



**QUALITY MARINE
EQUIPMENT SINCE 1981**

A close-up photograph of a hand in a white nitrile glove applying a thick, glossy green paint to a propeller. The propeller is mounted on a red metal shaft. The background shows a workshop setting with metal shelving. A dark blue rectangular box with white text is overlaid on the bottom left of the image.

**VELOX PLUS
APPLICATION
INSTRUCTIONS**

VELOX PLUS TECHNICAL INFORMATION

Please read all information and application instructions before beginning.

Coverage Estimates

- Normal coverage is approximately 8 square meters (86sq.ft) per liter.
- Flat surfaces, trim tab and rudder coverage is approximately 10 square meters (107sq.ft) per liter.
- Propeller or stern drive coverage is approximately 5 square meters (53sq.ft) per liter.
- Primer and Velox Plus Paint are available in .25 liter, and .50 liter cans.
- One 16" four blade prop will use approximately .125 liter for each coat.
- One 30" four blade prop will use approximately .25 liter for each coat.
- One 40" four blade prop will use approximately .50 liter for each coat.

Surface Preparation

- All metallic surfaces must be rough and clean. (See instructions)
- For cleaning grease and dirt use only acetone. When a new clean rag with fresh acetone stays clean, the prop is clean. Never wash the sanded surface with water, soap, detergents or acid!
- Do not touch the cleaned surface with bare hands, this will leave traces of grease or dirt.
- Do not apply when the metal surface temperature is below 41°F or above 95°F. (See instructions)

Aluminum must be protected with an appropriate epoxy coating before the metal primer is applied. This is not necessary when aluminum is already protected with a factory finish (such as new stern drives). For epoxy factory finishes, sand the surface with an abrasive pad (like Scotch-Brite) or fine sandpaper (180-220 grit), removing all gloss or shine before applying Metal Primer.

RECOAT TIMES / TIMES BEFORE LAUNCH

Dry Time (Using 68°F as an example)

18 hours start to finish

Touch dry: 1 hour

Recoating: 3 hours per coat

Launching: 12 hours

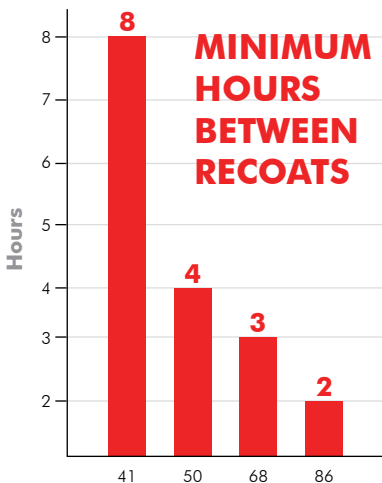
*Please note that this is for one coat of primer and one coat of paint. Additional coats of paint will add 3 hours per coat.

Colors: White or Black

Specific gravity: 1.20 - 1.30

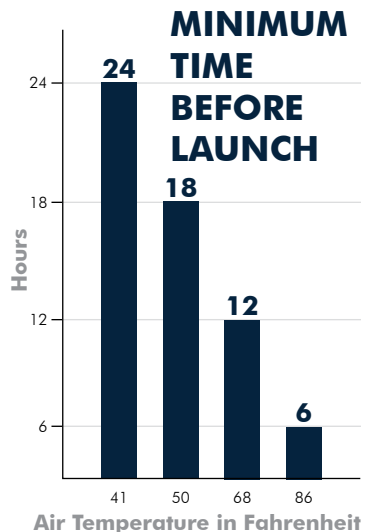
Application: Brush or spray gun

Thinner: Not necessary



◀ Minimum time between each coat based on surface temperatures.

Time before you can launch the boat based on air temperature after last application of paint. ▶



APPLICATION INSTRUCTIONS

EQUIPMENT NEEDED

- Metal Primer
- Velox Plus
- Acetone
- PPE (mask, gloves, etc. - read label)
- Stirring paddle
- 80 grit sandpaper
- clean rags
- brushes or spray gun
- Wear suitable protective clothing, goggles, mask and gloves as prescribed!



Tools and materials needed.

