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Detailed steps for applying Metal Primer and VELOX PLUS:

1.1 Remove all existing antifouling or other coating using 80 grit sandpaper, manually or with careful use of a dual action rotary sander (we suggest using a soft pad in order not to damage the propeller). Do not remove old VELOX PLUS from previous season (see recommendations, point 3.2). Do not remove factory finish from aluminum stern drives.

1.2 Wash and degrease carefully all metallic surfaces with our Solvent 102 Anti-silicone (or MIBK or a good and fast degreasing solvent like pure Acetone) and a clean rag. Change rag frequently, especially in case of new or folding propellers, which usually have more grease on them.

1.3 Sand thoroughly all metallic surfaces with dry 80 grit sandpaper, renewing it often. A dual action rotary sander can be used. Do not use wet sandpaper. Do not use coarser than 80 grit, nor finer, nor worn out sandpaper. Do not use scotch brite. We do not recommend sandblasting unless done by an experienced professional.

1.4 Brush all surfaces with a dry and clean cloth. Do not touch the surfaces with bare hands, that may leave traces of grease or dirt. If the surface gets contaminated again with some grease or dirt, use only MARLIN (SOLVENTE 102 or pure acetone to clean it. Absolutely do not wash the sanded surface with any other solvent than the ones recommended, water, soap or detergents, acid.

NOTE: We suggest protecting bare aluminum with an appropriate epoxy coating (after careful surface preparation as explained above). This is not necessary when aluminum is already protected with a factory finish (like new stern drives). On epoxy cycles or factory finish, just lightly sand the surface with abrasive pad (like Scotch Brite) or fine sandpaper (n. 180-220) before applying METAL PRIMER.

APPLICATION

2.1 Apply one coat of METAL PRIMER (maximum wet film thickness 100 μ , dry film thickness 30 μ). We suggest application with a small/medium brush. Let it dry for at least 3 hours at 68° F (20° C). A light coat is enough. Applying thicker coats than recommended may result in worse adhesion.

2.2 Apply one coat of VELOX PLUS by brush (wet film thickness 100 μ , dry film thickness 30 μ). Apply it with continuous long brush strokes. Avoid going back and forth on the same spot, as this will soften too much of the METAL PRIMER. As pictured below, full coverage will not be achieved with first coat of VELOX PLUS. The first coat will normally slightly soften the primer, showing some of its green color.

2.3 Wait at least 3 hours at 68° F (20° C) then apply a second coat of VELOX PLUS (wet film thickness 100 μ , dry film thickness 30 μ). For best result, apply it by brush with long and continuous strokes, perpendicular to the brush strokes of the first coat. A third coat of VELOX PLUS may be applied to obtain perfect coverage or in areas where fouling growth is particularly aggressive.

2.4. Wait at least 12 hours at 68° F (20° C) before launching.

RECOMMENDATIONS

3.1 Prepare the surface carefully; at the time of applying METAL PRIMER all metallic surfaces should be very rough and clean (free from grease, dust, fingerprints, sweat, water, soaps or any kind of dirt contaminating agent).

3.2 On top of VELOX PLUS from previous season, another two coats of VELOX PLUS can be applied directly as explained above in Points 2.2 and 2.3 after cleaning and lightly sanding the surface with fine sandpaper or abrasive pad (like Scotch Brite). We suggest removing all the antifouling paint in any case at least every three years. Do not apply METAL PRIMER or VELOX PLUS on any other antifouling.

3.3 Do not apply VELOX PLUS in bare metal.

3.4 For spraying both VELOX PLUS and METAL PRIMER, it is not necessary to dilute the product.

3.5 Stir very thoroughly both METAL PRIMER and VELOX PLUS before application as both contain heavy particles that may settle. Scrape the bottom of the can and stir until the paint becomes homogeneous.

3.6 Brush out immediately any sag or dip that may form when applying METAL PRIMER or VELOX PLUS, check carefully the edge of the blades for dips after the application of every coat.

3.7 Read carefully the instructions on the label and always wear suitable protective clothing, goggles, mask, gloves, as prescribed.

TECHNICAL SPECIFICATIONS

Colors: White, black

Specific Gravity: 1.20 - 1.30

Application: Brush, Spray Gun

Thinner: Not Necessary

Drying Time:

Touch Dry: 1 hour at 68° F

For Recoating: 3 hours at 68° F

For Launching: 12 hours at 68° F

