not apply when there is a chance of condensation forming on the substrate (Dew-Point) : substrate, ambient air and product temperatures must be close.
- Stir or shake individual components thoroughly. Add hardener to the Base, stir and leave for 10 minutes to allow bubbles to disperse.
- Mix only the necessary quantity.
- If filling is required, use appropriate filler after the first coat of primer has been applied.
- Application :
 - Adhesion for antifouling : Apply 1 coat of primer. If overcoating period is exceeded, sand with 120 grade once dried.
 - Protection : Apply 3-5 coats of primer. If overcoating period is exceeded, sand with 120 grade once dried.
- For high thickness application (250µ wet), it’s recommended to double overcoating period.
- Favour natural solvent evaporation and do not heat ambient air after beginning of application. Do not use ventilator or heater directed on the surface.

APPLICATION

Roller / brush

- Apply the product by crossing roller layers.
- Thinning (volume) : Nautix DE from 0 to 10% max.
To get the best results, use a solvent-resistant mohair type roller. Do not hesitate to change refill when worn.

Theoretical coverage : 8m²/L per layer.
Thickness film : around wet 120µm per layer.

Conventional spray

- 2.0 to 2.5 bars, nozzle 2.0mm to 2.2mm.
- Thinning (volume) : Nautix DE from 10 to 15%.

Theoretical coverage : 5 to 6m²/L per layer.
Thickness film : around wet 120µm per layer.

Airless spray

- 170 to 240 bars, Nozzle 419 to 525 (if necessary : Thinner DE 10% max)
- Double the overcoating times.

Theoretical coverage : 3 to 4m²/L per layer.
Thickness film : around wet 250µm per layer.

TRANSPORT, STORAGE, AND SAFETY INFORMATION

Transport and storage

- This product should be kept in securely closed containers during transport and storage.
- Exposure to air, sun, and extreme temperatures should be avoided. For the full shelf-life of the paint, be sure that the container is firmly closed between use and the storage temperature is between 10° and 25°C. Keep out of direct sunlight.

Safety

- Before use, read the label safety section for Health and Safety Information. For further details, please contact Nautix or its distributors.
- All professional operators must wear suitable protective clothing : coveralls of a contrasting colour to the product being applied, underneath a disposable coverall with hood, suitable gloves and impervious footwear that protects the lower leg. Wear suitable respiratory equipment (such as air fed respiratory protective equipment with combined protective helmet and visor) when spraying.

Disposal

Disposal of remainders must be arranged for in consultation with the authorities. Do not discard tins or pour paint into water courses, use the facilities provided. It is best to allow paints to harden before disposal. Remainders of this product cannot be disposed of through the municipal waste route or dumped without permit.

General

The information given in this sheet is not intended to be exhaustive. Any person using the product without first making further written enquiries as to the suitability of the product for the intended purpose does so at their own risk. Nautix can accept no responsibility for the performance of the product or for any loss or damage. The information contained in this sheet is liable to modification from time to time.

