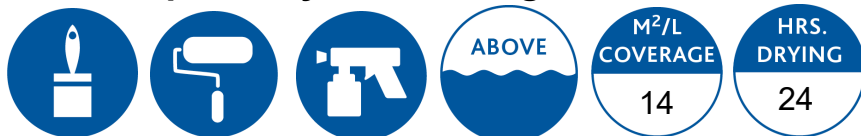


Epifanes Yacht Enamel

One-component yacht coating for above the waterline



PRODUCT DESCRIPTION

High gloss yacht coating with an unique flow characteristics. This paint is very easy to apply at all temperatures. offers good gloss retention and it is easy to maintain over time. Due to the high concentration of pigments, it gives a high covering power.

Field of use: In a new system for wood, steel and aluminium. GRP in combination with the appropriate primer.

Note: On GRP Epifanes Mono-urethane gives a better bonding. Also suited for maintenance of existing intact one- and two-component paint systems above the waterline regardless which brand.

PRODUCT INFORMATION

Type	Oxidative drying
Base	Linseed oil / alkyd resin
Gloss	High gloss
Colour	46 Standard colours. Custom made colours (RAL K7) are available on request
Density at 20°C.	950 - 1300 gr. / dm ³ depending on colour
Viscosity	45 - 50 seconds ISO-cup 6 mm
Solids Contents	50 - 55 ± 2 vol. %
VOC-level	371 gram/liter
Packing	750ml. - various colours also in 2000ml.
Shelf life	In closed unopened container stored in a dark location between 5 - 25°C approx. 3 years.
Rec. filmthickness	80 - 90 µm wet = 40 - 45 µm dry
Thinner brush	Epifanes Brushthinner for Paint & Varnish or a good quality white spirit
Thinner spray	Epifanes Spraythinner for Paint & Varnish or denaturated alcohol
Thinning in general	Thinning ratio depends on product temperature and working area. Avoid overthinning. For thinning ratios, refer to the Epifanes paint systems.

Drying times	10°C.	15°C.	20°C.	25°C.
Dust dry	5 hours	4 hours	3 hours	2 hours
Sandable/Recoatable	48 hours	30 hours	24 hours	20 hours

The above mentioned drying times are indicative at 65% RAH and 35 µm dry filmthickness. Drying also depends on the amount of ventilation and applied wet filmthickness. Higher wetfilmthickness and/or limited ventilation results in longer drying times. Especially flat surfaces may take longer to dry due to high wetfilmthickness. Allow each varnish coat sufficient time to dry. Do not apply wet-on-wet!

Theoretical coverage 14m² per liter @ 35 µm dry filmthickness

Practicle coverage Dependent on condition of substrate, loss of material due to factors such as application technique, shape of object, circumstances during application.



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APPLICATION

Conditions during application	Temperature	minimal 8°C. - maximal 30°C.
	Relative air humidity	minimal 50% - maximal 85%

Best results are achieved by roller, longhaired soft brush or by spray. Evenly distribute the paint over the surface and do not retipp. Do not apply wet-on-wet. Do not apply excessive wet film thickness to avoid the formation of curtains and drying problems. Avoid painting in direct sunlight or too much wind. A rapid loss of solvents will occur under these conditions and decrease the flowing ability. The maximum difference in temperature between the surface and the paint is 3°C. In case the product “pulls” and is difficult to apply, 10% Epifanes Brush thinner may be added. After drying, lightly sand the surface with P400 or Scotch Brite before applying the next coat. Always sand by hand.

Guidelines for spray application:

Thinning volume	Nozzle	Pressure	Visco DIN-cup 4 mm
5-15%	1.2 mm - 1.5 mm	2-3 Bar	20-22 sec.

Substrates	Bare GRP	Clean and degreased with Epifanes Fibreglass Prep Cleaner Sanded with P220-240
	Bare wood	Clean, dry and degrease with Epifanes Spraythinner for Paint & Varnish Sanded with P220-240
	Bare Steel	Clean, dry, free of corrosion and degreased with Epifanes Cleaning Solution Sanded with P60
	Existing paintwork	Well bonding, dry and degreased with Epifanes Spraythinner for Paint & Varnish Sanded with P220-240
Appropriate primer	All substrates	: Epifanes Multi Marine Primer - Epifanes Undercoat
	Wood	: Epifanes Woodprimer.
	New aluminium	: Epifanes Washprimer AQ

GRP	Steel	Wood	Aluminium
1 - 2 primer coats	3 primer coats	1 - 2 primer coats	1 - 2 primer coats

After curing, sand every primer coat with P180-220 before applying finishing coats

System build up
After priming, finish with 3 full bodied coats of Epifanes Yacht Enamel. Lightly sand between coats with P400 or Scotch Brite. For further information about the recommended Epifanes system build up. Visit our website and download the step-by-step system information.

Theoretical coverage
Practicle coverage
14m² per liter @ 35 µm dry filmthickness
Dependent on condition of substrate, loss of material due to factors such as application technique, shape of object, circumstances during application.

Recoatibility with other Epifanes products

Epifanes Mono-urethane Yacht Paint	Epifanes Satin Finish
Epifanes Non-skid deck coating	Epifanes Flat Black
Epifanes Nautiforte Yacht Paint	Epifanes Waterline Paint

Safety
The user of this product should obey all national laws and legislation concerning health, safety and environmental hazard. For more information on health and safety, refer to the Material Safety Data Sheet of this product.

Although the facts and suggestions in this product information sheet are based on our own research and field experiences and are believed reliable, we cannot simply be held responsible for performance or results obtained through the use of this product. Ineffectiveness or other unintended consequences may result, because of such factors as weather, conditions, presence or other materials or the manner of preparation, use or application all of which are beyond W. Heeren & Zoon's control. All such risks are assumed by user.

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