SURFACE PREPARATION

1. Remove all existing antifouling or other coating using 80 grit sandpaper. Use either a dual action rotary sander (we suggest using a soft pad in order not to damage the propeller) or by hand. Do not remove factory finish from aluminum stern drives. It is OK to apply over solid base of Velox Plus from the previous season. Do not use wet sandpaper. The surface must be very rough after sanding.



Removing old antifouling.



Sanding metallic surface with 80 grit sandpaper.

All smooth surface shine must be removed by sanding. Do not use sandpaper that is coarser than 80 grit or anything finer. Do not use worn out sandpaper. Do not use Scotch-Brite. We do not recommend sandblasting unless done by an experienced professional.

2. Wash and degrease all metallic surfaces carefully with acetone). Use a clean rag and change it often, when a new clean rag with fresh acetone stays clean, the prop is clean. This is very important for new or folding propellers, which usually have more grease on them.



Clean surface with acetone.



Wash and degrease all metallic surfaces.



Close up of the clean surface ready for primer.

PRIMING

4. Stir the Metal Primer thoroughly for three to five minutes before applying.
5. Apply one coat of Metal Primer (maximum wet film thickness 100 μm , dry film thickness 30 μm). We suggest applying Metal Primer with a small or medium sized brush. A light coat is enough, applying thicker coats than recommended may result in the Metal Primer to not adhering properly. Brush out any runs or drips immediately that may form when applying Metal Primer. Carefully check the edges of the blades for runs after applying each coat. Primer must dry for at least 3 hours at 68°F (20°C).



Applying Metal Primer.



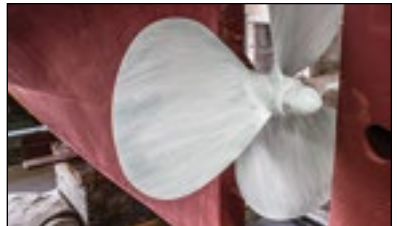
After applying Metal Primer.

APPLYING VELOX PLUS

6. Thoroughly stir Velox Plus for three to five minutes before applying.
7. Do not apply Velox Plus on bare metal. Only apply over Metal Primer supplied with Velox Plus. Apply one coat of Velox Plus by brush (wet film thickness 100 μm , dry film thickness 30 μm). Apply with continuous long brush strokes. Avoid going back and forth on the same spot, as this will soften them Metal Primer too much. Full coverage will not be achieved with the first coat of Velox Plus as seen below. The first coat will normally slightly soften the primer, showing some of its green color. Brush out any runs or drips immediately that may form when applying Metal Primer.

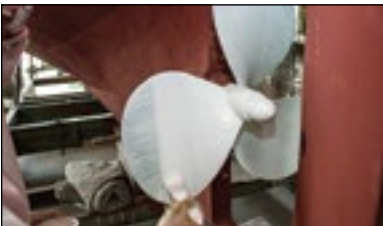


Applying first coat of Velox Plus paint.



First coat of Velox Plus paint.

8. Wait at least 3 hours at 68°F (20°C) then apply a second coat of Velox Plus (wet film thickness 100 μm , dry film thickness 30 μm). For best results, apply it by brush with long and continuous strokes, perpendicular to the brush strokes of the first coat. A third coat of Velox Plus may be applied to obtain perfect coverage or in areas where fouling growth is particularly aggressive.



Applying second coat of Velox Plus paint.



Ready for launch after dry time.

