Alexseal products-: A painters guide.

This is meant as a guide, a very short one at that, telling you what I have found to be effective use of some extremely good products. I use a DeVilbis 2lt Pressure Pot, a DeVilbis JGA gun (yes I know it is getting a bit old now) 1.1mm for top coat. If using a HVLP or High Trans tech I would/have use/d a .85-1.0mm set up. I use a 1.8mm set up for the 401, 442 and 302 (thinned to 20%)primers and also the Suede Finish and primer. You can use a 2-2.2mm for them as well but 2.2 is getting a bit big for the finer primers and you can start to introduce more peel than you want. Use a 2.5 for Spray Fair.

If I am thinning the 101 primer to use wet on wet, then I will use my topcoat set up. You may have to wind you material out only 1.5times; or alternately 2.75 times. Different brands, set up sizes and painters styles will determine this. However, I am confident it will be in the area; particularly the pot pressure. Even when using some of the heavier aircraft topcoats I only have to go to 10 PSI in the pot. The top coat is the most critical of course, but the finer you can finish your primers the less peel you have to rub out before you start straitening your repairs!

Alexseal 101 Anti Corrosive Primer

Use 1.
Mix 9:1:10% thinner. 1 x Dble Header for *normal use*.
Use 2.
Can be used as a *wet on wet* primer for areas such as anodised masts. I then mix it 9:1:30-50% reducer, 1 coat. Approx 2hrs flash off* then apply Alexseal 501 topcoat.
Equipment. 2lt pot, 2-3mt 6mm hoses, 1.1-2.2mm set up. P'pot 10-15PSI. air pressure Med 45-55psi at gun.(This is an estimate as like most of you, I just listen to it.)
If using a pot gun whether gravity or suction I would suggest a 1.4-2.0mm set up.

Spray Fair 328

Mix 100:100:20% thinner. 3 coats @ 400-500µm per coat, 2hrs flash off.
Sand next day 80-120grit.
Equipment. 2lt pot, 2-3mt 10mm hoses, 2.5mm set up. P'pot 20PSI. air pressure
Air pressure to suit.

Alexseal 302 Super Build.

Use 1.
Mix 100:100:20% thinner. (Viscosity approx 30 Seconds)
2 coats @ 200-250µm per coat, 2hrs flash off for *normal use.* Sand next day 180g.

Rextel Pty Ltd
10/212 Curtin Ave West Eagle Farm Qld 4009
Tel: 61 7 3268 7511 Fax: 61 7 3268 1445
Email: glen@seairland.com.au
ABN: 38 010 697 659 ACN: 010 697 659

Use 2.
If you have F'glass boat that you may have sanded through the gelcoat and have pinholes, 302 can be used as a ***pinhole filler***.
Mix 100:100:20% thinner. 1 coat @ 200µm; 2hrs flash off*. Then wet on wet with 2 coats of 401 Primer @ 75-125µm per coat (1hr flash off between 401 coats).
Use 3.
Prior to the release of Spray Fair 328 I have used this as a ***spray bog***. 2 coats @ 500µm per coat. Min 4 hrs flash off. Could still sand the next day (35dc, and outside). Please note, TDS recommends for max build of this product is 3 coats @ 300µm WFT per coat. Yeilds DFT of over just over 600µm. If you need more build than this, you need to use Spray Fair, and/or do better repairs in the 1st place!
Equipment. 2lt pot, 2-3mt 6mm hoses, 1.8-2.2mm set up. P'pot 15PSI. air pressure Med 45-55psi at gun. (This is an estimate as like most of you, I just listen to it.)
If using a pot gun whether gravity or suction I would suggest a 2.0-2.5mm set up.

Alexseal 401 High Build Finish Primer.

