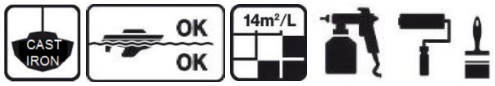
# IA

*Pore-plugged impregnation for cast iron*



*The printing process may render some of the colour samples imperfectly. We recommend testing the paint before committing to a colour.*

## PRODUCT DESCRIPTION

Nautix IA is a high performance pore-plugged impregnation primer, formulated with a Desmodur™ resin which hardens by reacting with air moisture. Nautix IA must be applied in 1 thin layer on metal substrate before PA application.

This product is very easy to use and allows application in uncontrolled environment (outdoors). Moreover, it can be applied from 0°C, dries quickly and should not be sanded before PA application.

This product is recommended for professional use only.

## PRODUCT INFORMATION

| | |
|---|---|
| Finish | Matt |
| Coverage | 14m²/L per layer (roller/brush) |
| Flash point | 23°C <FP<55°C |
| Unit size | 0.35L - 0.75L – 3L |
| Typical shelf life | 2 years |
| Thinner/Cleaner | Nautix DP |
| Colour | Light grey |

**Drying / Overcoating Information**

| Temperature | 10°C | 15°C | 20°C | 25°C | 30°C |
|---|---|---|---|---|---|
| Touch dry | 3h | 2h | 1h30 | 1h | 30min |
| Overcoated by primer* | 6h | 5h | 3h | 2h | 1h |
| Sand after | 6h | 5h | 3h | 2h | 1h |
| Dry | 96h | 72h | 30h | 24h | 20h |

d=days h=hours min=minutes

*Minimum overcoating time recommended for 1 layer (70µm wet thickness) – Please refer to *Application*

## TYPE OF SURFACES

- Cast iron
- Steel

## SURFACE PREPARATION

**Over new metal substrate**

- The surface should be degreased with Nautix SD and free of all contaminants (oil, grease, salt etc).
- Rough sand with P40 grade paper to improve adhesion of primer.
- If necessary, remove any trace of oxidation with needle scaler, rotary wire brushes, grinding disc or sandblasting (finish SA1 minimum).
- Apply asap 1 thin layer of Nautix IA.
- Ensure the substrate to be dried, degreased, and free of dust before PA application.

**Maintenance**

- Remove all non-adherent coating.
- Remove oxidation with sandblasting (SA1 minimum), grind or sand with 40 grit and then apply quickly 1 thin layer of Nautix IA.
- Then follow instructions "*over new metal substrate*".

**Technical recommendation**

Moisture content of substrate should be checked before any paint application.

Bite the keel to remove coke plugs.

After sanding or sandblasting of a metal surface, IA impregnation should be applied quickly.

**Compatibility**

Nautix IA could be overcoated by 1-pack or 2-pack primer.

In case of doubt on primer compatibility or quality, remove all the former primer or contact your sales representative.

## SAFETY INFORMATION

- Work in well-ventilated area (ensure adequate ventilation during use), wear suitable protective clothing, gloves, glasses and eye/face protection. Unprotected person must be kept away from treatment area. Dispose of protective gloves and equipment after use.
- Read the label safety section for Health and Safety Information before application.
- This primer contains isocyanates.

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# IA

*Pore-plugged impregnation for cast iron and steel*

## HINTS

- Application methods : brush, roller. Spray application only for professionals.
- If substrate is damaged, we recommend to use a brush.
- Recommended to apply between 5 and 30°C, but can be applied from 0°C.
- Do not apply when there is a chance of condensation forming on the substrate (Dew-Point) : substrate, ambient air and product temperatures must be close.
- Homogenize the product with a blender.
- It's not necessary to sand after IA application.
- Use only the required quantity for application, and then close firmly the tin immediately. An opened can must be used asap.
- If filling is required, use appropriate filler after the first coat of PA primer (not immediately after IA).
- Apply one thin layer of Nautix IA.
- Favour natural solvent evaporation and do not heat ambient air after beginning of application. Do not use ventilator or heater directed on the surface.

## APPLICATION

**Roller / brush (professional use only)**

- Apply the product by crossing roller layers.
- Thinning (volume) : Nautix DP from 5 to 10% max.

  *To get the best results, use a solvent-resistant mohair type roller. Do not hesitate to change refill when worn.*

Theoretical coverage : 14m²/L per layer.
Thickness film : around wet 70µm per layer.

**Airmix spray (professional use only)**

- 2.0 to 2.5 bars, nozzle 2mm to 2.2mm.
- Thinning (volume) : Nautix DP from 10 to 20%.

Theoretical coverage : 10m²/L per layer.

## TRANSPORT, STORAGE, AND SAFETY INFORMATION

**Transport and storage**

- This product should be kept in securely closed containers during transport and storage.
- Exposure to air, sun, and extreme temperatures should be avoided. For the full shelf-life of the paint, be sure that the container is firmly closed between use and the storage temperature is between 10° and 25°C. Keep out of direct sunlight.

**Safety**

- Before use, read the label safety section for Health and Safety Information. For further details, please contact Nautix or its distributors.
- All professional operators must wear suitable protective clothing : coveralls of a contrasting colour to the product being applied, underneath a disposable coverall with hood, suitable gloves and impervious footwear that protects the lower leg. Wear suitable respiratory equipment (such as air fed respiratory protective equipment with combined protective helmet and visor) when spraying.

**Disposal**

Disposal of remainders must be arranged for in consultation with the authorities. Do not discard tins or pour paint into water courses, use the facilities provided. It is best to allow paints to harden before disposal. Remainders of this product cannot be disposed of through the municipal waste route or dumped without permit.

**General**

The information given in this sheet is not intended to be exhaustive. Any person using the product without first making further written enquiries as to the suitability of the product for the intended purpose does so at their own risk. Nautix can accept no responsibility for the performance of the product or for any loss or damage. The information contained in this sheet is liable to modification from time to time.

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