



## Two-component paint system on (ply-)wood above the waterline

### General surface preparation

Make sure that the wood is dry and degreased. Oily, resinous types of wood, like pine and Oregon Pina must be well degreased before varnish or stain is applied. Wipe down the wood with Epifanes Spraythinner for Paint & Varnish or denaturated alcohol and allow to evaporate. Sand the wood to a fresh surface with dry abrasive paper P60-80. Subsequently sand with finer grits from P100 to P220. Always sand along the wood grain. Remove all sanding dust and degrease once more. Allow to fully evaporate before applying paint.

### Two-component paint system on wood above the waterline

| After surface preparation | Step 1   | Step 2  | Step 3   |
|---------------------------|--|---|--|
| <b>Product</b>            | EPIFANES<br>Epoxy Primer   | EPIFANES<br>Epoxy HB Coat                                   | EPIFANES<br>Poly-urethane Yacht Coating  |
| <b>Number of coats</b>    | 1  | 2   | 3  |
| <b>Verduunning</b>        | EPIFANES<br>Thinner D-601  | EPIFANES<br>Thinner D-601                                   | EPIFANES<br>Poly-urethane Thinner  |
| <b>Percentage</b>         | 25%  | 5-10%   | 0-5%   |
| <b>Drying time @18°C.</b> | 12 hours   | 6 hours   | 24 hours   |
|                           | P180 - 220 - dry   | P180 - 220 - dry  | P400 - wet   |
| <b>Remarks</b>            | Thin this first coat by 25% and apply with a stiff brush. If needed, fill with Epifanes Epoxy Filler 1500. | Sand with P180 if subsequent coat is applied after 48 hours | Thin first PU coat 5-10%. Within 48 hours without sanding. After 48 hours always sand. |