## **BOAT PREPARATION**

# TREATMENT OF LEAD KEEL

With Acralu-PA system



- Sandblasting or discing to bare metal.
- Remove rust with: needle scaler, rotary wire brushes, grinding disc or sandblasting (finish SA1 minimum).



### STEP 2: DEGREASE

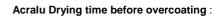
- Rinse lead keel with fresh water several times.
- Degrease with Nautix SD.





### Work in a well ventilated area.

Wear appropriate protective clothing, gloves, glasses and mask



Hygrometry / Temperature	10°C	15 °C	20°C	25°C
40%	9 h	8 h	6 h	3 h
60%	20min	15min	10min	15min
80%	2 h	1h30	1 h	30min
			•••••	

### PA 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 : Acralu =  $15m^2/L$  - PA =  $14m^2/L$  (120µm wet

Apply between 0°C and 35°C.

### STEP 3: IMPREGNATION

- 1 thin coat of Nautix Acralu impregnation with brush.
- 1 coat of Nautix PA anticorrosion primer







### 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 36 h

Mixing ratio: 1 for 1 (weight or volume)

### 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
- Rough sand with 80-150 grit, rinse and let dry.





### Drying time before overcoating:

	10°C	15 °C	20°C	25°C	
Pot life	12 h	9 h	7 h	5 h	•
Over coating	8 h	5 h	4 h	3 h	
Dry	4 days	3 days	30 h	24 h	•

Covering:  $U2 = 14m^2/L (120\mu m \text{ wet film})$ 

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.

## STEP 5: UNDERCOAT: U2

- 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 U2 undercoat for protection: 3.
- Sand with 120 grit between each layer to get a good adhesion, then rinse with fresh water and let dry thoroughly





### STEP 6: HARD MATRIX ANTIFOULING WITH PTFE: A9T.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.



	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: 12m2/L



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