



# Aluminium Hull

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PROCESS SPECIFICATION

# A 6 STEP PROCESS



1. Substrate preparation
2. Adhesion promoter : « Metapox »
3. Insulation: « Epoxygard »
4. Fairing : « Watertight or Blue Filler Epoxy »
5. Protection : « Epoxygard »
6. Finishing paints

# Step 1 : Substrate preparation



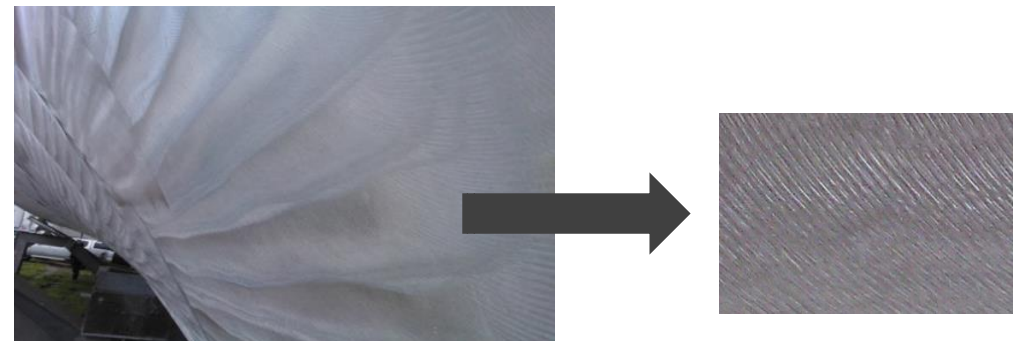
Clean the surface with soap, neutral or faintly caustic washing liquid (like diluted St Marc). Rinse with fresh water. If there is oil or fat, wash the surface with SD Nautix Degreaser.

Remove completely superficial oxidation by mechanical scouring. If possible, go on with sandblasting (medium or large grit). Otherwise use special abrasives discs as Zirconia, Ceramic or corundum (P40 or 60 grit for optimum result).

*The resulting surface must be uniform, lightly dulled and rough. Do not let any shiny or smooth areas.*

Rinse with fresh water, let dry thoroughly

Proceed to the painting without delay (within 1/2 day)



# Step 1 : Substrate preparation

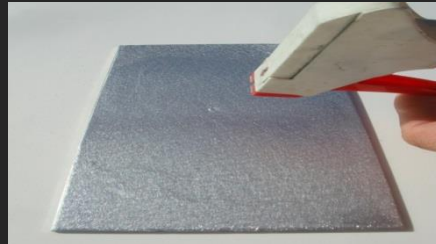


## SPRAY test:

Spray water over a small area and check that the water spreads evenly. No droplets should appear .



Roughly frosted surface



Well-frosted surface



In the case of a prolonged wait after scouring an alumina film will form on the substrate.

In that case you will have to deoxidize the surface by paper sanding (P80-120P Grit) or using SCOURING ACID with a spray before painting.

When using Scouring Acid let work for 20 minutes and rinse copiously with fresh water before applying METAPOX.





# Step 2 : Adhesion promoter



## METAPOX :

This easy-to-use product has been developed to strengthen the adhesion of epoxy on aluminium. It acts by bridging between two surfaces.



Do not apply METAPOX if you are not sure whether you can apply a first coat of epoxy within one day.

Application in one coat by brush or roller.

Wet the surface evenly with a very thin coat

*METAPOX is very liquid, do not attempt to apply thickly.*

Isolate this support with an epoxy primer as soon as the Metapox is dry.



Temperature	10°C	20°C	30°C
Overcoating time after metal substrate preparation		0 - 4 H	

# Step 3 : Insulation



Apply a first coat of epoxy primer EPOXYGARD

- Maximum recommended thickness : 150µm wet per coat
- Apply with brush, roller or Airless

Avoid condensation, ensure temperature is above dew point and that hull is not colder than the room temperature.

This layer gives a hard and uniform background. It reveals hull defects before coating.



## EPOXYGARD :

High performance protective coating gives long wet on wet overcoating time.

