

**STEP BY STEP**  
boat repairs with Sea-Line®



# STEP BY STEP

| GRP BOAT SYSTEM  |  |   |                  |                                  |              |
|--|--|---|------------------|----------------------------------|--------------|
| LIGHTSYSTEM  |  |   |                  |                                  |              |
| Product  | Number of coats  | Thinning ratio  | Pot life at 20°C | Time before applying next coat   |              |
|  |  |   |                  | Min.                             | Max.         |
| Above the waterline                                      |  |   |                  |                                  |              |
| Polyurethan  | 1 - 2  | Thinner PU brush / roll 15% - 25%<br>spray 45% - 55%              | 6 h              | 30 min.                          | 72 h         |
| Below the waterline<br>(apply 5 cm above real waterline) |  |   |                  |                                  |              |
| Epoxy Lightprimer  | 1 - 2  | Thinner for epoxy primers brush / roll 5% - 25%<br>spray 5% - 50% | 2 h              | 4 h                              | 5 days       |
| Antifouling  | Above system can be over coated with every kind of antifouling selfpolishing as well as hard one |   |                  |                                  |              |
|  | 1-3 *  | Not recommended   | –                | Dry to launch (immersion times): |              |
|  |  |   |                  | Min.6~12 h                       | Max 6 months |

| ANTYOSMOTIC SYSTEM - new hull                            |  |  |         |                                  |              |
|--|--|--|---------|----------------------------------|--------------|
| Below the waterline<br>(apply 5 cm above real waterline) |  |  |         |                                  |              |
| Epoxy Lightprimer  | 1  | Thinner for epoxy primers: brush / roll 5% - 25%<br>spray 5% - 50% | 2 h     | 4 h                              | 5 days       |
| Antiosmotic HS Epoxy Primer                              | 2 - 4  | Thinning not recommended   | 45 min. | 8 h                              | 72 h         |
| Epoxy Lightprimer  | 1  | Thinner for epoxy primers: brush / roll 5% - 25%<br>spray 5% - 50% | 2 h     | 4 h                              | 5 days       |
| Antifouling  | Above system can be over coated with every kind of antifouling selfpolishing as well as hard one |  |         |                                  |              |
|  | 1-3 *  | Not recommended  | –       | Dry to launch (immersion times): |              |
|  |  |  |         | Min.6~12 h                       | Max 6 months |

| OSMOTIC REPAIR SYSTEM                                    |  |  |         |                                  |              |
|--|--|--|---------|----------------------------------|--------------|
| Below the waterline<br>(apply 5 cm above real waterline) |  |  |         |                                  |              |
| Epoxy Lightprimer  | 1 - 2  | Thinner for epoxy primers: brush / roll 5% - 50%<br>spray 5% - 50% | 2 h     | 4 h                              | 5 days       |
| Epoxy filler   | If necessary<br>1. for leveling small areas universal epoxy filler is recommended<br>2. for large areas epoxy lightweight filler is recommended<br>3. for thick applications epoxy filler with fiberglass is recommended |  |         |                                  |              |
| Antiosmotic HS Epoxy Primer                              | 2 - 4  | Thinning not recommended   | 45 min. | 8 h                              | 72 h         |
| Epoxy Lightprimer  | 1 - 2  | Thinner for epoxy primers: brush / roll 5% - 25%<br>spray 5% - 50% | 2 h     | 4 h                              | 5 days       |
| Antifouling  | Above system can be over coated with every kind of antifouling selfpolishing as well as hard one   |  |         |                                  |              |
|  | 1-3 *  | Not recommended  | –       | Dry to launch (immersion times): |              |
|  |  |  |         | Min.6~12 h                       | Max 6 months |

