



**SeaCoat**  
TECHNOLOGY, LLC

## APPLICATION GUIDELINE FOR

*Company Name*

*M/V*

### **SEA-SPEED® V 10 X (100 % solids)**

(Hard film siloxane hybrid foul release coating)

## SCOPE

This specification, together with the Product Data Sheet, defines the minimum requirements for the Maintenance and the pre-treatment, minimal surface preparation, application, and inspection of an exterior underwater hull surface with **SEA-SPEED V 10 X** coating system.

## STANDARDS

Swedish and Steel Structures Painting Council (SSPC)

- SP-1 Solvent Cleaning
- SP-3 Power Tool Cleaning
- SA-2** or SP-6 Commercial Blast
- SA-3** or SP-5 White Metal
- SA-1** or SP-7 Brush Blast
- SA-2½** or SP-10 Near White Metal Blast Cleaning
- SP-11 Power Tool Cleaning to Bare Metal
- 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

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## PREPARATION

### Surface Preparation for all Immersed Surfaces

1. High pressure (3000 psi) wash the topside and freeboard for removal of any oils and salts. **(NOT REQUIRED FOR NEW BUILDING)**
2. STEEL HULL: High pressure wash (5000 psi minimum (340 bar)) the hull from the boottop to keel to remove all marine growth, loose and poorly adhered antifouling paint. **(NOT REQUIRED FOR NEW BUILDING)**
3. Allow the surface to dry adequately. **(NOT REQUIRED FOR NEW BUILDING)**
4. Abrasive or water blast the hull with an adequate abrasive in order to completely remove existing antifouling paint to existing solid and well adhered anticorrosive epoxy primer SA 1. For mechanically damaged areas where corrosion is present, the surface shall be abrasive blasted to produce a minimum SA 2.5 (SP – 10) anchor profile of 2.5 mils. **IF GRIT BLASTING IS NOT AVAILABLE A UHP WJ-2 PREPARATION IS ADEQUATE. Contact SCT Technical for consultation.**
5. Remove any residual blast contaminants from the blasted areas with compressed air.

### Special Areas

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

### Blast Surface Protection

1. **Steel:** All blasted and exposed steel surfaces shall be coated with the 1<sup>st</sup> coat of **SEAPOXY 73 / Macropoxy 646** during the same day they are blasted and coated prior to sundown of that day, before any rusting occurs.
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.

## COATING SYSTEM HULL:

### **Blasted areas:**

### **ANTI CORROSIVE PRIMER (SEAPOXY 73 / Macropoxy 646):**

**SEAPOXY 73 / Macropoxy 646** will be applied in two coats in order to facilitate coating:

The **SEAPOXY 73 / Macropoxy 646** is supplied in two alternating colors for coats 1 & 2.

- 1) Upon completion of complete antifouling paint removal and grit blasting of damaged areas to the specified profile and compressed air cleaning of the hull and acceptance by inspectors;
- 1B) Apply one coat of **SEAPOXY 73 / Macropoxy 646** color #1 at 7 mils (175 microns) wet film thickness to the bare steel on the bare steel damaged areas. This will equate to 5 mils (125 microns) DFT.

Recoat window: Min 5 Hrs. / Max. 12 months (at 25 C/ 77F) without abrasion.

- 1C) Allow the primed touch up areas to cure a minimum of 6-8 hours or overnight (at 25 C/ 77F). Follow with a complete fresh water wash down to remove residual blast contamination. Allow entire hull to dry prior to application of the full coat of Primer coat (**SEAPOXY 73/Macropoxy 646**).
- 2) On final coating day in the morning: Apply the full coat of **SEAPOXY 73 / Macropoxy 646** Color #2 at a minimum of 11 mils (275 microns) wet film thickness in order to achieve a total dry film thickness of 8 mils (200 microns) for the full coat.