Temperature	10°C	20°C	30°C	40°C
Operating window to overcoat METAPOX with Epoxygard	2-10 H	1-8 H	1-6 H	1-5 H

# Step 4 : Fairing



Application of filler is optional : depending on importance of surface imperfection (mixing ratio 1/1 in weight & volume)

Sanding with 80-120P grit



## WATERTIGHT OR BLUE FILLER :

Fast-drying **WATERTIGHT** filler for low thickness application (5mm) and small local repairs (density 1).

**BLUE** filler for high-thickness application and fairing of large surfaces (density 0,8).

Temperature	10°C	15°C	20°C	25°C
Overcoated time without sanding between EPOXYGARD and epoxy filler	Mini - Max 8h to 5 days	Mini - Max 6h to 4 days	Mini - Max 4h to 3 days	Mini - Max 3h to 2 days
Minimum time before Watertight filler sanding	9h	6h	4h	3h
Minimum time before Blue filler sanding	24h	16h	8h	5h

# Step 5 : Protection



Apply 4-6 coats of Epoxygard :

- By roller or spray gun (thinner : 10 - 20%)
- Recommended thickness maximum : 150µm wet/coat
- Coverage : 7m<sup>2</sup>/L

Respect overcoating time between layers to allow good evaporation of solvents.



## EPOXYGARD :

Epoxygard is an epoxy primer giving high protection against moisture.

It gives large overcoating window to aid easier application, also good resistance to abrasion

Temperature	10°C	15°C	20°C	25°C	30°C
	Mini - Max	Mini - Max	Mini - Max	Mini - Max	Mini - Max
Overcoated by itself	8h to 5 days	6h to 4 days	4h to 3 days	3h to 48h	2h to 36h
Overcoated by antifouling	8 to 30h	6h to 24h	4h to 16h	3h to 12h	2h to 8h
Drying time before Sanding	24h	16h	12h	8h	6h



# Step 6 : Finish paints



## Hull : Antifouling A1

Nautix A1 is a high-performance antifouling especially developed for aluminium hulls.

- Apply in 2 thick coats or even a 3rd coat at the waterline
- Covering 10 m<sup>2</sup>/L
- For mor information check the data sheet



## Topsides & Deck

- Degreasing with SD Nautix then sanding
- Metapox adherence promoter
- Epoxygard insulation
- Epoxy Filler Watertight if needed
- Epoxygard protection
- Nautix **U2** (two-component opacifying epoxy undercoat for obtaining a plain white background)
- Nautix **L2** (High quality two-component finishing paint with a very high level of gloss and high resistance to U.V. rays)



This system can be coated with **VA2 varnish** to prevent raking, and/or mixed with **Grip Additive Medium** anti-slip ball.

# PRODUCT REFERENCES

Product	Description	Color	0,5L	1L		
METAPOX	Adhesion promoter	Colorless	15.19.01	15.19.02		
			<b>0,75L</b>	<b>2,5 L</b>	<b>5 L</b>	<b>20 L</b>
EPOXYGARD	High Protective Epoxy Primer	Grey	15.19.90	15.19.91	15.19.92	15.19.93
		Ivory	15.19.95	15.19.96	15.19.97	-
U2	White Epoxy undercoat for L2	White	15.19.20	15.19.21		
				<b>1 L</b>	<b>5 L</b>	<b>30 L</b>
Blue Filler	Light Epoxy Filler	Light Blue	-	-	15.18.42	15.18.44
Watertight	Fast cure Epoxy Filler	Light Pink	-	15.18.53	15.18.54	-
			<b>0,75 L</b>	<b>2,5 L</b>		
L2	PU Topside finish	14 colors+RAL	TBD	TBD		
VA2	PU Varnish	High Gloss / Satin	TBD	TBD		
			<b>0,75 L</b>	<b>2,5 L</b>		<b>20L</b>
A1	Antifouling	White	15.01.00	15.01.01		15.01.03
		Blue	15.01.04	15.01.05		15.01.07
		Black	15.01.08	15.01.09		15.01.11
			<b>0,75 L</b>	<b>2,5 L</b>		
DA	Antifouling Thinner	Colorless	15.17.10	15.17.12		
DE	Thinner for Epoxygard and U2	Colorless	15.17.50	15.17.52		
DP	Thinner for L2	Colorless	15.17.30	15.17.32		



# Technical support

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