

Anti-fouling Paint Treatment 75 kHz Transducer MW 11 April 2006

Note: This procedure used prior to installation in April 2006. It takes about a week with cure times.

NOTE: This is the RDI-recommended paint scheme for both WorkHorse and Ocean Surveyor ADCPs. This was confirmed with RDI Field Service prior to starting.

WARNING: These paints, particularly the Trilux anti-fouling paint, have a high VOC content, and should be applied only in a well-ventilated area. This treatment was done in the Ship Ops South Bay with the garage door open, and heater left on. Paint is mostly gassed off in the first 6-8 hours, so it is safe to close the door at night. Be sure to close the doors on both sides of the bay to keep fumes out of the rest of the building. Leave the heater on at night, particularly if outside temperature is expected to drop below 50F.

- 1) Remove all fouling and old paint from transducer face and wet side of brass housing.
- 2) Sand brass with 150 grit Production Paper to remove oxidation and rough surface.
- 3) LIGHTLY sand transducer face and fiberglass ring with 150 grit Production Paper.
- 4) Mask off transducer face and fiberglass rim.
- 5) Apply one coat Interlux Viny-Lux self-etching primer wash. This is a very thin compound, and only one thin layer is required. Note that the mix is 7 parts **Viny-Lux 353**, 1 part **354**, 4 parts **355** thinner. 353 and 354 are in the kit, 355 is separate. Englund Marine had the 353/354 kit, but not the 355 thinner. It must be shipped by ground, so plan ahead. West Marine (Portland) also stocks Interlux, and has the 355 thinner.

- **WARNING: DO NOT PUT ON TRANSDUCER FACE**
- Once mixed, pot life is <8 hours
- Must be overpainted between 1 and 24 hours after application, otherwise a second coat must be put on.

6) Apply three coats **Interlux Primocon primer**. Coats must cure at least 8 hours before overcoating. This is a single-part, vinyl-based primer. One quart is MORE than enough to do three coats on the transducer.

• WARNING: DO NOT PUT PRIMER ON TRANSDUCER FACE

7) > 8 hours after final primer coat, remove masking, and apply two coats of **Interlux Trilux 33 anti-fouling paint** to primed areas AND transducer face. This is a thick paint, and should be applied thickly to the transducer. The more paint, the longer it will keep the fouling off. RDI recommends one coat “per season,” and state than two coats “might last one year.” Wait at least 24 hours between coats.

8) Allow final AF coat to cure at least 24 hours before installing transducer.

Additional work: Rust spots on the adapter plate were scraped and wire-brushed to bright metal. Loose flakes of paint were removed. Touched up with Primocon primer (2 coats), then wet side (inside rim only) recoated with two coats Trilux over existing epoxy-based AF. Be sure to mask off threaded studs before painting.

Paints used (all **Interlux**: www.yachtpaint.com)
(Info Sheets and MSDS attached)

Viny-Lux (two part kit, 28 oz. can 353, 4 oz. jar 354)

Thinned with **355 Solvent**

Primocon Underwater Primer not thinned

Trilux 33 Anti-fouling Paint not thinned

Viny-Lux 353/354, Primocon and Trilux were in stock at Englund Marine, Newport. Englund's does not stock 355 solvent. 355 Solvent sourced from West Marine, Hayden Meadows Drive, Portland. 355 can only be shipped by ground since it is considered hazardous material. Englund can get it within 4-5 days. Also available via the web from West Marine. There are other vendors of Interlux paint in the Portland area.