Use 1.
Mix 100:50:0-10% thinner. 2 coats @ 75-125µm per coat, 1hr flash off for normal use.
Use 2.
Mix 100:50:30% thinner. 2 coats @ 75-100µm per coat, 1 hr flash off as a finish primer. (Mixed like this will cup similar to 545 primer mixed 100:100:0% thinner added!)
Use 3.
Mix 100:50:50% thinner. 1 thin coat. 2hr flash off then wet on wet with 501 topcoat. Good for over printed/moulded type non slip.
Equipment. 2lt pot, 2-3mt 6mm hoses, 1.8-2.2mm set up. P'pot 12.5-15PSI. air pressure Med 45-55psi at gun. (This is an estimate as like most of you, I just listen to it.)
If using a pot gun whether gravity or suction I would suggest a 1.8-2.2mm set up
This is *the* best primer I have ever used. Care needs to be taken to not put too much on though. It is quite deceiving how much is going on so use of a WFT comb until you get used to the "look" of the primer going on at 75-100 µm is highly recommended.

Alexseal 442 Finish Primer.

Mix 100:100:10-25% reducer. 2 or 3 coats @ 75-125µm per coat, 1hr flash off between coats. Basic finish primer, lays out nice though. Solids have been lowered compared with 401. This is to remove the problem of applying too much product accidently. (some people had un-knowingly applied over 1000µm dft of 401 and wondered why it took too long to dry!)
I have not used this product wet on wet as yet.

Rextel Pty Ltd
10/212 Curtin Ave West Eagle Farm Qld 4009
Tel: 61 7 3268 7511 Fax: 61 7 3268 1445
Email: glen@seairland.com.au
ABN: 38 010 697 659 ACN: 010 697 659

Alexseal 501 Premium Topcoat.

Mix 100:100:30% thinner. (Viscosity approx 14.5 Seconds Ford #4)
2 coats @ 50-75µm per coat. 1 hr flash off . 2 coats every time whether Colour or White. If over stripes or repairs I will put extra coat on just these areas, then full 2nd coat over entire surface. Leave full flash off between all coats.
I do not usually measure the WFT as I go(usually just the primers) but when I have, I have hit 50-75um WFT. Just paint as wet and evenly as possible (and keep in mind it is a 2 coat system), it should look very nice when going on. As the solvent comes out over the 24hrs to dry to tape time, it will pull back even more.
A % of painters are still applying as a 3 coat system. This is fine to do so, however Orange Peel can be introduced into the finish on the 3rd coat. I have only applied as a 2 coat system. I have Red, Blue, and Dk Green boats as well as White's that are now 4, 5&6yrs old still looking great.

Equipment. 2lt pot, 2mt 6mm hoses, 1-1.2mm set up. P'pot 7.5-8PSI, Air pressure HIGH 55-65psi at gun. Material wound 2-2.25 turns from fully wound in.
Shoot from the hip 1-1.2mt with no air.
If using a pot gun whether gravity or suction I would suggest a 1.2-1.4mm set up.

Non Skid Application.
I (Jeff Holland Mankiewicz) believe the non skid can be applied acceptably in one application. We are doing this regularly here in the US.

Mix the 501 topcoat 1:1 with C5051 spray converter and reduce 10-15%. This lower reduction will help with coverage.

Add the non skid at a rate of 1 to 1-1/2 quarts to each mixed gallon. I prefer 1-1/2 quarts but clogging becomes even more a concern. Constant agitation is absolutely necessary to prevent floating and clogging of the non skid beads.

After agitating the non skid thoroughly into the 501 mix, make sure to continually shake the paint pot 100% of the time from when the paint pot is closed until you are done spraying. I do this by having one man rocking the paint pot back and forth. If you had an agitating gun this would be best but don't turn the agitator up to much or you will get to much air into the paint. A medium slow turn is good.

Apply the nonskid paint using a cross coat application so every area has been sprayed from two directions for better dispersion of the non skid. This will also help with coverage.

Rextel Pty Ltd
10/212 Curtin Ave West Eagle Farm Qld 4009
Tel: 61 7 3268 7511 Fax: 61 7 3268 1445
Email: glen@seairland.com.au
ABN: 38 010 697 659 ACN: 010 697 659

On angled surfaces, scaffold the surface so it is not necessary to walk on the surface. Apply a tack coat to these areas, then come back over these areas with the overall application. This will help prevent runs and achieve coverage where you can not apply to much paint in one application.

