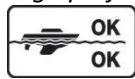


BLACK EPOXY FINISHING

High performance thin and gloss epoxy finishing paint



PRODUCT DESCRIPTION

Nautix 2-component black epoxy finishing is a specific paint especially developed for the hulls of river boats.

This finishing paint forms a thin film that brings great hardness and high abrasion resistance. Easy to apply, this paint will offer very smooth and glossy finishing aspect to make easier cleaning job.

PRODUCT INFORMATION

Finish	Gloss
Mixing ratio (volume)	2.3 base / 1 hardener
Mixing ratio (weight)	3 base / 1 hardener
Coverage	12m ² /L (roller)
Flash point	23°C <PE<55°C
Unit size	2.5L
Typical shelf life	5 years
Thinner / Cleaner	Nautix DE
Colour	Black

Drying / Overcoating Information

Temperature	10°C	15°C	20°C	25°C	30°C
Pot life	12h	8h	6h	3h	2h
Touch dry	3h	2h	1h30	1h	30min
Overcoated by itself*	6 à 12h	5 à 10h	3 à 6h	2 à 5h	1 à 3h
Sand after	24h	20h	12h	8h	6h
Dry	4d	3d	30h	24h	20h

d=days h=hours min=minutes

*Overcoating time recommended for 1 layer (100µm wet thickness) – Please refer to Application

*If maximum overcoating time is exceeded, sand with 120 grade wet or dry paper

TYPE OF SURFACES

- Polyester
- Epoxy

SAFETY INFORMATION

- Work in well-ventilated area (ensure adequate ventilation during use), wear suitable protective clothing, gloves, glasses and eye/face protection. Unprotected person must be kept away from treatment area. Dispose of protective gloves and equipment after use.
- Read the label safety section for Health and Safety Information before application.

SURFACE PREPARATION

New hull

- Sand the surface with P40 (metal) or P120 (polyester) to improve mechanical adhesion.
- The surface should be degreased with Nautix SD and free of all contaminants (oil, grease, salt etc.).

Previously coated surface (primer,...)

- Check the substrate coated: Before overcoating, remove all loosely adhering and flaking paint, feather back all edges. You can grit with brush in different areas to test adhesion of coatings over substrate.
- Remove all traces of existing paints with poor adhesion.
- Sand the surface with P120 to improve mechanical adhesion.
- The surface should be degreased with Nautix SD and free of all contaminants (oil, grease, salt etc.).

Technical recommendation

Select the right protective or adhesion primer over metal substrate :
Aluminium/steel : METAPOX + EPOXYGARD

Compatibility

Important: 2-pack epoxy primer (hard finish) should not be used over any 1-pack product (soft finish).

In case of doubts about old primer compatibility or quality, remove all the former primer.



BLACK EPOXY FINISHING

High performance thin and gloss epoxy finishing paint

HINTS

- Application methods : brush, roller, spray gun, airless.
- Apply between 10 and 30°C (ideally inside with hygrometry rate no greater than 85%).
- Whilst curing in high humidity conditions and at lower temperatures, epoxies can develop an 'amine bloom' on the surface. This slightly sticky substance must be removed with Nautix SD. Failure to remove the bloom will also make sanding more difficult.
- Do not apply when there is a chance of condensation forming on the substrate (Dew-Point) : substrate, ambient air and product temperatures must be close.
- Favour natural solvent evaporation and do not heat ambient air after beginning of application. Do not use ventilator or heater directed on the surface.
- Stir or shake individual components thoroughly. Add hardener to the base, stir and leave for 10 minutes to allow bubbles to disperse.
- Mix only the necessary quantity.

APPLICATION

Brush / Roller

- Apply the product by crossing layers.
- Thinning (volume) : Nautix DE from 5 to 10% max.
- To get the best results, use a solvent-resistant mohair type roller. Do not hesitate to change refill when worn.

Minimum number of layers : 1
Theoretical coverage per layer : 12m²/L
Recommended WFT* per layer : 100µm

Conventional spray

- 2.0 to 2.5 bars, nozzle 1.6mm to 2.0mm.
- Thinning (volume) : Nautix DE from 10 to 20%.
- Do not filter less than 300µm.

Minimum number of layers : 1
Theoretical coverage per layer : 8m²/L
Recommended WFT* per layer : 100µm

Airless spray

- 170 to 240 bars, Nozzle 419 to 525 (if necessary : Thinner DE 10% max)
- Do not use thinner

Minimum number of layers : 1
Theoretical coverage per layer : 6m²/L
Recommended WFT* per layer : 200µm

*WFT : Wet Film Thickness

TRANSPORT, STORAGE, AND SAFETY INFORMATION

Transport and storage

- This product should be kept in securely closed containers during transport and storage.
- Exposure to air, sun, and extreme temperatures should be avoided. For the full shelf-life of the paint, be sure that the container is firmly closed between use and the storage temperature is between 10° and 25°C. Keep out of direct sunlight.

Safety

- Before use, read the label safety section for Health and Safety Information. For further details, please contact Nautix or its distributors.
- All professional operators must wear suitable protective clothing : coveralls of a contrasting colour to the product being applied, underneath a disposable coverall with hood, suitable gloves and impervious footwear that protects the lower leg. Wear suitable respiratory equipment (such as air fed respiratory protective equipment with combined protective helmet and visor) when spraying.

Disposal

Disposal of remainders must be arranged for in consultation with the authorities. Do not discard tins or pour paint into water courses, use the facilities provided. It is best to allow paints to harden before disposal. Remainders of this product cannot be disposed of through the municipal waste route or dumped without permit.

General

The information given in this sheet is not intended to be exhaustive. Any person using the product without first making further written enquiries as to the suitability of the product for the intended purpose does so at their own risk. Nautix can accept no responsibility for the performance of the product or for any loss or damage. The information contained in this sheet is liable to modification from time to time.

