

BOAT PREPARATION

▷ PROTECTION OF STEEL HULL

With IA-PA system



STEP 1 : PREPARATION

- Sandblasting or discing to bare metal.
- Remove rust with: needle scaler, rotary wire brushes, grinding disc or sandblasting (finish SA1 minimum).

STEP 2 : DEGREASE

- Rinse cast-iron keel with fresh water several times.
- Degrease with Nautix SD.

STEP 3 : IMPREGNATION

- 1) 1 thin coat of Nautix IA impregnation with brush.
- 2) 1 coat of Nautix PA anticorrosion primer

STEP 4 : FAIRING / REPAIR (OPTIONAL)

- Fill uneven areas with Nautix **Watertight** (solvent-free fast drying finishing Epoxy filler),
can be easily sanded between 3h to 9h after repair,
- Rough sand with 80-150 grit, rinse and let dry.

STEP 5 : PRIMER : PA

- If necessary, dilute with Nautix DP (approx, roller:10%, spray gun: 20%)
- Apply with brush, roller or spray gun (1,8 or 2mm nozzle, 2 bar).
- Layers of PA primer for protection: 2.
- If necessary, light sand with 240 grit to have plane surface, then rinse with fresh water and let dry thoroughly

STEP 6 : ANTIFOULING : A3 or A4

- *Spray gun (recommended)* : 1,4 or 1,6 mm nozzle, 2 bar pressure. Dilution : 15 to 25%(Nautix DA) depending on T° and nozzle.
- *Roller*: choose a good quality roller for best result (natural fiber, short or medium haired). Dilution : 5 to 10%(Nautix DA).
- To ensure a good antifouling efficiency over time, apply a minimum of 100µm dry film (total) in 2 or 3 layers.
Top Tip : to get a better finishing, use more thinner for 2nd layer



Work in a well ventilated area.
Wear appropriate protective clothing, gloves, glasses and mask.

Drying time before overcoating :

| Hygrometry / Temperature | 10°C | 15 °C | 20°C | 25°C |
|--------------------------|------|-------|------|------|
| 40% | 12 h | 9 h | 7 h | 5 h |
| 60% | 8 h | 5 h | 3 h | 2 h |
| 80% | 6 h | 3 h | 2 h | 2 h |

Covering : IA = 16m²/L – PA = 14m²/L (120µm wet film)
Apply between 0°C and 35°C.

Recommendations :

Avoid condensation, ensure temperature is above dew point and that hull is not colder than room temp.
Not necessary to sand IA or PA

| | 10°C | 15 °C | 20°C | 25°C |
|-----------------------|-------|-------|-------|-------|
| Pot life | 60min | 45min | 20min | 15min |
| Sandable/over coating | 9 h | 6 h | 4 h | 3 h |
| Dry | 96 h | 72 h | 48 h | 36 h |

Mixing ratio : 1 for 1 (weight or volume)

Drying time before overcoating :

| Hygrometry / Temperature | 10°C | 15 °C | 20°C | 25°C |
|--------------------------|------|-------|------|------|
| 40% | 12 h | 9 h | 7 h | 5 h |
| 60% | 8 h | 5 h | 3 h | 2 h |
| 80% | 6 h | 3 h | 2 h | 2 h |

Covering : PA = 14m²/L (120µm wet film)
Apply between 0°C and 35°C.

Recommendations :

Avoid condensation, ensure temperature is above dew point and that hull is not colder than room temp.
Put the quantity you need in a container and close the cans immediately.
Not necessary to sand PA

| | 10°C | 15 °C | 20°C | 25°C |
|--------------|-------|--------|--------|--------|
| Pot life | 2 h | 1 h 30 | 1 h | 30 min |
| Over coating | 3-4 h | 2-3 h | 1 h 30 | 1 h |
| Dry | 6 h | 4 h | 3 h | 2 h |

Usual covering:
A3 : 8.5m²/L
A4 : 10m²/L



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