

Painting Procedures

Cleaning & Painting Aluminum Propellers & Gear Housings

WARNING

Avoid serious injury from flying debris. Avoid serious injury from airborne particles. Use eye and breathing protection with proper ventilation.

PROPELLERS

1. Sand the entire area to be painted with 3M 120 Regalite Polycut or coarse Scotch-Brite, disc or belts.
2. Feather edges of all broken paint edges. Try not to sand through the primer.
3. Clean the surface to be painted using PPG Industries DX330 Wax and Grease Remover or equivalent (Xylene or M.E.K.).
4. If bare metal has been exposed, use Quicksilver's Light Gray Primer.
5. Allow a minimum of 1 hour dry time and no more than 1 week before applying the finish coat.
6. Apply the finish coat using Quicksilver's EDP Propeller Black.

GEAR HOUSINGS

The following procedures should be used in refinishing gear housings. This procedure will provide the most durable paint system available in the field. The materials recommended are of high quality and approximate marine requirements. The following procedure will provide a repaint job that compares with a properly applied factory paint finish. It is recommended that the listed materials be purchased from a local Ditzler Automotive Finish Supply Outlet. The minimum package quantity of each material shown following is sufficient to refinish several gear housings.

Procedure:

1. Wash gear housing with a muriatic acid base cleaner to remove any type of marine growth and rinse with water, if necessary.
2. Wash gear housing with soap and water, then rinse.

3. Sand blistered area with 3M 180 grit sandpaper or P180 Gold Film Disc to remove paint blisters only. Feather edge all broken paint edges.
4. Clean gear housing thoroughly with (DX-330) wax and grease remover.
5. Spot repair surfaces where bare metal is exposed with (DX-503) alodine treatment.

IMPORTANT: Do not use any type of aerosol spray paints as the paint will not properly adhere to the surface nor will the coating be sufficiently thick to resist future paint blistering.

6. Mix epoxy chromate primer (DP-40) with equal part catalyst (DP-401) per manufacturer's instructions, allowing proper induction period for permeation of the epoxy primer and catalyst.
7. Allow a minimum of one hour drying time and no more than one week before top coating assemblies.
8. Use Ditzler Urethane DU9000 for Mercury Black and DU33414M for Sea Ray White. Catalyze all three colors with Ditzler DU5 catalyst mixed 1:1 ratio. Reduce with solvents per Ditzler label.

CAUTION

Be sure to comply with instructions on the label for ventilation and respirators. Using a spray gun, apply one half to one mil even film thickness. Let dry, flash off for five minutes and apply another even coat of one half to one mil film thickness. This urethane paint will dry to the touch in a matter of hours, but will remain sensitive to scratches and abrasions for a few days.

9. The type of spray gun used will determine the proper reduction ratio of the paint.

IMPORTANT: Do not paint sacrificial trim tab or anode.

10. Cut out a cardboard "plug" for trim tab pocket to keep paint off of mating surface to maintain good continuity circuitry between trim tab and gear housing.

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Marcel A. Müller



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Table of Contents 20saab 9 5 Se Repair Manual

1. Understanding the eBook 20saab 9 5 Se Repair Manual
 - The Rise of Digital Reading 20saab 9 5 Se Repair Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying 20saab 9 5 Se Repair Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an 20saab 9 5 Se Repair Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from 20saab 9 5 Se Repair Manual

- Personalized Recommendations
- 20saab 9 5 Se Repair Manual User Reviews and Ratings
- 20saab 9 5 Se Repair Manual and Bestseller Lists
- 5. Accessing 20saab 9 5 Se Repair Manual Free and Paid eBooks
 - 20saab 9 5 Se Repair Manual Public Domain eBooks
 - 20saab 9 5 Se Repair Manual eBook Subscription Services
 - 20saab 9 5 Se Repair Manual Budget-Friendly Options
- 6. Navigating 20saab 9 5 Se Repair Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - 20saab 9 5 Se Repair Manual Compatibility with Devices
 - 20saab 9 5 Se Repair Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of 20saab 9 5 Se Repair Manual
 - Highlighting and Note-Taking 20saab 9 5 Se Repair Manual
 - Interactive Elements 20saab 9 5 Se Repair Manual
- 8. Staying Engaged with 20saab 9 5 Se Repair Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers 20saab 9 5 Se Repair Manual
- 9. Balancing eBooks and Physical Books 20saab 9 5 Se Repair Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection 20saab 9 5 Se Repair Manual
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine 20saab 9 5 Se Repair Manual
 - Setting Reading Goals 20saab 9 5 Se Repair Manual
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of 20saab 9 5 Se Repair Manual

- Fact-Checking eBook Content of 20saab 9 5 Se Repair Manual
- Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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