9. Wait at least 12 hours at 68°F (20°C) before launching. See page 1 for chart launch times at other temperatures.

ADDITIONAL INFORMATION

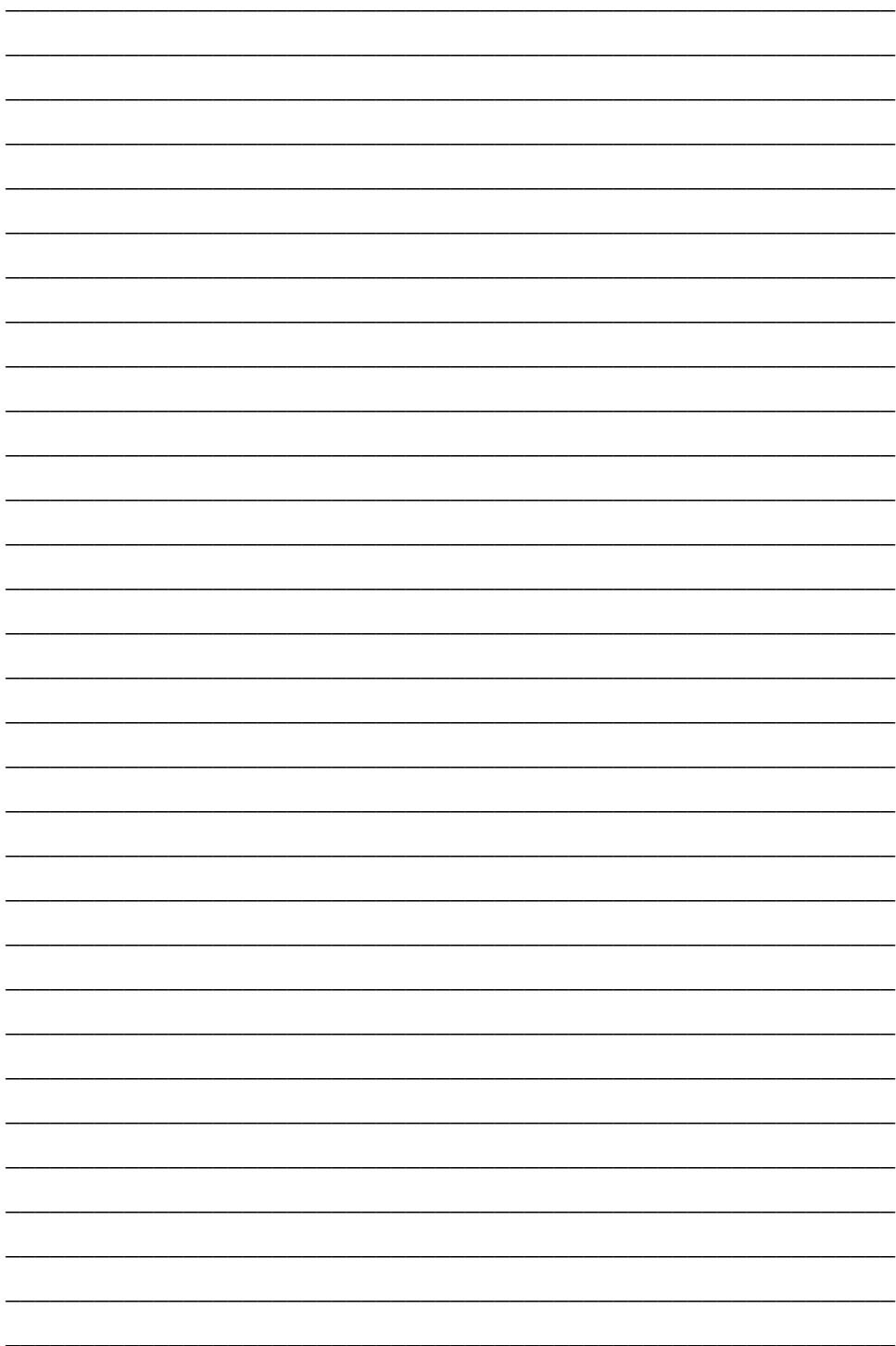
- You can apply another two coats of Velox Plus to the previous season of Velox Plus. Refer steps 6-7 for applying. After cleaning and lightly sanding the surface with fine sandpaper or abrasive pad (like Scotch Brite). We suggest removing all the antifouling paint in any case at least every three years. Do not apply Metal Primer or Velox Plus on any other antifouling.
- For spraying Velox Plus or Metal Primer, it is not necessary to dilute the product.
- Brush out any runs or drips immediately that may form when applying Metal Primer or Velox Plus.
- Carefully check the edges of the blades for runs after applying each coat.
- Carefully read the instructions on the label and always wear suitable protective clothing, goggles, mask and gloves as prescribed.

The following pictures show some propellers treated with Velox Plus after one year service.*





* results may vary depending on location, water temperatures and salinity. All pictures are taken in European or Australian temperate waters. In particular situations (such as tropical lagoons with brackish waters) there may be some more growth of fouling.





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