

# HULL PREPARATION

## ▶ ALUMINIUM

Preparation/Epoxy primer/Antifouling



*Preliminary remark : Aluminium surfaces become covered quickly with oxide layer (aluminium oxide) that protects naturally metal against corrosion. That colourless layer is not suitable for paint adhesion. That's why the surface must be carefully prepared : Clean it and make it rough to improve adhesion of primer.*

### PREPARATION

- Clean the surface with soap, neutral or faintly caustic washing liquid (like diluted St Marc). Rinse with fresh water.
- If there is oil or fat, wash the surface with **SD Nautix Degreaser**



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

### DESOXYDATION

- Remove completely superficial oxidation by **mechanical scouring**.
- If possible, go on with sandblasting (medium or large grit). Otherwise use fiber discs with zirconium oxide, corundum or ceramic (P40 or 60 grit for optimum result). The resulting surface must be uniform, lightly dulled and rough. Do not let any shiny or smooth areas.
- Never use steel wool or wire brush.
- **Rinse** with fresh water, let dry thoroughly and **overcoat with primer asap (2-3 hours max)**.
- In case of prolonged waiting time after scouring, it is recommended to remove oxidation on surface with **scouring acid before paint application**. Let work for 20 minutes and **rinse copiously** with fresh water.



### ADHESION PRIMER

- To get the best adhesion, apply one thin coat of **Acralu**.
- Let dry for 15-20 minutes and **overcoat immediately** with primer.



Mixing ratio : 1 for 1

Covering : 15 m<sup>2</sup> / L (50µm wet maximum)

	10°C	15 °C	20°C	25°C
Pot life	9 h	8 h	6 h	3 h
Hand dry	20min	15min	10min	5min
Max overcoating time	2 h	1 h30	1 h	30min

### PROTECTION PRIMER : HPE

- Homogenize each part separately before mixing
- Dilute after mixing with Nautix **DP** (approx, roller : 10%, spray gun : 20%)
- Apply with brush, roller or spray gun (1,8 or 2mm nozzle, 2 bar)
- Apply 4-5 coats for an optimum protection.
- Succession of layers :
  - Overcoat before full polymerization to favour chemical adhesion (wait until complete evaporation of solvents),
  - Otherwise, sand with P150 grit after polymerization, between 8 and 24h after each layer application (See drying time table).
- Layers can be applied wet on wet for optimal chemical bonding, or sand using 150 grit between 8 to 24h after each application (see table).
- Let dry the last layer through and rough sand with P150 grit



Mixing ratio : 3 for 1 in volume

Covering : 8,5 m<sup>2</sup> / L (120µm wet)

Apply between 10°C and 35°C.

Avoid condensation, ensure temperature is above dew point and that hull is not colder than room temp.

	10°C	15 °C	20°C	25°C
Pot life	12 h	8 h	6 h	3 h
Hand dry	3 h	2 h	1 h 30	1 h
Overcoating after	6-10 h	4-6 h	3-4 h	2-3 h
Sanding after	24 h	18 h	12 h	8 h
Dry	4 j	3 j	32 h	24 h

### ANTIFOULING FOR ALUMINIUM HULL (A1 or A2)

- *Roller* : choose a good quality roller for best result (natural fiber, short or medium haired). Thinner : 5 to 10%(**Nautix DA**).
- *Spray gun (recommended)* : 1,4 or 1,6 mm nozzle, 2 bar pressure. Thinner : 15 to 25%(**Nautix DA**) depending on T° and nozzle.
- To ensure good antifouling efficiency over time, apply a minimum of 120µm dry film (total) in 2 or 3 layers.

Top Tip : to get a better finishing, use more thinner for final layer



	10°C	15 °C	20°C	25°C
Hand dry	2 h	1 h 30	1 h	30 min
Overcoating after	3-4 h	2-3 h	1 h 30	1 h
Dry	6 h	4 h	3 h	2 h

(\* See technical data sheets for details concerning application)

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