

STEP BY STEP  
boat repairs with Sea-Line®  
below the waterline



# STEP BY STEP

## boat repairs with Sea-Line®

### below the waterline

GRP BOAT SYSTEM					
Below the waterline (apply 5 cm above real waterline)					
LIGHTSYSTEM					
Product	Number of coats	Thinning ratio	Pot life at 20°C	Time before applying next coat	
				Min.	Max.
Below the waterline (apply 5 cm above real waterline)					
Epoxy Lightprimer	1 - 2	Thinner for epoxy primers brush / roll 5% - 25% 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					
Product	Number of coats	Thinning ratio	Pot life at 20°C	Time before applying next coat	
				Min.	Max.
Epoxy Lightprimer	1	Thinner for epoxy primers: brush / roll 5% - 25% 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% 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 (apply 5 cm above real waterline)					
Epoxy Lightprimer	1 - 2	Thinner for epoxy primers: brush / roll 5% - 50% spray 5% - 50%	2 h	4 h	5 days
Epoxy filler	If necessary 1. for leveling small areas universal epoxy filler is recommended 2. for large areas epoxy lightweight filler is recommended 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% 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.
Below the waterline (apply 5 cm above real waterline)					
Epoxy Lightprimer	1 - 2	Thinner for epoxy primers: brush / roll 5% - 25% spray 5% - 50%	2 h	4 h	5 days
Epoxy filler	If necessary 1. for leveling small areas universal epoxy filler is recommended 2. for large areas epoxy lightweight filler is recommended 3. for thick applications epoxy filler with fiberglass is recommended				
Epoxy Lightprimer	2 - 4	Thinner for epoxy primers: brush / roll 5% - 25% 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 boat repairs with Sea-Line® below the waterline

## STEEL AND ALUMINIUM BOAT SYSTEM

Product	Number of coats	Thinning ratio	Pot life at 20°C	Time before applying next coat	
				Min.	Max.
<i>Below the waterline (apply 5 cm above real waterline)</i>					
Anticorrosion Epoxy Primer	2 - 3	Thinner for epoxy primers: brush / roll 5% - 25% spray 5% - 50%	2 h	4 h	5 day
Epoxy filler	If necessary 1. for leveling small areas universal epoxy filler is recommended. 2. for large areas epoxy lightweight filler is recommended. 3. for thick applications epoxy filler with fiberglass is recommended.				
Epoxy Lightprimer	1 - 2	Thinner for epoxy primers: brush / roll 5% - 25% 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): 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.
<i>Below the waterline</i>					
Anticorrosion Epoxy Primer	1 - 2	Thinner for epoxy primers: brush / roll 5% - 10% spray 5% - 50%	2 h	4 h	5 days
Epoxy filler	If necessary 1. for leveling small areas universal epoxy filler is recommended 2. for large areas epoxy lightweight filler is recommended 3. for thick applications epoxy filler with fiberglass is recommended				
Antiosmotic 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: brush / roll 5% - 10% 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	

## WOOD BOAT SYSTEM

Product	Number of coats	Thinning ratio	Pot life at 20°C	Time before applying next coat	
				Min.	Max.
<i>Below the waterline (apply 5 cm above real waterline)</i>					
Epoxy Lightprimer	1 - 3	Thinner for epoxy primers: brush / roll 5% - 25% spray 5% - 50%	2 h	4 h	5 days
Epoxy filler	If necessary 1. for leveling small areas universal epoxy filler is recommended. 2. for large areas epoxy lightweight filler is recommended. 3. for thick applications epoxy filler with fiberglass is recommended.				
Epoxy Lightprimer	1 - 2	Thinner for epoxy primers: brush / roll 5% - 25% 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	

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