

# MarineShield UltraFlex Spray Application

## "RIB"/ INFLATABLE BOATS.

### Spray Application Instructions:

#### **Personal Protection:**

Always wear personal protective equipment when mixing and applying product, check Safety Data Sheets for full personal safety instructions.

#### **Conditions required for application:**

1. Do not apply in direct sunlight, but in a well-ventilated area.
2. Humidity must NOT exceed 75%.
3. Do not apply when temperatures are likely to fall below 10°C for 1½ hours within the first 2 hours after application, Low temperatures will affect the drying process.
4. In higher temperatures 25°C to 30°C and high humidity the paint will tack off and dry faster.
5. Do not apply when temperatures are likely to rise above 30°C & 75% humidity.
6. Areas that have existing branding either painted or stuck on will need to be masked off and not coated.

#### **Spot Test:**

Prior to application we recommend completing a spot test on a small area that is in a non-obvious location. This test is more important if your substrate is Hypalon as the material composition varies between manufacturers. This test is to ensure that the substrate is not contaminated or subject to impregnated silicon.

1. Find a small area where not visible easy to see.
2. Prepare and clean as per the instructions below.
3. Apply a small mixed quantity to test area.
4. After curing remove tape lines and test for adhesion.

## Substrate Preparation for New and Used Substrates:

1. Do a spot test to ensure that the UltraPrep does not react with the substrate.
2. If the substrate is HYPALON – the substrate MUST be abraded using 180 wet/dry sandpaper first.
3. Thoroughly clean the substrate with UltraPrep using the Red Scotchbrite pad provided to remove all salt crystals and any other surface contaminants. Taking care to remove the residue with wipes before it dries.
4. Put on a clean pair of gloves to avoid cross contamination.
5. Re-clean the surface using the “wipe on wipe off” method. Covering small areas at a time, use one of the wipes, wet with UltraPrep to clean and then wipe that same small area dry with one wipe without solution to ensure all contaminants are removed and not left to dry on the surface.

## Masking:

1. Using a high tack and good quality masking tape, test apply to the surface. Checking for; (a) for adhesion of the tape to the substrate, (b) to ensure it is not lifting on the edges and (c) it is providing a clean edge to the area to be coated.
2. Mask off area not being coated. Ensure the edge on the coated side of the masking tape is well pressed and adhered, to avoid paint bleeding under the tape.
3. Areas that have existing branding either painted or stuck on will need to be masked off and not coated.

## Tacking / Dust Removal:

1. Put on clean gloves
2. Wipe the surface clean
3. Ensure that fibres, fluff or lint are not present on stitching, substrate edges and seams before painting.

## Mixing:

1. Stir/shake tins well, each for 3 -5 minutes
2. Mix 2 parts MarineShield UltraFlex Part A to 1 part MarineShield UltraFlex Part B then add at the ratio of 60% - 70%, the MarineShield UltraFlex Reducer.

Example mix table (approx. 200ml mixed paint required per M <sup>2</sup> )			
Desired quantity	Part A	Part B	Reducer @ 60%
200ml (1M <sup>2</sup> )	83ml	41.6ml	75ml
600ml (3M <sup>2</sup> )	250ml	125ml	225ml
1200ml (6M <sup>2</sup> )	500ml	250ml	450ml

3. Strain mixed product through paint filter.
4. Mixed product has a relatively short pot life, so it is best to only mix what you require.

**ALWAYS PERFORM A TEST SAMPLE TO CHECK FOR ADHESION/COLOUR BEFORE FULL APPLICATION.**  
**RESENE AUTOMOTIVE & LIGHT INDUSTRIAL WILL NOT BE HELD RESPONSIBLE FOR DELAMINATION OR APPLICATION OF INCORRECT COLOURS.**

### **Application Equipment:**

1. Use a HVLP Spray Gun
2. Tip size: 1.3- 1.5
3. Recommended spray pressure: 15 – 20 PSI (1.0 – 1.2 Bar)
4. Ensure the pot lid is securely fitted to avoid drips.

### **Application Method:**

1. Apply 1 medium to wet coats of mixed UltraFlex to the desired area, (35 – 40 micron).
2. Wait 10-20 minutes until the tack off stage has begun to ensure good adhesion (when product is touch dry but still a bit sticky)
3. Apply second coat, if required for coverage a 3<sup>rd</sup> coat may be applied. **Maximum time between recoating is 1 hour.**
4. Remove masking tape when coating is tacky but not fully cured.

### **Application notes:**

1. If air bubbles appear during application use paint brush dipped in UltraFlex Reducer to dampen the bristles (must not be wet), and lightly feather over the affected area to disperse the air bubbles while the painted area is still wet.
2. If drips occur they must be wiped off immediately, use some UltraPrep on a rag to do this. The drips will not be removable once dry!
3. Deflating the boat slightly will help to reduce the appearance of bubbles.

### **Drying Time:**

1. 24 hours minimum cure time.
2. Do not fold or cover the coated surface until after 48 hours cure time.

### **Storage:**

Store inside between 5°C - 28°C or at a cool constant temperature, in a locked, well ventilated area. Keep lids on containers when not in use. See Safety Data Sheets for full storage instructions. It is recommended that all product is used once opened as shelf life will be reduced.