



SEA-SPEED V 10 X ULTRA CLEAR

Application guide for FRP/Gel-Coat hulls

(Hard film CLEAR COAT Silane - Siloxane foul release coating).

Spray or Brush and Roll Version

SEA-SPEED V 10 X ULTRA CLEAR is designed and engineered to be applied on new hulls. It Can be applied to pleasure craft, racing sailboats, powerboats and personal watercraft. Properly applied, the coating will be glass smooth with a surface roughness of less than 5 microns.

PREPARATION (New Hulls)

Surface Preparation for all Immersed gel coat / fiberglass Surfaces

1. If the craft has been in the water, remove the boat from the water and immediately high pressure water blast in order to remove fouling.
2. Mechanically remove fouling by scraping followed by high-pressure water cleaning.
3. Remove all accessories from the hull such as trim tabs. .
4. Using commercially available products the hull should be de-waxed. Follow the de-waxing process wipe down using high flash ketone based products such as MEK (Methyl ethyl ketone) to clean the area to be coated to remove any residual mold release compounds remaining on the surface. Apply solvent and follow by rubbing and wiping down towards the keel. This may take several applications.
5. Remove all accessories from the hull such as trim tabs.
6. Thoroughly sand surface by hand or with an orbital sander using one eighty (120 - 180 grit) sanding disks. Chines and waterline are critical areas and special care should be taken to ensure those areas in particular are properly prepared.

PLEASE NOTE: Surface preparation is the key to a quality and successful finish

7. All surfaces must be clean and be free of dust, salt, dirt, oil and grease. Use compressed air to remove residual dust. If latent oils or grease are present, use MEK (Methyl Ethyl Ketone) or other high flash solvent to remove any contamination.

Safety

It is important to protect yourself and the environment during the hull preparation and coating process.

Proper clothing such as disposable paper suits, goggles, a charcoal filter mask, a balaclava cotton hood and good quality dishwashing or chemical resistant disposable gloves.

Protect the ground where you are working so that you can contain the collect residual paint dust and dispose of it according to local regulations.

Prior to applying any coatings, a survey of the bottom should be performed to check for cracks, leaks, blisters or grounding damage. Repair as necessary or contact a professional for an assessment and repair.

PROCEDURE AND TIMING:

- Apply one coat of SEA-SPEED V 10 X CLEAR to the hull by airless spray pump (30:1 ratio 3000 psi minimum) with a Graco FFLP (Fine Finish Low Pressure) tip; size .308 or pressure pot with HVLP gun may be used. A 1.4 or 1.6 mm tip should be used for best results with an HVLP.
- Apply at 5 mils (125 microns) wet film thickness.
- **May be applied by roller (ANZA ELITE ONLY). Available through Seacoat SCT, LLC or SEA-SPEED-PC,LLC. Roll horizontally only. Do not overwork. 3-4 passes only.**
- Allow to cure a minimum of 24 hours prior to moving the vessel or blocks.

Protect the vessel from moisture (rain) and check the weather forecast before starting. Prior to applying any paint you should protect all areas not to be coated. Apply a good quality masking tape or "Fine Line" for the waterline / boot-top.

Supplies

Electric or pneumatic Airless spray pump (30:1 ratio)

Please note the airless sprayer should be compatible with hot solvents for cleaning purposes.

Tip: A Graco fine finish tip (FFLP) is best suited. Tip size should be (.208/.308).

Hose: 3/8 " i.d. (9.52 mm i.d.).

** If applied by Pressure pot with HVLP gun use a 1.4 or 1.6 mm tip.**

** If roller application method is to be used, ANZA ELITE rollers should be utilized.

Electric or pneumatic rotary paint mixers

Clean new Polyethylene or steel mixing containers

Clean up solvent: Sherwin Williams R7K15 or C 50, International 220, Ameron T-10 or Jotun No. 17

Disposable solvent resistant gloves.

Face protection and mask/ respirator

A wet film gauge.

HVLP: (High Volume Low Pressure) gun with pressure pot may be used. Tip size shall be 1.4 – 1.6 mm.

Mixing and application of *SEA-SPEED V 10 X ULTRA CLEAR*

IMPORTANT: Substrate temperature must be above 41 ° F (5° C) and at a minimum must be 5 ° F (3 C) above the dew point.

The ***SEA-SPEED V 10 X ULTRA CLEAR*** is supplied in 1 gallon (3.785 liter) or 5 gallon (18.925 liter) Kits. It is a 4:1 ratio mix by volume Part B Base(resin) to Part A activator.

DO NOT THIN THE MATERIAL

- Mix the necessary amount of ***SEA-SPEED V 10 X ULTRA CLEAR*** to coat the underwater hull area with:
- 5 mils (125 Microns) wet. Coverage is as follows:

at 5 mils (125 microns): 305 square feet per gallon (7.48 sq. meters per liter)
Practical coverage with Spray is 213 sq. ft per gallon (5.25 sq meters per liter).
- Pre- mix Part B until smooth. Keep rotary mixer blade submerged.

- Mix PART A & PART B together for 3-4 minutes until smooth and homogenous.
- Material should be smooth with no solids.
- Material may be filtered through a paper filter as this will help remove entrained air.
- **An Induction time of 5-8 minutes is required before applying.**
- Airless Spray tip should be a Graco Fine Finish Low Pressure .208, .308 when using an airless.
- For airless: Remove pump filter and gun filter.
- Check wet film thickness with a gauge to ensure proper thickness.

Once the SEA-SPEED has cured 24 hours or is sufficiently hard not to be damaged, the pads and blocks may be moved:

Around block and pad spots, lightly sand on to the new existing SEA-SPEED 1-2 inches with 120/180 sand paper.

Mix an appropriate amount of SEA-SPEED and apply by roller or HVLP spray on the pad spots being sure to feather the newly applied material on to the sanded area of SEA-SPEED on the perimeter. If spraying use adequate means to prevent overspray on adjacent areas.

Vessel may be placed into the water no sooner than twenty four (24) hours after coating and as soon as the coating system has achieved a hardness that is not easily mechanically damaged. If temperatures are or fall below 77°F additional time may be required before being re-floated. **For each 10°F under 77°F (6.25°C under 25°C) add 6 hrs to re-float time.**

The coated vessel may be left out of the water indefinitely. **SEA-SPEED** is inert once cured and does not contain any cuprous oxide or biocides that degrade.

Safety

Painters should avoid ingesting coating through the nose or mouth. Proper attire, such as adequate air masks and goggles must be worn during application. Refer to product data sheets and MSDS forms for full details.

Please note that vessels coated with **SEA-SPEED** that sit idle for extended periods will foul as will conventional toxic cuprous oxide bottom paints. Hulls with **SEA-SPEED** should be maintained by regular cleaning as are conventional paints.

DO NOT USE SCOTCHBRITE PADS OR ANYTHING ABRASIVE TO CLEAN. Divers mitts, Poly bristle brushes and plastic paint scrapers are to be used.

Cleaning the **SEA-SPEED** is the owners/operators responsibility and must be done with a **non abrasive** brush, mitt or pad only (such as a piece of carpet or plastic paint scraper) and will not harm the coating.