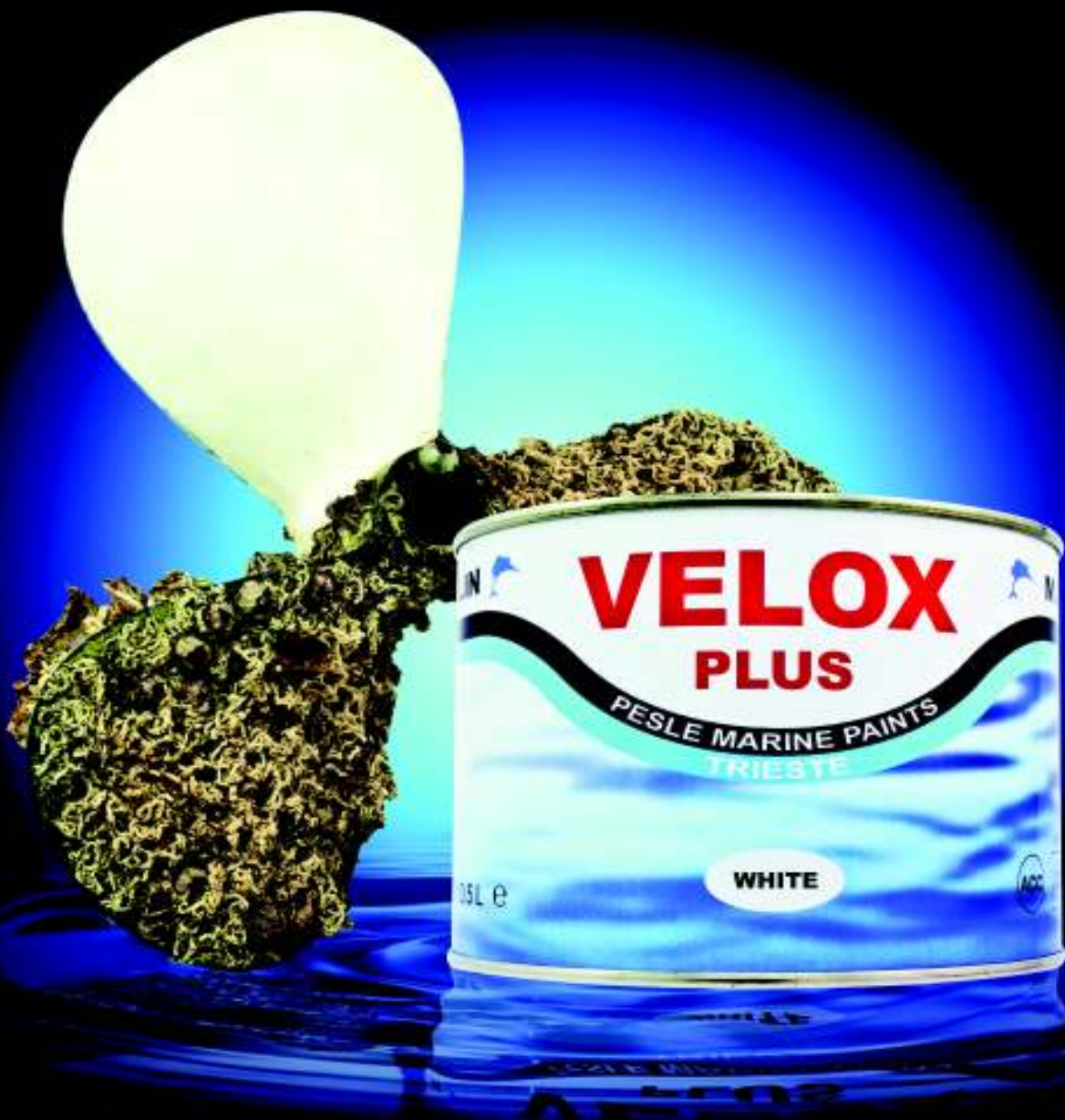


MARLIN Yacht Paints



PESLE MARINE PAINTS
TRIESTE



www.marlinpaint.com

VELOX PLUS

Antifouling for propellers

VELOX PLUS is an antifouling paint suitable for protection of propellers, stern drives, shafts, trim tabs and other metallic parts permanently immersed. It provide excelent adhesion and antifouling properties.

APPLICATION

Before you start, make sure you have all the necessary tools, paints and solvents:

- | | |
|---|--------------------|
| 1. METAL PRIMER | 4. Stirring paddle |
| 2. VELOX PLUS | 5. Sandpaper n. 80 |
| 3. SOLVENTE 102
(or MIBK - Methylisobutylketone) | 6. Clean rags |
| | 7. Brushes |



1. SURFACE PREPARATION

Surface preparation can be divided into four steps:

- 1.1 Remove old antifoulings or other coatings (jump to 1.2 in case of new propellers/stern drives).
- 1.2 Clean and degrease all bare metallic surfaces.
- 1.3 Roughen well the clean metallic surfaces.
- 1.4 Remove dust and carefully clean the surfaces (from the residue of roughening).

1.1 Remove all existing antifouling or other coating using sandpaper n. 80, manually or with careful use of a dual action rotary sander (we suggest using a soft pad in order not to damage the propeller). A paint stripper for antifoulings can also be used, very carefully. Do not remove old VELOX PLUS from previous season, if well attached (see recommendations). Do not remove factory finish from aluminium stern drives.



1.2 Wash and degrease carefully all metallic surfaces with our SOLVENT 102 ANTISILICONE (or MIBK or a good degreasing solvent) 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 sandpaper n. 80, renewing it often. A dual action rotary sander can be used. Do not use wet sandpaper. The surface must be rather rough after sanding. 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 for some reason the surface has been touched with bare hands or it has some grease or dirt on it, use only MARLIN SOLVENTE 102 or MIBK - (Methylisobutylketone) to clean it. Absolutely do not wash the sanded surface with water, soap, acid or solvent.



