



EPIFANES MONOURETHANE

Hardest finish available in a one-part paint!

| | |
|-------------------------------------|---|
| Type | One component, air dry, ultra high gloss finish based on urethane alkyd resins. |
| Color | 19 colors. See Epifanes color chart. |
| Gloss | Ultra high gloss |
| Recommended use | Finishing coat for wood, steel, aluminum and fiberglass in conjunction with the appropriate primers. For exterior use above the waterline, topsides and interiors . Can be applied directly on thoroughly degreased and sanded fiberglass, one-component primers and top coats as well as on thoroughly sanded two-component polyurethane. This finish is not compatible with epoxy. |
| Film characteristics | This one-component urethane formulation was developed to provide the application ease of a traditional enamel with the hard durability of a urethane resin base. Fresh and salt water resistant, long lasting weather durability and gloss retention, rapid wet film drying. |
| Container Size | 750 ml. |
| Density | 0.95 - 1.30 kg./liter (dependent on color) |
| Solids Content | 50 - 55 +/- 2 vol. %. |
| Recommended film thickness | Per coat wet - 60 micron Per coat dry - 35 micron |
| Application | Brush, roller, conventional air spray, H.V.L.P., airless. |
| Drying times at 65F / 65% RH | Tack free - 1 hour Dry - 24 hours Tape free - 24 hours Recoatable - 24 hours |
| Spray Application | Conventional air: Thin as needed up to 15% with Epifanes Spray Thinner for Paint & Varnish. Spray viscosity 18 - 22 seconds Din Cup 4, 14 - 18 seconds Ford Cup 4. Nozzle 1.5 mm. - 1.8 mm. Pressure 2 - 3 Bar. |
| Additives | None |
| Application conditions | Temperature should be between 50F. and 85F. during application. Air humidity below 85%. Avoid painting in too much wind or sun. A rapid loss of solvents will occur under these conditions and will decrease the flowing ability. Add thinner up to the specified percentage to compensate for the faster release of solvents. Epifanes Monourethane is compatible with most other types of one-component alkyd or urethane based paints and over two-component paints. |

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Finishing Epifanes Monourethane

Surface Preparation: See leaflet Surface Preparation **Primer System:** Further details on various Epifanes Primers Sheets

| | Marine Plywood | Fiberglass | Steel | Aluminum |
|-----------------|------------------------|----------------------------|------------------------|---|
| Primer | Werdol Woodprimer | Epifanes Fiberglass Primer | Werdol Metalprimer | Epifanes Washprimer AQ +Epifanes Epigrond |
| Thinner | Epifanes Thinner P & V | Epifanes Thinner P & V | Epifanes Thinner P & V | n/a |
| Thinning Ratio | 0-5% | 0-5% | 0-5% | n/a |
| Number of Coats | one or two | one or two | at least three | one |
| Drying Time | 24 hours | 24 hours | 24 hours | 24-48 hours |
| Sanding Grit | 180-220 dry | 320 dry | 220 dry | n/a |

| Top-Coat | Product | Thinner (brush/roller) | Thinning Ratio % | Drying time at 65 F. | Abrasive Paper Grit | Coverage per ltr. | Thinner | Airspray | Airless |
|--------------|-----------------------|------------------------------|------------------|----------------------|---------------------|--------------------------|-----------|------------|--------------|
| First | Epifanes Monourethane | Epifanes Brush-thinner P & V | 5 | 24 hours | 320 | 160 sq. ft. 15 sq. m. | Ratio | 10-15% | 5-10% |
| At least two | Epifanes Monourethane | Epifanes Brush-thinner P & V | 0-5 | 24 hours | 400 | 160 sq. ft. 15 sq. m. | Viscosity | 18-22 sec. | 35-50 sec. |
| | | | | | | | DIN | Cup 4 | Cup 4 |
| | | | | | | | Nozzle | 1.5-1.8 mm | 0.011-0.013" |
| | | | | | | | Pressure | 2-3 bar | 80-100 bar |

Maintenance: If existing paint system is intact and only loss of gloss is noticed, one or more fresh coats of Epifanes Monourethane may be applied on a well cleaned degreased surface that is sanded with 320 grit wet or dry abrasive paper. A paint system in poor condition must be removed.