MARINE PAINTS

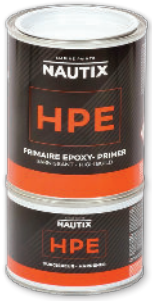
NAUTIX

TECHNICAL DATA SHEET

HPE

High-build epoxy primer

The above colours are not applications of our paints and are given for information only.



SUBSTRATE

Polyester | GRP | Aluminium | Epoxy | Steel | Plywood

OK
OK

7-8m²/L

DESCRIPTION

HPE is a two-component epoxy primer with high filling power combining adhesion and protection characteristics for polyester or metal substrates. Between 3 and 5 coats it offers very high protection against humidity. The primers fulfill an essential role of attachment or protection by hardness effect or barrier effect.
Its unique filling formula (200µm in one coat) promotes the protection and shaping of surfaces. Easy to apply and sand, this primer is particularly suitable for the marine environment.

MAIN FEATURES

COVERAGE	**7-8m²/L per layer** (see «application» section for details)
DRY EXTRACT	**48 (% volume) | 72 (% weight)**
VOLUME RATIO	**3 base | 1 hardener**
WEIGHT RATIO	**85g base | 15g hardener**
FLASH POINT	**23°C < FP <55°C**
UNIT SIZE	**0.75L - 2.5L - 5L - 20L**
TYPICAL SHELF LIFE	**5 years**
THINNER / CLEANER	**DE**
COLORS	**White, Grey**
FINISH	**Satin**

DRYING AND OVERCOATING

TEMPERATURE	10°C	15°C	20°C	30°C
Life pot	12h	10h	8h	4h
Overcoating	4h-24h	6h-24h	5h-24h	3h-16h
Sandable	24h	20h	16h	8h
Immersion	48h mini	48h mini	48h mini	48h mini

h=hours min=minutes

SURFACE PREPARATION

ON A NEW POLYESTER OR EPOXY HULL
- Degrease with Nautix SD.
- Polish the surface with P120 to promote adhesion.
- Make sure the substrate is dry and dust-free.

ON EXISTING ANTIFOULING OR PRIMER
- Remove existing antifouling:
  - 1 to 3 coats: Nautix Stripper
  - More than 4 coats: sanding, scrubbing or scraping
- Check the condition of the primer: to be covered, paint must not come off the substrate or crumble. Scratch with a brush in various places to test the adhesion of the substrate. Remove any non-adherent coatings.
- Check the residual humidity of the hull. Do not apply if the differential between above and below the waterline is greater than 5%.
- Degrease and roughen the surface with P120 to promote adhesion.
- Make sure the substrate is clean, dry and dust-free.

SPECIAL ADVICE

Respect the overcoating windows.
Overcoating too quickly locks the solvents in at the layer interface. If the window is exceeded, the surface is chemically too closed to allow adhesion.

COMPATIBILITY

Important :
A two-component (hard) epoxy primer cannot be applied over a single-component (soft) primer.

Check the moisture content of the hull with a moisture meter before applying epoxy paint.

If you have any doubts about the compatibility or quality of the existing primer or antifouling, remove the existing paint completely.

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HINTS

• Application methods: brush, roller, spray gun
•Apply between 10 and 30°C (ideally indoors with humidity below 85%).
•Do not paint a surface if there is the slightest risk of condensation forming on the surface (dew point): The temperatures of the ambient air, the substrate and the product must be very close.
•Avoid application in adverse weather conditions: strong wind, direct sunlight, high/low temperatures, high humidity or rain.
•Mix the base thoroughly before adding the hardener. Mix only as much as you need.
•Allow the mixture to stand for 10 minutes before application.
•Correct the profile with an Epoxy filler between the first 2 coats of primer.
•Apply 5 coats of primer. Apply several thin coats to increase the effectiveness of the protection. Recoat within the recommended time or roughen with P120 once dry.

APPLICATION

BRUSH/ROLLER
• Cross strokes when applying.
• Dilute Nautix DE from 0 to 10% max.
•Use a roller with a textured polyamide sleeve such as the Nautix 10cm sleeve.

AIRMIX SPRAY
• 2.0 to 2.5 bar, nozzle 2.0mm to 2.2mm.
• Nautix DE dilution from 10 to 15% max.

AIRLESS SPRAY
• 170 to 240 bar, nozzle 419 to 525.
• Dilute Nautix DE from 0 to 10% max.
• Double the drying time.

For thicker applications (250µ wet), increase coverage and drying times by 50%.

ROLLER INFO

Number of coats: 3- 5
Theoretical coverage per coat: 7-8m²/L
Recommended WFT* per coat: 120-150µm
Recommended final DFT**: 300µm

AIRMIX INFO

Number of coats: 3- 5
Theoretical coverage per coat: 6m²/L
Recommended WFT* per coat: 120µm
Recommended final DFT**: 300µm

AIRLESS INFO

Number of coats: 2 minimum
Theoretical coverage per coat: 3.5m²/L
Recommended WFT* per coat: 250µm
Recommended final DFT**: 300µm

**WFT : Wet Film Thickness / **DFT : Dry Film Thickness*

INFORMATIONS

OPERATOR PROTECTION
• Paint for amateur and professional use.
• Before use, read this sheet, the label and the product information carefully.
• Work in a well-ventilated area, wear protective clothing, gloves, goggles and a suitable mask.

TRANSPORT AND STORAGE
•The product must be transported and stored in hermetically sealed containers that are not permeable to solvents.
• Do not expose to the open air, sunlight or extreme temperatures. To keep the product in good condition, recap the can after use, turn the jars upside down and store between 10°C and 25°C. Do not expose to sunlight.

SAFETY
• Read the label and product information before use. Observe the precautions for use. Carefully read the safety advice given in the Health and Safety section, which is also available from Nautix and its retailers.
• All professional operators must wear appropriate protective clothing: coveralls in a colour that contrasts with the product being applied, disposable hooded under-suits, appropriate gloves and protective footwear that protects the lower limbs. Wear a respirator when spraying.

WASTE
• Empty cans and soiled waste must be disposed of in accordance with current municipal regulations on the treatment of hazardous products, for example by taking them to a waste collection centre or using dedicated bins. Do not dispose of waste in drains or waterways. Use the bins provided. It is advisable to allow paint residues to harden before disposing of them.

GENERAL
• The information given in this data sheet is not exhaustive. Anyone using this product for purposes other than those recommended, without prior written confirmation from us as to the feasibility of such use, does so at their own risk. Nautix cannot be held responsible. This information is subject to change without notice.

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