Below are the steps I have done in the past with Alexseal. I have done them the next day and up to two weeks old, IE: Fully cured. The most effective way I have found is -: Rub the next day after painting, then leave for 3-4 days, then buff using the system below.
1st step is the most important to me!

BUFFING ALEXSEAL

If necessary sand with 3M 1200grit 7 hole hook it finishing discs (3M260L GC800989631); then go over with 3M 1500grit 7 hole hook it finishing discs (3M260L GC800989649).
Use soft interface pad (3M59001 GC800928704).
You should be able to do approx $1m^2$ per disc, keep wiping substrate and disc with rag. Remember this is very fine paper the dust will clog quickly if you don't keep it clean. Do not rub with anything courser than 1200!
After sanding, paint should look shiny already, you don't want to be trying to rub or buff out coarse scratch marks. Bear in mind Alexseal meets the hardest pencil rating for a Polyurethane top coat.

1.
Perfect it III X-TRA CUT Rubbing Compound (3M5636 AS010558281)& 5700 Double faced WOOL PAD (3M5700 0330860). 5710 Adaptor to suit (3M5710 0187823)
All sanding scratches should be removed before moving to stage 2. This stage should only require 1-2 hits with dbl sided buff pad.

2.
Perfect it III RUBBING COMPOUND (3M5933 0411751) & White FOAM PAD (3M5735 60980028926).
This should remove all buff swirls from step No.1. Basically use this step to burnish as well.

Rextel Pty Ltd
10/212 Curtin Ave West Eagle Farm Qld 4009
Tel: 61 7 3268 7511 Fax: 61 7 3268 1445
Email: glen@seairland.com.au
ABN: 38 010 697 659 ACN: 010 697 659

3.
OPTIONAL--FOAM GLAZE (3M5996 60410009629 for Dark Colours) or Finesse IT finishing material (3M5928 60410009595 for Light colours) & Black/Grey FOAM Pad (3M5734 60980035988)
I didn't find this step did all that much. It is going to depend on how good the painter gets it with step No.2 (darker colours benefit more from this step) as to whether or not this will show any significant improvements.

4.
Hand polish for ongoing maintenance of coating with 9026/7 3M Liquid Wax (3M9061 60430050789-473ml) (3M9062 60430050777-1lt)), or McQuires Wet Look polymer based sealer.

Suede Primer and Finish

Alexseal Suede Finish gives a soft feel to it when done right, but is a really tough finish.
The secret of success is in applying it quite wet so you don't get "sandstoning" in the corners where bulk heads meet, especially in corners if the deck heads are also painted in the suede finish. I have successfully used this on outdoor awning deck heads & semi exposed bulwarks too. I would not use the Whites in this high UV exposure areas but have had no reported problems with the likes of Light Grey, Pearl, Havana or even Cream.
Application-: As per TDS, 1 wet coat of primer (I always thin at 30%). White may need a cross coat/dbl header.
Suede Finish needs 1 x Dbl header (I always thin at 20%). Mixing like this I get 8m2 per litre of primer and 4m2 per litre of finish, so it is very easy to work out material requirements.
Equipment. 2lt pot, 2-3mt 6mm hoses, 1.4-1.8mm set up. P'pot 15PSI., air pressure around 40-50psi at gun, depends on size of area being done. Material wound 1.5 turns from fully wound in.

**Please note, some of the flash off times and techniques are not according to manufacturers TDS. I have been using the products as described and performed adhesion tests etc etc with no failures. It is up to you as the applicator to decide whether or not to go outside the TDS recommendations. Temperature, wind and amount of thinner will of course alter the flash off and dry times.*

VB Regards

Glen McKenzie

Disclaimer All care is taken to be as accurate as possible, no responsibility taken for omissions or mistakes.

Rextel Pty Ltd
10/212 Curtin Ave West Eagle Farm Qld 4009
Tel: 61 7 3268 7511 Fax: 61 7 3268 1445
Email: glen@seairland.com.au
ABN: 38 010 697 659 ACN: 010 697 659