

FAIRING AND COATING A CAST IRON KEEL – WEST SYSTEM

PREPARATION

Remove all existing coatings exposing the metal. The preferred method is to blast the keel to standard SA2½. If this is not an option the use of an angle grinder with a 40-grit flap wheel is suggested. Angle grinders are available from good DIY stores.

Once all coatings have been removed and the keel is clear of all corrosion, dust, etc. the coating process can begin.

FAIRING

Apply by roller one coat of WEST SYSTEM 105 Resin with either the 205 Standard Hardener or the 206 Slow Hardener; use a brush to fill any voids not covered by the roller.

Allow the coating to become touch dry (1 to 3 Hours depending upon temperature). Apply a screed coat using WEST SYSTEM epoxy filled with 407 Low Density filler to a peanut butter consistency. This mix should be applied to the whole surface using a WEST SYSTEM 808 plastic squeegee to an even thickness of about 2mm.

Mix only small quantities of epoxy and allow to cure for 24 hours then sand to the desired fairness using a mechanical sander with 80-grit paper. If bare metal is exposed or low points are created, coating and extra filling may be necessary. This has to be completed before the coating process can continue.

COATING

When the keel has reached a satisfactory fairness apply four coats of WEST SYSTEM Epoxy using WEST SYSTEM 790 or 800 roller covers. Apply all four coats in the same working day, as soon as the previous coating is touch dry apply the next coat of epoxy. If the epoxy is allowed to cure between coats, wash, sand and dry the surface before applying the next coat.

Please refer to the West System user manual and product catalogue for further advice.

FINISHING

If applying paint coatings wash and sand the epoxy coated surface with 120 grit paper and apply the final coating system as recommended by the paint manufacturer.

NOTE:

Applying heat to the keel will quicken the curing process of the epoxy. An infra red lamp will effectively warm the whole keel in a relatively short time when placed about 1.5 metres away. Alternatively any source of dry heat can be used.

It is important to remember that the keel represents at least 25% of the wetted surface of the boat hull. So care in the fairing process is essential if performance is of the essence.

Please refer to the WEST SYSTEM User Manual and Product Catalogue for further information.