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



2. APPLICATION

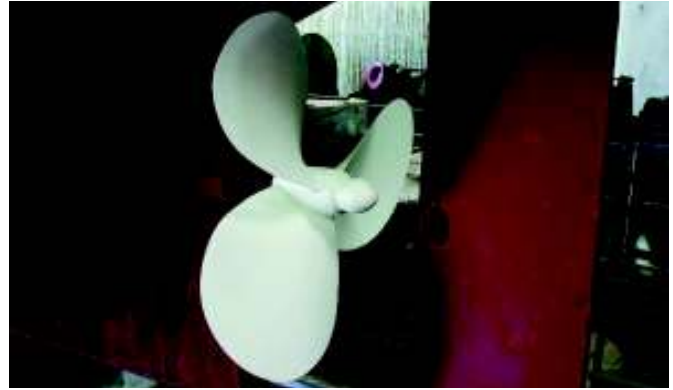
2.1 Apply one coat of METAL PRIMER (maximum wet film thickness 100 μ , dry film thickness 30 μ). We suggest application with a small/medium brush. Leave it dry for at least 3 hours at 68° F (20° C). A light coat is enough, applying coat that are thicker than recommended may result in worse adhesion.



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 the METAL PRIMER too much. 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.



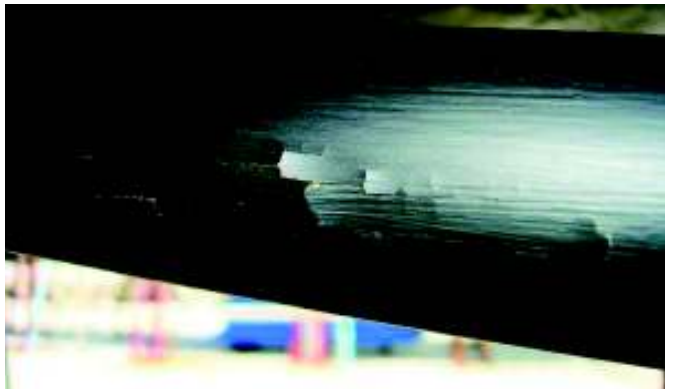
2.3 Wait at least 3 hours at 68° F (20 ° C) then apply a second coat of VELOX PLUS (wet film thickness 100 µ, dry film thickness 30 µ). For best result, apply it by brush with long and continuous strokes, perpendicular to the brushe strokes of the first coat. A third coat of VELOX PLUS may be applied 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.

3. 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, water, solvents or any other kind of dirt - even fingerprints or sweat). Below there are two pictures showing paint detachment caused by surface not well prepared.



3.2 For spraying both VELOX PLUS and METAL PRIMER, it is not necessary to dilute the product, we suggest using it as it is.

3.3 Do not apply METAL PRIMER or VELOX PLUS on any other antifouling. On the top of VELOX PLUS from previous season, another two coats of VELOX PLUS can be applied directly as explained above in points 5 to 7. We suggest removing all the antifouling paint in any case at least every three years.

3.4 Do not apply METAL PRIMER and VELOX PLUS on zinc anodes.

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

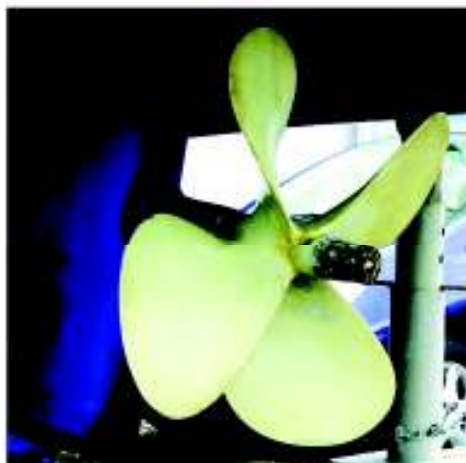
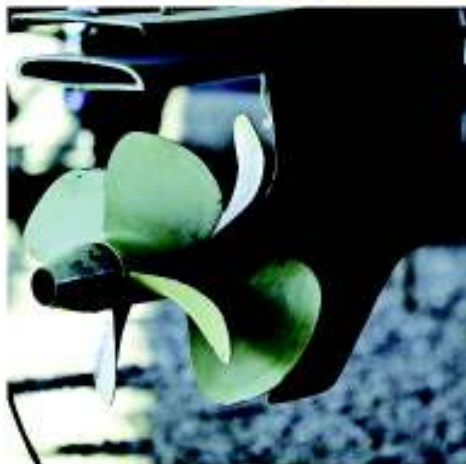
3.6 Brush out immediately any sag or dip that may form when applying METAL PRIMER or VELOX PLUS, check carefully the edge of the blades for dips after the application of every coat.

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

4. TECHNICAL SPECIFICATIONS

Colours	White, black, grey	Drying time	
Specific gravity	1.20 - 1.30	<i>touch dry</i>	1 hours at 20°C
Application	brush, spray gun	<i>for recoating</i>	3 hours at 20°C
Thinner	not necessary	<i>for launching</i>	12 hours at 20° C

The following pictures show some propellers treated with VELOX PLUS after one year service.



ZF Marine, LLC
U.S. Corporate Headquarters
15351 SW 29th Street
Miramar, FL 33027
Phone: +1 954 441 4040
Fax: +1 954 447 4141
www.zfmarinepropellers.com

ZF Marine, the exclusive
US distributor of



Driveline and Chassis Technology