

# BOAT PREPARATION

## TREATMENT OF LEAD KEEL

With **Acralu-PA** system



### STEP 1 : PREPARATION

- 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.

#### Acralu Drying time before overcoating :

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

### STEP 3 : IMPREGNATION

- 1) 1 thin coat of Nautix **Acralu** impregnation with brush.
- 2) 1 coat of Nautix **PA** anticorrosion primer



#### 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<sup>2</sup>/L - **PA** = 14m<sup>2</sup>/L (120µm wet film)

Apply between 0°C and 35°C.

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



	10°C	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	72 h	48 h	36 h

Mixing ratio : 1 for 1 (weight or volume)

### 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



#### 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<sup>2</sup>/L (120µm 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 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: 12m<sup>2</sup>/L



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