

Durepox Competition Yacht System Flow Chart Guide



Before You Start

Plan a paint meeting including all stakeholders from faring, paint process & signage. Clearly understand what is expected of the entire paint scheme before work is started. How many colours, in what order are they to be applied to the surface, where is any lettering being placed. Check all tools, equipment, spraying equipment are functioning correctly. That ALL spraying equipment is clean and has correct Air cap Fluid tip and needle combinations fitted for either primer fillers through to top coats.

Understand from the outset what is expected, is the final finish to be clearcoated for example. START WITH THE END IN MIND and backwards plan what is to be completed on what given day.

If carrying out large repaint work in a non controlled environment Do not apply paint if relative humidity is above 85% or temperature is within 3 deg C of Dew Point being the MPT or Minimum Paint Temperature.

Primer Filler Sanding & Faring Preparation Primer Surfacer Substrate Remove all initial mould release agents. Degrease with RAPC 1. Apply 2 High Build coats 1. After full cure apply an 1. Apply 2 wet even coats Wax & Grease Remover. C Power is also very good for water of Durepox Grey by roller even all over guide coat. 25—30 microns only. borne contaminants with its citrus base. Hot water & detergent and or airless spray, de-2. Long or short board to 2. Suggest 4:1:2 as a mix desired shape with P80 ratio guide. pressure wash also works very well. pending on equipment a 2. Grit Blast with Garnett Grade C to 30 micron profile. DO NOT start point mix ratio of grit or coarser finishing 3. Suggested gun set up **Carbon Fibre** 4:1:1 or less thinner if with P180 grit. 1.4mm Gravity or pres-3. Long or short board to desired shape with P80 grit or coarser 3. Apply fillers if needed for required. sure pot. **Large Surface Area** 2. Identify small pinholes finishing with P150 grit. pinholes and low points. 4. Allow 24hr cure at temp 4. Fill visible fine pin holes and any low points with desired filling and squeegee or brush 4. Air blow and clean down above 20 deg C 5. Using higher temperafaring compound. over as seen. always wearing gloves Male or Female 5. Long or short board to desired shape with P80 grit or coarser 3. Allow 24hr cure at temp and clean lint free cloths tures for thermal curing finishing with P150 grit above 20 deg C. will shorten cure times. using the wipe on wipe Mould 4. Using higher temperaoff method changing Air blow and clean down always wearing gloves and clean lint tures for thermal curing cloths frequently. free cloths using the wipe on wipe off method changing cloths will shorten cure times. frequently. **Final Sand Colour Coats Deck & Cock Pit Area** 1. Final sand by hand or machine to remove guide coat finishing 1. Mask by hand or spray mask starting with the smallest surface 1. Follow step 1 & 2 of prep process. 2. Apply Durepox with Deck Grip in appropriately masked out arwith P400 grit. area colour first. 2. Inspect for sand throughs or pin holes. 2. Allow 24hr cure at temp above 20 deg C. eas with large 2.5 to 3mm gun set up. 3. Fill any missed pin holes and spot prime any rub throughs. 3. Using higher temperatures for thermal curing will shorten cure 3. Mask out any other colours and apply Durepox as per agreed 4. Air blow and clean down always wearing gloves and clean lint paint and colour scheme. free cloths using the wipe on wipe off method changing cloths 4. Apply all other colours in agreed sequence. 5. Pay particular attention to accurate masking and edge to edge Point to note: By adding 10% By Volume of Durepox High 5. Apply IPA / DI Water mixed 80% IPA & 20% DI water. Performance Clear to Durepox colours will greatly enhance clean 6. Final sand for racing finish or alternatively apply Durepox High 6. Air blow and clean down always wearing gloves and clean lint ability and visual appearance. Keels, Appendages, Masts etc follow free cloths using the wipe on wipe off method changing cloths Performance Clear to the over all surface area. prep method depending on degree finish required. frequently. **Lead Bulbs:** Clean / Sand / Clean / use a high build epoxy primer / over night cure / sand with P150 followed by Durepox.

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