



APPLICATION SPECIFICATION FOR NEW CONSTRUCTION

SEA-Speed™ DTM

(Hard film fluorinated polysiloxane foul release direct-to-metal coating).

SCOPE

This specification, together with the Product Data Sheet, defines the minimum requirements for the new construction and the pre-treatment, abrasive blasting, application, and inspection of an exterior hull surface with the **SEA-Speed™ DTM** coating or the combined **HULLGUARD™ / SEA-Speed™ DTM** coating system.

STANDARDS

Steel Structures Painting Council (SSPC)

SP-10	Near White Metal Blast Cleaning
PA-1	Shop, Field and Maintenance Painting
PA-2	Measurement of Dry Paint Thickness with Magnetic or Electronic Gauges
PA-3	A Guide to Safety in Paint Application

PREPARATION

Surface Preparation for all Immersed Surfaces

1. STEEL Abrasive blast steel with an adequate abrasive in order to produce an SSPC-SP10 (near white) surface with an anchor profile of 2.0-2.5 mils
2. ALUMINUM Abrasive blast with an adequate abrasive in order to produce an anchor profile of 2.0-2.5 mils
3. NON-METALLIC Roughen surface with No.2 sandpaper to produce an anchor profile of 1.0-1.5 mils.

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Special Areas

All welded areas and appurtenances shall be given special attention for removal of welding flux in crevices. Weld splatter, slivers, surface laminations, and underlying mill scale (on steel) exposed during surface preparation cleaning shall be removed by grinding.

Blast Surface Protection

1. Steel

All steel surfaces shall be coated during the same day they are blasted and prior to sundown of that day, before any rusting occurs. If this procedure is not possible, then on any given day the steel surface shall be reblasted prior to painting.

2. Aluminum and Non-Metallic

Aluminum and non-metallic surfaces do not have to be coated the same day; however, all surfaces not coated the same day must be washed to be free of salt, dirt, oil and grease. All surfaces must be dry prior to applying **HULLGUARD™** or **SEA-Speed™ DTM**.

Prior to Coating Application

1. Surfaces

All surfaces shall be clean and dry before the application of any coating.

2. Humidity

No coating shall be applied when the temperature of the surface is within 5°F of the dew point as determined using a sling psychrometer. To apply **HULLGUARD™** or **SEA-Speed™ DTM** the substrate temperature must be above 3°C (39°F), air temperature should be a minimum of 4°C (40°F) and rising. Humidity should be lower than 90%.



COATINGS

OPTION # 1 Apply one coat **SEA-Speed™ DTM** @ 12 mils (300μ) DFT/10 mils (250μ) dry mils.

OPTION # 2

1st Coat **HULLGUARD™** @ 5 mils DFT wet (grey)
All welds shall be stripe painted by brush or spray with **HULLGUARD™**. Follow with main coat @ 8 mils WFT. Allow 12 hrs to dry at 72°F.

2nd Coat **SEA-Speed™ DTM**
Apply topcoat @ 7 mils DFT or 8 mils wet.

NOTE: for maximum adhesion between coats apply second coat within 24 hours of the first coat application

Mixing and Application of SEA-SPEED

1. Mix all coating materials with a power mixer and apply in accordance with SeaCoat TECHNOLOGY, LLC Product Data Sheets.
2. Flush all spray equipment thoroughly between products to ensure no cross contamination.
3. Spray apply first and second coat with airless equipment; for best results we recommend a 45:1 ratio airless, also, the material hose to be 1/2" O.D. and 3/8" I.D.
4. If spray equipment is not available then the use of rollers or power rollers shall be acceptable; however, an extra coat may be required.
5. After application wash all equipment with appropriate solvent.

NOTE: Plural spray equipment may utilized to spray either **HULLGUARD™** and/or **SEA-Speed™ DTM**. If **SEA-Speed™ DTM** is to be applied direct to metal during inclement weather conditions it is preferred that Plural type equipment with heated hoses be used.



INSPECTION AND SAFETY

Inspection

1. It is perceived that the vessel will be placed back into the water before the full cure of the **SEA-Speed™ DTM** occurs; hence, in order to insure that a proper dry film thickness is achieved, wet film thickness readings must be taken continuously during application.
2. All DFT measurements and their locations shall be in accordance with SSPC PA-2, paragraphs 1-5, and documented for record.
3. Vessel may be placed into the water as soon as the coating system has achieved a hardness that is not easily mechanically damaged. The coating system should be allowed to dry a minimum of 24 hours @ 77°F prior to being put in the water. 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.**

Safety

1. **HULLGUARD™/SEA-Speed™ DTM** are non-flammable and do not pose a fire hazard.
2. **HULLGUARD™/SEA-Speed™ DTM** are non-toxic; however, painters should avoid ingesting coating through the nose or mouth. Proper attire, such as adequate air masks, must be worn during application.
3. Safety precautions and procedures shall be in strict compliance with SSPC PA-3, paragraphs 1-16.