| GRP BOAT SYSTEM  |  |  |                  |                                  |              |
|--|--|--|------------------|----------------------------------|--------------|
| RECOMMENDED STANDARD SYSTEM                              |  |  |                  |                                  |              |
| Product  | Number of coats  | Thinning ratio   | Pot life at 20°C | Time before applying next coat   |              |
|  |  |  |                  | Min.                             | Max.         |
| Above the waterline                                      |  |  |                  |                                  |              |
| Epoxy Lightprimer  | 1 - 2  | Thinner for epoxy primers: brush / roll 5% - 25%<br>spray 5% - 50% | 2 h              | 4 h                              | 5 days       |
| Epoxy filler   | If necessary<br>1. for leveling small areas universal epoxy filler is recommended<br>2. for large areas epoxy lightweight filler is recommended<br>3. for thick applications epoxy filler with fiberglass is recommended |  |                  |                                  |              |
| Epoxy Lightprimer  | 1 - 2  | Thinner for epoxy primers: brush / roll 5% - 25%<br>spray 5% - 50% | 2 h              | 4 h                              | 5 days       |
| Polyurethan  | 1 - 3  | Thinner PU brush / roll 15% - 25%<br>spray 45% - 55%               | 6 h              | 30 min.                          | 72 h         |
| Below the waterline<br>(apply 5 cm above real waterline) |  |  |                  |                                  |              |
| Epoxy Lightprimer  | 1 - 2  | Thinner for epoxy primers: brush / roll 5% - 25%<br>spray 5% - 50% | 2 h              | 4 h                              | 5 days       |
| Epoxy filler   | If necessary<br>1. for leveling small areas universal epoxy filler is recommended<br>2. for large areas epoxy lightweight filler is recommended<br>3. for thick applications epoxy filler with fiberglass is recommended |  |                  |                                  |              |
| Epoxy Lightprimer  | 2 - 4  | Thinner for epoxy primers: brush / roll 5% - 25%<br>spray 5% - 50% | 2 h              | 4 h                              | 5 days       |
| Antifouling  | Above system can be over coated with every kind of antifouling selfpolishing as well as hard one   |  |                  |                                  |              |
|  | 1-3 *  | Not recommended  | –                | Dry to launch (immersion times): |              |
|  |  |  |                  | Min.6~12 h                       | Max 6 months |

## REMEMBER

- Correct surface preparation is the condition of good product application.
- Degrease the work surface, sand with sandpaper, remove dust and degrease again.
- Wash off salts and any other impurities with fresh water.
- Use Sea – Line® cleaner.
- Minimum temperature for application epoxy products is +10°C.
- Do not exceed the recommended amount of hardener.
- Mix contents well until mixture is a solid color.
- Only mix enough product for immediate use.
- Use only thinners recommended by producer.
- Epoxy fillers are the only ones recommended for elements of the hull below the water line.
- For epoxy fillers and non solvent hs epoxy filler we recommend to apply Sea – Line® epoxy lightprimer before applying the polyester topcoat system.
- System below the water line apply 5 cm above real waterline.
- Primers do not require polishing when proper amount of time is given between applying separate coats.
- Sea-line product usage scheme requires getting acquainted with technical data sheet (TDS) and MSDS.
- Always work according to technical data sheet and MSDS.
- Download TDS and MSDS here: [www.sea-line.eu](http://www.sea-line.eu)

# STEP BY STEP

| STEEL AND ALUMINIUM BOAT SYSTEM                                  |   |   |                  |   |       |
|--|---|---|------------------|---|-------|
| Product  | Number of coats   | Thinning ratio  | Pot life at 20°C | Time before applying next coat                                    |       |
|  |   |   |                  | Min.  | Max.  |
| Above the waterline  |   |   |                  |   |       |
| Anticorrosion Epoxy Primer                                       | 2 - 3   | Thinner for epoxy primers:<br>brush / roll 5% - 25%<br>spray 5% - 50% | 2 h              | 4 h   | 5 day |
| Epoxy filler   | If necessary<br>1. for leveling small areas universal epoxy filler is recommended.<br>2. for large areas epoxy lightweight filler is recommended.<br>3. for thick applications epoxy filler with fiberglass is recommended. |   |                  |   |       |
| Epoxy Lightprimer  | 1 - 2   | Thinner for epoxy primers:<br>brush / roll 5% - 25%<br>spray 5% - 50% | 2 h              | 4 h   | 5 day |
| Polyurethan  | 2 - 3   | Thinner PU<br>brush / roll 15% - 25%<br>spray 45% - 55%               | 6 h              | 30 min.   | 72 h  |
| <i>Below the waterline<br/>(apply 5 cm above real waterline)</i> |   |   |                  |   |       |
| Anticorrosion Epoxy Primer                                       | 2 - 3   | Thinner for epoxy primers:<br>brush / roll 5% - 25%<br>spray 5% - 50% | 2 h              | 4 h   | 5 day |
| Epoxy filler   | If necessary<br>1. for leveling small areas universal epoxy filler is recommended.<br>2. for large areas epoxy lightweight filler is recommended.<br>3. for thick applications epoxy filler with fiberglass is recommended. |   |                  |   |       |
| Epoxy Lightprimer  | 1 - 2   | Thinner for epoxy primers:<br>brush / roll 5% - 25%<br>spray 5% - 50% | 2 h              | 4 h   | 5 day |
| Antifouling  | Above system can be over coated with every kind of antifouling selfpolishing as well as hard one  |   |                  |   |       |
|  | 1-3 *   | Not recommended   | –                | Dry to launch (immersion times):<br>Min. 6~12 h      Max 6 months |       |

