

# PA

1-pack high performance anticorrosion primer for metals



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



## PRODUCT DESCRIPTION

Nautix PA is a high performance anticorrosion primer, formulated with a Desmodur™ resin which hardens by reacting with air moisture. Applied in 5 layers, PA prevents corrosion on metal areas of the boat.

Nautix PA can be overcoated by antifouling under the waterline or by finishing system (undercoat + enamel) above the waterline. 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 between layers.

This product is recommended for professional use only.

## PRODUCT INFORMATION

Finish	Matt
Coverage	12m²/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	red

### Drying / Overcoating Information

Temperature	10°C	15°C	20°C	25°C	30°C
Touch dry	3h	2h	1h30	1h	30min
Overcoated by itself*	6h	5h	3h	2h	1h
Overcoated by antifouling*	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

- Aluminium
- Steel

## SURFACE PREPARATION

### Over bare 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 adhesion primer :
  - Nautix IA impregnation for cast iron (eventually steel).
  - Nautix Acralu primer for aluminium, lead, and galvanized surfaces.
- 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 adhesion primer (Nautix IA or Acralu).
- Then follow instructions "over new metal substrate".

### Technical recommendation

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

Bite the keel to remove coke plugs.

After sanding or sandblasting of a metal surface, an isolated primer (IA for cast iron and steel, ACRALU for aluminium, lead, galvanized substrates) should be applied quickly.

### Compatibility

Nautix PA 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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Before Printing, think about environment ! 06/10/2016



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### HINTS

- Application methods : brush, roller. Spray application only for professionals.
- 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 between coats.
- 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 primer has been applied.
- Application :
  - Adhesion for antifouling : Apply 1 coat of primer.
  - Protection : Apply 4-5 coats of primer.
- 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 : 12m<sup>2</sup>/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 : 6 to 8m<sup>2</sup>/L per layer.  
Thickness film : around wet 80-100µm per layer.

#### Airless spray (professional use only)

- 170 to 240 bars, Nozzle 419 to 525.
- Do not use thinner.
- Double the overcoating times.

Theoretical coverage : 3 to 4m<sup>2</sup>/L per layer.  
Thickness film : around wet 200µm 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.

