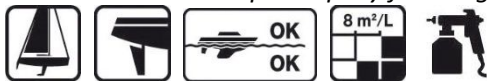


# NX194

Abrasion resistant 2-pack epoxy finishing paint for appendages



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



## PRODUCT DESCRIPTION

NX194 is a very durable 2-pack epoxy paint containing high-hardness particles to protect sensitive underwater profiles (daggerboard, keel, rudder, foil) against abrasion. This product can be applied on all hard surfaces, providing primer protection has been applied.

NX194 provides very smooth finishing aspect, and limits abrasion of the surface of foils and daggerboards when sliding under load into their bearings.

## PRODUCT INFORMATION

Finish	Satin
Mixing ratio (volume)	5 base / 3 hardener
Mixing ratio (weight)	3 base / 1 hardener
Coverage	8m <sup>2</sup> /Kg per layer
Flash point	21°C < FP < 55°C
Density	1.4 kg/L
Volume solids	50%
Unit size	1kg
Typical shelf life	5 years
Colours	White, black, orange fluo, yellow fluo
Thinner/Cleaner	Nautix DE (or DP)

### Drying / Overcoating Information

Temperature	15°C	20°C	25°C
Pot life	6h	4h	3h
Touch dry	4h	2h	1h30
Overcoated by itself*	6h – 10h	4h – 8h	3h – 6h
Sand after	18h – 24h	14h – 20h	10h – 16h
Immersion after	72h	48h	36h

d=days h=hours min=minutes

\*Overcoating time recommended for 1 layer (30-40µm wet thickness) – Please refer to *Application*

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

## TYPE OF SURFACES

- Polyester.
- Epoxy.

## SURFACE PREPARATION

### Over Epoxy paint or existing two-component primer :

- Surface must be clean and degreased using Nautix SD.
- Lightly sand with 120-150 grit to promote mechanical bonding.
- Rinse with fresh water, let dry thoroughly, and degreased using Nautix SD.

### On composite surface (in good condition) :

- Ensure absence of porosity, pinhead or open crossing of threads. If any, scrape on the surface a porosity-filler or a compatible solvent-free pure resin in order to avoid possible subsequent water tightness problems (localized blistering).
- Level off and sand the surface with 120 grit. Rinse with fresh water, let dry and degrease with Nautix SD.
- Apply minimum 2 layers of high-hardness primer (i.e. PE).
- Lightly sand the surface with abrasive paper 120-150 grit. Rinse with fresh water, let dry and degrease with Nautix SD.

### Technical recommendation

Due to low hiding power of NX194, it is recommended to spray it on a light background (like PE ivory primer or U2 white undercoat).

Moreover, in order to facilitate the later removal of NX194, it is recommended to first apply a colored primer (interlining to visualize disappearance of abraded layers) directly on top of composite materials. A minimum of two primer layers is therefore suggested.

## 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.



# NX194

Abrasion resistant 2-pack epoxy finishing paint for appendages

## HINTS

- Application method : Conventional spray gun.
- 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.
- 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.
- Apply between 10° and 30°C (ideally inside with hygrometry rate no greater than 85%).
- 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

### Conventional spray gun

- Application using a spray gun is recommended (2.0 bars, nozzle 1.8mm).
- Thinning (volume) : Nautix DE from 20 to 30% max.
- Finishing :
  - Can be sanded with wet paper (600, then 800 or 1000) within 36h to 48h following application to achieve optimal surface finish. This limits abrasion to the foil or dagger board surface, whilst being used in a bearing housing under load.
  - Can be overcoated with antifouling paint (i.e. fluorescent paint on daggerboard tips) provided the surface has been prepared for mechanical bonding using abrasive paper before NX194 is fully dry.

Number of coats : 2 minimum  
Theoretical coverage per layer : 8m<sup>2</sup>/Kg  
Recommended WFT\* per layer : 30-40µm  
Minimum final recommended DFT\*\* : 60µm

### Important :

*NX194 contains high-density particles that makes it subject to sagging on vertical surfaces when diluted. It is therefore strongly recommended to position appendages horizontally. This will allow the building of a sufficient wet film thickness (30 to 40µm) despite a high dilution ratio, and enable the paint to flow consistently. If not possible, do not dilute more than 30% and break down the application process in several light passes to allow faster evaporation of solvents. Do not hesitate to make trial shots on a separate surface before application.*

\*WFT : Wet Film Thickness / \*\*DFT : Dry Film Thickness

**Note** : wet on wet application of NX194 over itself or over Epoxy primers is possible, provided solvents are totally evaporated from the previously applied film (depends on dilution and atmospheric conditions). If subsequent layers polymerizes faster than the underlying coat dries, solvent could be trapped in the film or in the composite surface. Paint must stay slightly tacky but not leave traces on finger.

## 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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