



APPLICATION GUIDELINE FOR

Company Name

M/V

SEA-SPEED® V 10 X ULTRA CLEAR (95 % solids)

(Hard film Silane - siloxane hybrid Non-Toxic foul release coating)

SCOPE

This specification, together with the Product Data Sheet, defines the minimum requirements for the Maintenance and the pre-treatment, abrasive blasting, application, and inspection of an exterior underwater hull surface with a **SEA-SPEED V 10 X ULTRA CLEAR** coating combined **SEAPOXY 73** 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 blast the necessary areas of the hull up to with an adequate abrasive in order to produce a minimum SA 2 ½ 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 steel surfaces shall be coated with the 1st coat of **SEAPOXY 73** 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**):**

SEAPOXY 73 will be applied in two coats in order to facilitate coating:

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

- 1) Upon completion of grit blasting to the specified profile and compressed air cleaning of the hull and acceptance by inspectors; Apply one coat of **SEAPOXY 73** color #1 at 7 mils (175 microns) wet film thickness as a holding primer. This will equate to 5 mils (125 microns) DFT. Once the entire underwater hull has been blasted and the holding primer applied per the following time schedule:

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

- 1B) Allow the last portion of applied primer to cure 8 hours. Follow with a complete fresh water wash down to remove residual blast contamination. Allow entire hull to dry prior to application of primer coat #2.
- 2) On final coating day in the morning: Apply the second coat of **SEAPOXY 73** Color #2 at 7 mils (175 microns) wet film thickness in order to achieve a total dry film thickness of 10 mils (250 microns) combined for the two coats.

For best adhesion for the **SEA-SPEED V 10 X ULTRA CLEAR** as applied over the **SEAPOXY 73**, the second coat of **SEAPOXY 73** should be allowed to cure to "TACK FREE" firm thumbprint stage. The ideal estimated recoat window for application of SEA-SPEED V 10 X ULTRA CLEAR over the **SEAPOXY 73** / is 4 - 8 hours at 77 F (25C). Note that if recoat times are exceeded a tie coat of **SEAPOXY 73** may be required at 2-3 mils (50-75 microns) DFT prior to applying SEA-SPEED V 10 X ULTRA CLEAR.

TOPCOAT (SEA-SPEED V 10 X ULTRA CLEAR):

Apply one coat of **SEA-SPEED V 10 X ULTRA CLEAR** @ 6 mils (150µ) 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.

NEW BUILDING (only):

Once blocks are painted and assembled, joint areas can be painted as Follows:

Junctions, burned areas, block areas to be grit blasted to SA 2.5

- 1) The new SEA-SPEED surrounding the junctions, burned areas and blocks to be sanded using 80 grit to a distance of 1.5 feet (30 Centimeters) to the point where it is dull.
- 2) The sanded areas shall be blown off using dry oil free compressed air.
- 3) The Sanded SEA-SPEED areas shall be wiped down with either MEK (Methyl Ethyl Ketone) or Isopropyl Alcohol (Rubbing Alcohol).
- 4) Apply the AC primer (**SEAPOXY 73**) as per above to the bare steel only. Do not apply primer over surrounding SEA-SPEED.
- 5) Once the AC primer is sufficiently cured a coat of SEA-SPEED may be applied by spray according to the specified interval.

NOTE: Detailed instructions and graphics can be supplied for Joint areas.

Mixing and Application of **SEAPOXY 73 and **SEA-SPEED™ V 10 X ULTRA CLEAR****

Mix all coating materials in accordance with SeaCoat SCT, LLC Product Data Sheets and application instructions.

SEAPOXY 73:

1. **This product** is supplied in a two component package (1part 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.

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3. **Airless Spray Equipment:**

Use a minimum 45:1 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 3200 – 3,500psi or as needed to eliminate "fingering".

SEA-SPEED V 10 X ULTRA CLEAR (95 % solids):

1. SEA-SPEED is provided in five gallon Kits or one gallon kits. It is supplied as a 1A (Activator): 4B (Base) mixture by volume. Premix PART B separately and then add PART A into Part B. Mix thoroughly with a power mixer until homogeneous (2-3 min) for twenty liter can. Induction time is required (5 – 8 min). DO NOT USE ANY THINNER

2. Flush all spray equipment thoroughly between products with Sherwin Williams R7K15 or C 50, Ameron T – 10, Jotun no. 17, or International 220 epoxy thinner clean up solvent to ensure no cross contamination.

3. **Airless Spray Equipment:**

Apply with airless equipment; for best results, a 33:1 ratio Graco air driven fluid pump or equivalent shall be used. Hose shall be ½" (12.7mm) i.d. Spray tip shall be Graco Fine Finish Low Pressure type (FFLP) in size .510

4. Draft marks and markings: white SEA-SPEED V 10 X ULTRA has been provided. Mix appropriate quantities on a 1:4 by volume ratio depending on the label. Draft and other markings may be applied via brush. Apply hull markings on to final coat of SEA-SPEED V 10 X ULTRA CLEAR as soon as it is tacky (Generally 2 hours).

Do not thin material unless approved by Seacoat representative.

*****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 40° F (5° C) and at a minimum must be 5° F (3° C) above the Dew Point and rising.
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