| SYSTEM FOR KEEL                                |  |   |                  |   |        |
|--|--|---|------------------|---|--------|
| Product  | Number of coats  | Thinning ratio  | Pot life at 20°C | Time before applying next coat                                    |        |
|  |  |   |                  | Min.  | Max.   |
| Below the waterline                            |  |   |                  |   |        |
| Anticorrosion Epoxy Primer                     | 1 - 2  | Thinner for epoxy primers:<br>brush / roll 5% - 10%<br>spray 5% - 50% | 2 h              | 4 h   | 5 days |
| Epoxy filler                                   | If necessary<br>1. for leveling small areas universal epoxy filler is recommended<br>2. for large areas epoxy lightweight filler is recommended<br>3. for thick applications epoxy filler with fiberglass is recommended |   |                  |   |        |
| Antismotic HS Epoxy Primer                     | 2 - 3  | Thinning not recommended  | 45 min.          | 8 h   | 72 h   |
| Epoxy Lightprimer / Anticorrosion Epoxy Primer | 1 - 2  | Thinner for epoxy primers:<br>brush / roll 5% - 10%<br>spray 5% - 50% | 2 h              | 4 h   | 5 days |
| Antifouling                                    | Above system can be over coated with every kind of antifouling selfpolishing as well as hard one   |   |                  |   |        |
|  | 1-3 *  | Not recommended   | –                | Dry to launch (immersion times):<br>Min. 6~12 h      Max 6 months |        |

| WOOD BOAT SYSTEM   |   |   |                  |   |        |
|--|---|---|------------------|---|--------|
| Product  | Number of coats   | Thinning ratio  | Pot life at 20°C | Time before applying next coat                                    |        |
|  |   |   |                  | Min.  | Max.   |
| OPTION I   |   |   |                  |   |        |
| Above the waterline                                      |   |   |                  |   |        |
| Epoxy Lightprimer  | 1 - 3   | Thinner for epoxy primers:<br>brush / roll 5% - 25%<br>spray 5% - 50% | 2 h              | 4 h   | 5 days |
| Epoxy filler   | If necessary<br>1. for leveling small areas universal epoxy filler is recommended<br>2. for large areas epoxy lightweight filler is recommended<br>3. for thick applications epoxy filler with fiberglass is recommended    |   |                  |   |        |
| Epoxy Lightprimer  | 1   | Thinner for epoxy primers:<br>brush / roll 5% - 25%<br>spray 5% - 50% | 2 h              | 4 h   | 5 days |
| Poliuretan   | 2 - 3   | Thinner PU<br>brush / roll 15% - 25%<br>spray 45% - 55%               | 6 h              | 30 min.   | 72 h   |
| OPTION II  |   |   |                  |   |        |
| Above the waterline                                      |   |   |                  |   |        |
| Polyurethan Clearcoat                                    | 2 - 3   | Thinner PU<br>brush / roll 15% - 20%<br>spray 15% - 20%               | 3 h              | 30 min.   | 72 h   |
| Polyurethan Clearcoat                                    | 2 - 4   | Thinner PU<br>brush / roll 0% - 5%<br>spray 0% - 5%                   | 3 h              | 30 min.   | 72 h   |
| OPTION I AND II  |   |   |                  |   |        |
| Below the waterline<br>(apply 5 cm above real waterline) |   |   |                  |   |        |
| Epoxy Lightprimer  | 1 - 3   | Thinner for epoxy primers:<br>brush / roll 5% - 25%<br>spray 5% - 50% | 2 h              | 4 h   | 5 days |
| Epoxy filler   | If necessary<br>1. for leveling small areas universal epoxy filler is recommended.<br>2. for large areas epoxy lightweight filler is recommended.<br>3. for thick applications epoxy filler with fiberglass is recommended. |   |                  |   |        |
| Epoxy Lightprimer  | 1 - 2   | Thinner for epoxy primers:<br>brush / roll 5% - 25%<br>spray 5% - 50% | 2 h              | 4 h   | 5 days |
| Antifouling  | Above system can be over coated with every kind of antifouling selfpolishing as well as hard one  |   |                  |   |        |
|  | 1-3 *   | Not recommended   | –                | Dry to launch (immersion times):<br>Min. 6~12 h      Max 6 months |        |

\*Special attention should be paid to obtaining a specific coating thickness (100 µm dtf), which ensures the effective operation of the antifouling paint.