



# MARLIN Yacht Paints

Discover  
the efficacy  
of VELOX PLUS



[www.marlinpaint.com](http://www.marlinpaint.com)

# VELOX PLUS

## Antifouling for propellers

VELOX PLUS is an antifouling paint suitable for protection of propellers, stern drives, shafts, trim tabs and other metallic parts permanently immersed. It provides excellent adhesion and antifouling properties.

### APPLICATION

Before you start, make sure you have all the necessary tools, paints and solvents:

1. METAL PRIMER
2. VELOX PLUS
3. SOLVENTE 102 (or pure ACETONE)
4. PPE (mask, gloves, etc. - read label)
5. Stirring paddle
6. Sandpaper n. 80
7. Clean rags
8. Brushes



### 1. SURFACE PREPARATION

Surface preparation can be divided into three steps:

- 1.1 Remove old antifouling or other coatings (jump to 1.2 in case of new propellers/stern drives).
- 1.2 Roughen well the clean metallic surfaces.
- 1.3 Remove dust and carefully clean the surfaces.

1.1 Remove all existing antifouling or other coating using sandpaper n. 80, manually or with careful use of a dual action rotary sander (we suggest using a soft pad in order not to damage the propeller). Do not remove old VELOX PLUS from previous season (see recommendations, point 3.2). Do not remove factory finish from aluminium stern drives.



1.2 Sand thoroughly all metallic surfaces with dry sandpaper n. 80, renewing it often. A dual action rotary sander can be used. Do not use wet sandpaper. The surface must be very rough after sanding. Do not use coarser than 80 grit, nor finer, nor worn out sandpaper. Do not use scotch brite. We do not recommend sandblasting unless done by an experienced professional.



1.3 Wash and degrease carefully all metallic surfaces with our SOLVENT 102 ANTISILICONE (or pure ACETONE) and a clean rag. Change rag frequently, especially in case of new or folding propellers, which usually have more grease on them.





**IMPORTANT:** All metallic surfaces must be rough and clean. Do not touch the surfaces with bare hands, that may leave traces of grease or dirt. For cleaning grease and dirt use only our SOLVENTE 102 or pure Acetone. Absolutely do not wash the sanded surface with water, soap, detergents, acid!

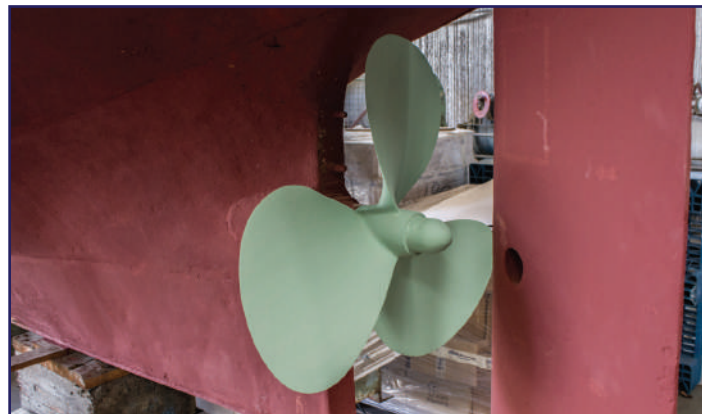


**NOTE:** We suggest protecting bare aluminium with an appropriate epoxy coating (after careful surface preparation as explained above). This is not necessary when aluminium is already protected with factory finish (like new stern drives). On epoxy cycles or factory finish, just lightly sand the surface with abrasive pad (like Scotch Brite) or fine sandpaper (n. 180-220) before applying METAL PRIMER.



## 2. APPLICATION

2.1 Apply one coat of METAL PRIMER (maximum wet film thickness 100  $\mu\text{m}$ , dry film thickness 30  $\mu\text{m}$ ). We suggest application with a small/medium brush. Leave it dry for at least 3 hours at 68° F (20° C). A light coat is enough, applying thicker coats than recommended may result in worsened adhesion.



2.2 Apply one coat of VELOX PLUS by brush (wet film thickness 100  $\mu\text{m}$ , dry film thickness 30  $\mu\text{m}$ ). Apply it with continuous long brush strokes. Avoid going back and forth on the same spot, as this will soften too much the METAL PRIMER. As pictured below, full coverage will not be achieved with first coat of VELOX PLUS. The first coat will normally slightly soften the primer, showing some of its green colour.





2.3 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 result, 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.



2.4. Wait at least 12 hours at 68° F (20° C) before launching.

### 3. RECOMMENDATIONS

3.1 Prepare the surface carefully: at the time of applying METAL PRIMER all metallic surfaces should be very rough and clean (free from grease, dust, fingerprints, sweat, water, soaps or any kind of dirt or contaminating agent). Below there are two pictures showing paint detachment caused by surface not well prepared.



3.2 On top of VELOX PLUS from previous season, another two coats of VELOX PLUS can be applied directly as explained above in points 2.2 and 2.3, 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.

3.3 Do not apply VELOX PLUS on bare metal without METAL PRIMER.

3.4 For spraying VELOX PLUS or METAL PRIMER, it is not necessary to dilute the product.

3.5 Stir very thoroughly both METAL PRIMER and VELOX PLUS before application as both contain heavy particles that may sediment. Scrap the bottom of the can and stir until the paint becomes homogeneous.

3.6 Brush out immediately any sag or dip that may form when applying METAL PRIMER or VELOX PLUS, check carefully the edge of the blades for dips after the application of every coat.

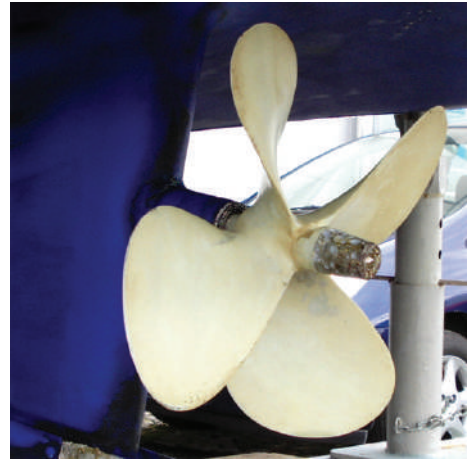
3.7 Read carefully the instructions on the label and always wear suitable protective clothing, goggles, mask, gloves as prescribed.

### 4. TECHNICAL SPECIFICATIONS

<b>Colours</b>	White, black, grey	<b>Drying time</b>	
<b>Specific gravity</b>	1.20 - 1.30	<i>touch dry</i>	1 hours at 68°F
<b>Application</b>	brush, spray gun	<i>for recoating</i>	3 hours at 68°F
<b>Thinner</b>	not necessary	<i>for launching</i>	12 hours at 68° F



The following pictures show some propellers treated with VELOX PLUS after one year service. Most pictures were taken in temperate waters (Mediterranean sea, UK or Australia). Results may be different depending on type of waters, location, temperatures. Especially in tropical brackish waters, or in extremely heavy fouling areas, there may be more growth of barnacles or other fouling than showed below.





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