



Two-component paint system on fiberglass /GRP above the waterline

General surface preparation

Cleaning Start by cleaning the fiberglass surface with (warm) soapy water in order to remove all water-soluble dirt. After drying, degrease with Epifanes Fibreglass Prep Cleaner to remove all wax substances.

Sanding After cleaning, sand with P320 dry sandpaper and degrease once more with Epifanes Fibreglass Prep Cleaner.

Filling Check the fiberglass Fill small irregularities above the waterline with Epifanes Fibreglass Filler. Larger repairs can be filled with Epifanes Epoxy Filler. Also sand inside cracks and scratches to open them before filling. This will ensure better mechanical bonding. Direct after the filler has dried, sand with P280 dry, degrease with Epifanes Fibreglass Prep Cleaner and apply a 15% thinned primer or topcoat. This thinned sealer coat will prevent absorption of moisture and sinking of topcoats in the filler. After drying of the sealer coat, sand the area(-s) with P280 dry.

Product Epifanes Mono-urethane and Poly-urethane Yacht Paint may directly be applied on well degreased and sanded fiberglass without the use of a primer. However if fiberglass is showing small cracks and irregularities or a filler has been used, it is recommended to first apply a primer coat before topcoating. Also when using Epifanes the more traditional Epifanes Yacht Enamel as a topcoat, also first apply a primer coat.

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| After surface preparation | Step 1 | Step 2 |
|---------------------------|--|--|
| Product | EPIFANES Poly-urethane Primer | EPIFANES Poly-urethane Yacht Coating |
| Number of coats | 1 | 3 |
| Verdunning | EPIFANES Poly-urethane Thinner | EPIFANES Poly-urethane Thinner |
| Percentage | 5-10% | 0-5% |
| Drying time @18°C. | 6 hours | 24 hours |
| | P220 - dry | P400 - wet |
| Remarks | This primer coat is not necessary if gelcoat is intact and smooth. | Thin first PU coat 5-10%. Within 48 hours without sanding. After 48 hours always sand. |