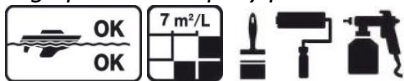


# EPOXYGARD

High protective epoxy primer with long overcoating period



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

## PRODUCT DESCRIPTION

Nautix EPOXYGARD is “new generation” high performance 2-pack epoxy primer recommended to hull protection, and paint adhesion, especially antifouling.

EPOXYGARD shapes very strong protective film with high-resistance to abrasion, particularly efficient against moisture. Easy to apply, EPOXYGARD is particularly adapted to substrates, which require high protection, below or above the waterline (GRP/Composites, aluminium, steel, and wood).

Its formula has been optimized to offer a long wet on wet overcoating period to painters and it can be overcoated by itself without sanding even after few days, provided that the surface would be maintained in good condition. This margin of tolerance makes easier planning of paint jobs for shipyards.

Applied in single layer, EPOXYGARD improves antifouling adhesion.

Applied in several layers (3-5), this primer provides high-protection against moisture (osmosis or corrosion).

## PRODUCT INFORMATION

Finish	Matt
Mixing ratio (volume)	4 base / 1 hardener
Mixing ratio (weight)	88g base / 12g hardener
Coverage	7m <sup>2</sup> /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 (or DP)

### Drying / Overcoating Information

Temperature	10°C	15°C	20°C	25°C	30°C
Pot life	12h	8h	6h	3h	2h
Touch dry	4h	3h	2h	1h30	1h
Overcoated by itself*	8h-5d	6h-4d	4h-3d	3h-48h	2h-36h
Overcoated by antifouling*	8h-30h	6h-24h	4h-16h	3h-12h	2h-8h
Sand after	24h	16h	12h	8h	6h
Dry	96h	72h	36h	24h	18h

d=days h=hours min=minutes

\*Overcoating time recommended for 1 layer (150µm wet thickness) – Please refer to Application

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

Colours Grey, ivory

## 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.

### Over antifouling or existing primer :

- Remove the old antifouling : 1 to 3 coats with Nautix STRIPPER, more than 4 coats with 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.

### 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).

### 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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## 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 (min 300µ DFT) : 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.
- For application over IMPREGARD : Apply 1<sup>st</sup> thin layer of EPOXYGARD if you don't want to soak resin while polymerization.

## APPLICATION

### Roller / brush

- Apply the product by crossing 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.*

### Conventional spray

- 2.0 to 2.5 bars, nozzle 1.8mm to 2.0mm.
- Thinning (volume) : Nautix DE from 10 to 20%.
- Do not filter less than 300µm.

### Airless spray

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

Minimum number of layers : 1 (adhesion), 3 (protection)  
Theoretical coverage per layer : 7m<sup>2</sup>/L  
Recommended WFT\* per layer : 150µm  
Recommended final DFT\*\* (protection) : 300µm

Minimum number of layers : 1 (adhesion), 3 (protection)  
Theoretical coverage per layer : 5m<sup>2</sup>/L  
Recommended WFT\* per layer : 150µm  
Recommended final DFT\*\* (protection) : 300µm

Minimum number of layers (protection) : 3  
Theoretical coverage per layer : 3.5m<sup>2</sup>/L  
Recommended WFT\* per layer : 200µm  
Recommended final DFT\*\* (protection) : 300µm

\*WFT : Wet film thickness / \*\*DFT : Dry film thickness

### EPOXYGARD overcoated by EPOXYGARD

- Chemical affinity without sanding works for 5 days and could go to 2-3 weeks in interior (no moisture, dust-free, constant temperatures).
- For high-thickness application (airless), double the overcoating times.
- In case of doubt, rough sand with 120 paper grade.

### EPOXYGARD overcoated by antifouling

- Antifouling overcoating must be done within the period indicated in "Product Information" sheet. In case of doubt, rough sand with 120 grade.

## 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.

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