



# Underwater Metal Kit

6456

TECHNICAL BULLETIN 712 4/11



Underwater Metal Kit 6456 combines convenient sized containers of both our 6455/044 Metal Primer and 6627 Tie Coat Primer in one easy package. This kit is specifically designed for the painting of underwater metal running gear including shafts, struts, props, thru-hulls, and trim tabs. The system is suitable for use on all underwater metal running gear, including steel, stainless or galvanized steel, bronze, and aluminum.

The following specification is for the painting of underwater metal running gear. The system is suitable for use on all underwater metals, including steel, stainless or galvanized steel, bronze, and aluminum. Close attention to detail is essential to obtain maximum results on these difficult to paint surfaces. Regardless of the metal to be painted, the preparation and priming procedures are the same. Only the antifouling will be different. Use Vivid, Ultima Eco, Vivid Free, or Alumaspray Plus on aluminum surfaces and Trinidad SR, Trinidad, Vivid, Ultima Eco, Unepoxy Plus, Unepoxy, Horizons, Hydrocoat, Ultima SR-60 or Ultima SR-40 on all other metals. Consult our Product Data Sheets for more information. Detailed product information can be found at [www.pettitpaint.com](http://www.pettitpaint.com) or by calling (800) 221-4466.

## The painting specification is broken down into three separate parts:

- I. Surface Preparation of the Underwater Metal Surfaces
- II. Priming of the Underwater Metal Surfaces
- III. Application of Antifouling Paint

### I. Surface Preparation of Metal Surfaces

1. If the metal surface has been previously painted, sandblast, scrape, sand, or use a paint and varnish remover to remove the existing coatings and expose the bare metal. If a stripper was used to remove the old coatings, use Pettit D-95 Dewaxer to clean the metal thoroughly of all residues before proceeding further.
2. Sandblast or disc sand the bare metal using coarse (60 to 80 grit) sandpaper. Sand aggressively and thoroughly until all metal surfaces to be painted are completely clean and bright. Wipe the surfaces to be painted with rags wetted with Pettit D-95 Dewaxer removing all traces of sanding residue. Proceed immediately to Part II.

### II. Priming of the Metal Surfaces

1. Shake or knead the 6455 Metal Primer pouch thoroughly before using. Make sure any pigment settled during storage has been properly remixed into suspension. Add the complete pouch of 044 Metal Primer Activator to the complete pouch of 6455 Metal Primer very slowly with constant stirring. If smaller amounts of primer are going to be mixed, add 1 volume of Activator to 4 volumes of the Metal Primer. Do not mix more material than can be used in 8 hours. The mixture of Primer and Activator will still be fluid after 8 hours but should not be used since the quality of adhesion to metals will be reduced.
2. Apply the mixed 6455/044 Metal Primer by brush directly to the cleaned, bare metal. The 6455/044 Metal Primer should be applied in one thin coat, resulting in a somewhat translucent finish. Attempts to apply a heavier coating or a second coat of the product will result in coating system failure. Dry film thickness of the coating should be .3 to .5 mils (.0003-.0005 inches). Do not apply over old paints or primers and do not apply more than one coat of this primer. Do not apply 6455 Metal Primer on extremely humid days or when rain is threatening. Do not apply in the late afternoon when working outdoors as the wet film may be adversely affected by dew. When working in cooler temperatures be sure that the air and surface temperature will remain at or above 50°F until the primer is dry. Allow the 6455/044 Metal Primer to dry 2 hours minimum, 48 hours maximum and proceed to step 3.
3. Thoroughly stir the 6627 Tie Coat Primer and apply a full coat by brush to ensure adequate film thickness and coverage. Apply a second coat of 6627 Tie Coat Primer after 2 hours. Proceed to Part III.

### III. Application of Antifouling Paint

1. Once the second coat of 6627 Tie Coat Primer has dried 4 hours or more apply the first coat of antifouling paint. Use Vivid, Ultima Eco, Vivid Free, or Alumaspray Plus on aluminum surfaces and Trinidad SR, Trinidad, Vivid, Ultima Eco, Unepoxy Plus, Unepoxy, Horizons, Hydrocoat, Ultima SR-60 or Ultima SR-40 on all other metals. Allow the first coat of antifouling to dry in accordance with the label directions and then proceed with a second coat of antifouling.

NOTES: This system works exceptionally well on properly prepared and grounded metal surfaces. Improper grounding of the metal surfaces or stray currents resulting from faulty dockside hook-ups can result in neutralization of the antifouling paint and/or disbondment of the priming system. Please make sure all electrical systems on the boat are maintained in satisfactory operating condition.

Kit contains 1 pint (16 FL.OZ.) 473mL of # 6627 Tie-Coat Primer, 8 FL.OZ. (236mL) of # 6455 Metal Primer, and 2 FL.OZ. (59 mL) of # 044 Activator