

# BOAT PREPARATION

## TREATMENT OF CAST-IRON KEEL

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.



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

### STEP 3 : IMPREGNATION

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



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 = 16m<sup>2</sup>/L – PA = 14m<sup>2</sup>/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

### 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.



	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)

### 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



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 = 14m<sup>2</sup>/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

### STEP 6 : HARD MATRIX ANTIFOULING WITH PTFE : A4T.Speed

- *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 2<sup>nd</sup> layer



	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: 12m<sup>2</sup>/L



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