



## ***SEA-SPEED V 10 X CLEAR***

### ***Application guide for FRP/Gel-Coat hulls***

(Hard film CLEAR COAT Silane - Siloxane foul release coating).

***SEA-SPEED V 10 X CLEAR*** is designed and engineered to be applied on new hulls or hulls of vessels that have not previously been painted with epoxy barrier coats and or antifouling paint. Can be applied to pleasure craft, racing sailboats, powerboats and personal watercraft. Properly applied, the coating will be glass smooth with a surface roughness of less than 8 microns.

### **PREPARATION**

#### Surface Preparation for all Immersed gel coat / fiberglass Surfaces

1. If the craft has been in the water, remove the boat from the water and immediately high pressure water blast in order to remove fouling.
2. Mechanically remove fouling by scraping followed by high-pressure water cleaning.
3. Remove all accessories from the hull such as trim tabs. .
4. Using commercially available products the hull should be de-waxed. Follow de-waxing process with a solvent wipe down using hi flash ketone based products such as MEK (Methyl ethyl ketone).
5. Thoroughly sand surface by hand or with an orbital sander using one hundred eighty (180 grit) sanding disks. Chines and waterline are critical areas and special care should be taken to insure those areas in particular are properly prepared.

***PLEASE NOTE: Surface preparation is the key to a quality and successful finish.***

6. All surfaces must be washed to be free of dust, salt, dirt, oil and grease. Use compressed air to remove residual dust. If latent oils or grease are present, use MEK (Methyl Ethyl Ketone) or other high flash solvent to remove any contamination.

## **PREPARATION (New hulls)**

1. Using MEK (Methyl Ethyl Ketone) or de-waxing agents to clean the area to be coated to remove any residual mold release compounds remaining on the surface. Apply solvent and follow by rubbing and wiping down towards the keel. This may take several applications.
2. Remove all accessories from the hull such as trim tabs.
3. Thoroughly sand surface with one hundred eighty grit (180) sandpaper to the point where no glaze or shine is visible. Chines and waterline are critical areas and special care should be taken to insure those areas in particular are properly prepared.
4. All surfaces must be washed to be free of dust, salt, dirt, oil and grease. Use compressed air to remove residual dust. Use MEK (Methyl Ethyl Ketone).

### Safety

It is important to protect yourself and the environment while the hull preparation.

Proper clothing such as disposable paper suits, goggles, a charcoal filter mask, a balaclava cotton hood and good quality dishwashing or chemical resistant disposable gloves.

Protect the ground where you are working so that you can contain the collect residual paint dust and dispose of it according to local regulations.

Prior to applying any coating a survey of the bottom should be performed to check for cracks, leaks, blisters or grounding damage. Repair as necessary or contact a professional for an assessment and repair.

## PROCEDURE AND TIMING:

- Apply one coat of SEA-SPEED V 10 X CLEAR to the hull by airless spray.
- Apply at 5 - 6 mils (125 - 150 microns) wet film thickness.
- Allow to cure a minimum of 24 hours prior to moving the vessel or blocks.

Protect the vessel from moisture (rain) and check the weather forecast. Prior to applying any paint you should protect all areas not to be coated. Apply a good quality masking tape or "Fine Line" for the waterline / boot-top.

## Supplies

### **Electric Airless spray pump (30:1 ratio)**

**Note a handheld GRACO battery operated airless is ideal for small craft. Please note the airless sprayer should be compatible with solvents for cleaning purposes.**

Tip: A fine finish tip is best suited. Tip size should be (.208/.308). Maximum tip size is a .311  
Electric or pneumatic mixers

Clean new Polyethylene or steel mixing containers

4" solvent resistant phenolic core foam rollers (1/4" thick maximum) Roller pans

Clean up solvent (Sherwin Williams R7K15 or C 50 only)

**NOTE: Do Not use Acetone, LACQUER THINNER or Xylene.**

Disposable solvent resistant gloves.

Face protection and mask/ respirator

A wet film gauge.

## **Mixing and application of SEA-SPEED V 10 X CLEAR**

**IMPORTANT:** Substrate temperature must be above 50 ° F (10° C) and at a minimum must be 5 ° F (3 C) above the dew point.

The **SEA-SPEED V 10 X CLEAR** is supplied in 1 gallon (3.785 liter) Kits. It is a 4:1 ratio mix by volume.

### **DO NOT THIN THE MATERIAL**

- Mix the necessary amount of **SEA-SPEED V 10 X CLEAR** to coat the underwater hull area with

5-6 mils (125 - 175 Microns) wet. Coverage is as follows:

at 5 mils ( 125 microns): 305 square feet per gallon ( 7.48 sq. meters per liter)

at 6 mils ( 150 microns): 254 square feet per gallon ( 6.23 sq. meters per liter)

Account for loss when spraying.

Mix PART A & PART B together for 3-4 minutes until smooth and homogenous.

- **An Induction time of 5-8 minutes is required before applying.**
- Spray tip should be a Fine Finish .208, .308, .311 Pressure should be 750 - 900 psi to eliminate fingering.
- Check wet film thickness with a gauge to ensure proper thickness.

Once the SEA-SPEED has cured 24 hours or is sufficiently hard not to be damaged, the blocks may be moved:

Mix an appropriate amount of SEA-SPEED and apply by roller on the pad spots being sure to feather the newly applied material on to the sanded area of SEA- SPEED on the perimeter.

Vessel may be placed into the water no sooner than twenty four (24) hours after coating and as soon as the coating system has achieved a hardness that is not easily mechanically damaged. 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.**

The coated vessel may be left out of the water indefinitely. **SEA-SPEED** is inert once cured and does not contain any cuprous oxide or biocides that degrade.

### Safety

Painters should avoid ingesting coating through the nose or mouth. Proper attire, such as adequate air masks and goggles must be worn during application. Refer to product data sheets and MSDS forms for full details.

Please note that vessels coated with **SEA-SPEED** that sit idle for extended periods will foul as will conventional toxic cuprous oxide bottom paints. Hulls with **SEA-SPEED** should be maintained by regular cleaning as are conventional paints.

Cleaning the **SEA-SPEED** is the owners/operators responsibility and must be done with a **non abrasive** brush, mitt or pad only (such as a piece of carpet or plastic paint scraper) and will not harm the coating.