

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 sanded?, is the 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.

Substrate	Preparatio	on	Primer Filler	Sanding & Faring	Primer Surfacer
Carbon Fibre Large Surface Area Male or Female Mould	 Remove all initial mould release agents. D & Grease Remover. C Power is also very g contaminants with its citrus base. Hot wat wash also works very well. Grit Blast with Garnett Grade C to 30 micu grit. Long or short board to desired shape with with P150 grit. Fill visible fine pin holes and any low poin compound. Long or short board to desired shape with with P150 grit Air blow and clean down always wearing g free cloths using the wipe on wipe off met frequently. 	good for water borne ter & detergent pressure ron profile. DO NOT recycle h P80 grit or coarser finishing nts with desired filling faring h P80 grit or coarser finishing gloves and clean lint	 Apply 2 High Build coats of Durepox Grey by roller and or airless spray, depending on equipment a start point mix ratio of 4.1.1 or less thinner if required. Identify small pinholes and squeegee or brush over as seen. Allow 24hr cure at temp above 20 deg C. Using higher temperatures for thermal curing will shorten cure times. 	 After full cure apply an even all over guide coat. Long or short board to desired shape with P80 grit or coarser finishing with P180 grit. Apply fillers if needed for pinholes and low points. Air blow and clean down always wearing gloves and clean lint free cloths using the wipe on wipe off method changing cloths frequently. 	 Apply 2 wet even coats 25–30 microns only. Suggest 4:1:2 as a mix ratio guide. Suggested gun set up 1.4mm Gravity or pressure pot. Allow 24hr cure at temp above 20 deg C Using higher temperatures for thermal curing will shorten cure times.
Final Sand		Colour Coats		Deck & Cock Pit Area	
 grit. 2. Inspect for sand throughs or pin holes. 3. Fill any missed pin holes and spot prime any rub throughs. 4. Air blow and clean down always wearing gloves and clean lint free cloths using the wipe on wipe off method changing cloths frequently. 5. Apply IPA / DI Water mixed 80% IPA & 20% DI water. 6. Air blow and clean down always wearing gloves and clean lint free cloths using the wipe on wipe off method changing cloths frequently. 5. Apply IPA / DI Water mixed 80% IPA & 20% DI water. 6. Final sand for the second clean lint free cloths using the wipe on always wearing gloves and clean lint free cloths using the wipe on always wearing gloves and clean lint free cloths using the wipe on always wearing gloves and clean lint free cloths using the wipe on always wearing gloves and clean lint free cloths using the wipe on always wearing gloves and clean lint free cloths using the wipe on always wearing gloves and clean lint free cloths using the wipe on always wearing gloves and clean lint free cloths using the wipe on always wearing gloves and clean lint free cloths using the wipe on always wearing gloves and clean lint free cloths using the wipe on always wearing gloves and clean lint free cloths using the wipe on always wearing gloves and clean lint free cloths using the wipe on always wearing gloves and clean lint free cloths using the wipe on always wearing gloves and clean lint free cloths using the wipe on always wearing gloves and clean lint free cloths using the wipe on always wearing gloves and clean lint free cloths using the wipe on always wearing gloves and clean lint free cloths using the wipe on always wearing gloves and clean lint free cloths using the wipe on always wearing gloves and clean lint free cloths using the wipe on always wearing gloves and clean lint free cloths gloves and clean lint free cloths using the wipe on always wearing gloves and clean lint free cloths gloves and clean lint free cloths gloves and gloves		 colour first. 2. Allow 24hr cure at temp about 23. Using higher temperatures 4. Apply all other colours in ago 5. Pay particular attention to a colours. 	for thermal curing will shorten cure times. greed sequence. ccurate masking and edge to edge of all or alternatively apply Durepox High	 Follow step 1 & 2 of prep process. Apply Durepox with Deck Grip in appropriately masked out areas with large 2.5 to 3mm gun set up. Mask out any other colours and apply Durepox as per agreed paint and colour scheme. Point to note: By adding 10% By Volume of Durepox High Performance Clear to Durepox colours will greatly enhance clean ability and visual appearance. Keels, Appendages, Masts etc follow prep method depending on degree finish required. Lead Bulbs: Clean / Sand / Clean / use a high build epoxy primer / over night cure / sand with P150 followed by Durepox. 	

No warranty either expressed or implied is made by Resene Automotive & Performance Coatings in this document, which is a technical flow chart to be used as a helpful guide only. The description of the product and its properties is for the sole purpose of identifying the product and does not constitute a warranty that the product or its properties shall conform to that description, nor is the description of the product or process and its properties a warranty by Resene Automotive & Performance Coatings that the goods are suitable for a particular purpose. If carrying out large repaint 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.

