



SEA-SPEED V 10 X ULTRA CLEAR

Application guide for Gel coat or Fiberglass hulls previously painted with antifouling paint

(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 to new hulls as well as hulls that have existing antifouling paints. 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

Surface Preparation for all Immersed 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. Sand off or Soda blast the hull to remove all old coatings.
5. Any hull damage should be repaired and faired accordingly to customer satisfaction.
6. Finish off hull preparation with 180 – 220 sandpaper. All Chine areas should be well sanded.

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

7. clean all surfaces, must be 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 while the hull preparation.

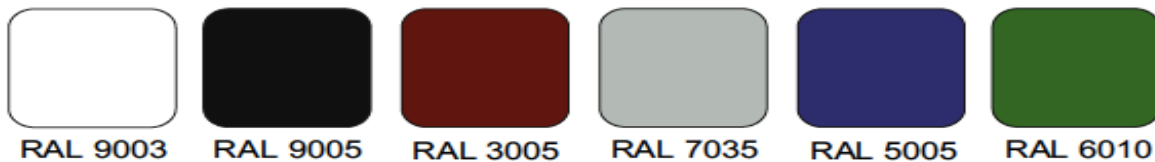
Proper clothing such as disposable paper suits, goggles, a charcoal filter mask, a balaclava cotton hood and good quality dishwashing or chemical resistant disposable gloves.

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 coating 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 SEAPOXY 73 Epoxy barrier coat at 7 mils (175 microns) wet. Allow to cure overnight. Please review SEAPOXY 73 Technical data sheet and MSDS prior to use.
- Next morning apply another coat of SEAPOXY 73 Epoxy barrier coat at 7 mils (175 microns) wet. This should be the final desired color of the hull. Standard color choices are:



- For ideal maximized adhesion Allow the second coat of SEAPOXY 73 to cure between 4 – 8 hours temperature dependent to a point it is a “**Firm Thumbprint**”. This where you apply 20 -25 psi pressure with your thumb and can barely leave a print.
- **NOTE: SEAPOXY 73 may be allowed up to 12 hours cure prior to overcoat with SEA-SPEED V 10 X ULTRA if the SEAPOXY 73 curing period is overnight and the ambient temperature falls below 65 °F (18 °C). The adhesion between the SEAPOXY 73 and SEA-SPEED V 10 X ULTRA CLEAR drops off quite rapidly if the SEAPOXY 73 is allowed to cure past 12 hours.**
- Apply one coat of SEA-SPEED V 10 X ULTRA CLEAR to the hull by:
 - a) airless spray using a Graco FFLP (Fine Finish Low Pressure tip in size .308
 - b) pressure pot with HVLP gun. A 1.4 or 1.6 mm tip should be used for best results.

c) SEA-SPEED V 10 X ULTRA CLEAR can be applied by roller. USE ONLY ANZA elite rollers available through Seacoat or SEA-SPEED-PC, LLC. **Do not overwork. 3-4 passes only. Roll Horizontally only.**

- Apply at 5 mils (125 microns) wet film thickness.
- 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. 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 (Min 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 rolling USE ONLY ANZA ELITE ROLLERS

Electric or pneumatic rotary paint mixers

Clean new Polyethylene or steel mixing containers

Clean up solvent (Sherwin Williams R7K15, C50, Ameron T-10, International 220, Jotun No. 17

Disposable solvent resistant gloves.

Face protection and mask/ respirator

A wet film gauge.

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.

- 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 by 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 Fine Finish .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 220 or finer sand paper.

If the two coats of SEAPOXY 73 need to be applied on the gel coat or fiberglass, apply using the same process detailed above. Do not apply SEAPOXY 73 over the Adjacent cured and sanded SEA-SPEED. Apply only on block or pad spot only.

After appropriate cure time proceed with application of SEA-SPEED.

Mix an appropriate amount of SEA-SPEED and apply by roller on the pad spots being sure to feather the newly applied material on to the sanded area of SEA- SPEED on the perimeter.

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.