For best adhesion for the **SEA-SPEED V 10 X** as applied over the **SEAPOXY 73 / Macropoxy 646**, the coat of **SEAPOXY 73 / Macropoxy 646** should be allowed to cure to "TACK FREE" firm thumbprint stage. The ideal estimated recoat window for application of SEA-SPEED V 10 X over the **SEAPOXY 73 / Macropoxy 646** is 5 - 8 hours at 77 F (25C). No more than 12 hours at 77 F (25C). Note that if recoat times are exceeded a tie coat of **SEAPOXY 73 / Macropoxy 646** may be required at 2-3 mils (50-75 microns) DFT prior to applying SEA-SPEED V 10 X.



## **TOPCOAT (*SEA-SPEED V 10 X*):**

Apply one coat of ***SEA-SPEED V 10 X*** @ 9 mils (225 $\mu$ ) minimum wet film thickness up to 10 mils (250 microns) wet film thickness.

Apply the SEA-SPEED 12" – 18" from the surface at right angles to the surface. Applicator shall cross hatch while applying to achieve the following wet film thicknesses. Special precautions shall be taken to prevent runs or sags.

### **Mixing and Application of *SEAPOXY 73/Macropoxy 646* and *SEA-SPEED™ V 10 X***

Mix all coating materials in accordance with SeaCoat Technology, LLC or Sherwin Williams Company Product Data Sheets and application instructions.

#### ***SEAPOXY 73/ Macropoxy 646:***

1. **These products** are supplied in a two component package (1 part resin/1 part cure). Mix each component separately ensure a homogenous mixture. Add cure to resin and mix with an explosion proof mixer. Mix thoroughly.
2. Allow 8 minutes induction time prior to commencing application.

#### **3. Airless Spray Equipment:**

Use a minimum 30:1 ratio or higher Graco air driven fluid pump; Line: ½" (12.7mm i.d.); Tips: 0.017" – 0.023" orifice reverse-clean tips or equal. Fluid pressure should be 2,800 – 3,000 psi or as needed to eliminate "fingering."

#### ***SEA-SPEED V 10 X (100 % solids):***

1. SEA-SPEED is provided in five gallon Kits or two gallon kits. It is supplied as 1:1 mixture by volume. Black 5 gal (20 liter) pails contain 2.5 gallons (9.4625 liters) of PART A (activator) color code (Customer choice). Small Grey or Black pails contain 2.5 gallons of (9.4625 liters) PART B (resin). Premix PART B separately and then add to PART A. Mix thoroughly with a power mixer until color is fully homogeneous. Induction time is required 20-30 min) if thinner is added to the mixed kit.

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2. Flush all spray equipment thoroughly between products with Sherwin Williams R7K15 epoxy thinner / clean up solvent to ensure no cross contamination.
3. **Airless Spray Equipment:**  
Apply with airless equipment; for best results, a 74:1 ratio Graco air driven fluid pump or equivalent shall be used. Hose shall be ½" (12.7mm) i.d. Spray tip shall be 0.019 – 0.023
4. Draft marks and markings: white SEA-SPEED has been provided. Mix appropriate quantities on a 1:1 or 4:1 by volume ratio as per the label. Draft and other markings may be applied via brush. Apply hull markings on to final coat of SEA-SPEED as soon as it is Tack free. Normally 6-8 hours after application.

***Do not thin material unless approved in writing by Seacoat representative. Only Sherwin Williams R7K15, C 50, Ameron T-10 or International 220 may be used.***

***DO NOT USE XYLENE, ACETONE or LACQUER THINNER***

## INSPECTION AND SAFETY

### Inspection

1. 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 by yard QC personnel.  
Substrate temperature must be above 50° F (10° C) and at a minimum must be 5° F (3° C) above the Dew Point.
3. Vessel may be placed into the water in twenty four hours or as soon as the coating system has achieved a hardness that is not easily mechanically damaged.
4. ***For each 10° F under 77° F (6.25° C under 25° C) add 6 hrs to re-float time.***

### Safety

Proper attire, such as air masks and goggles must be worn during application. Avoid ingesting coating through the nose or mouth. Refer to MSDS sheets for industrial safety and hygiene procedures. Safety precautions and procedures shall be in strict compliance with SSPC PA-3 paragraphs 1-16