



## EPIFANES NAUTIFORTE

Highest gloss, non-yellowing, minimal dirt retention!

<b>Type</b>	One-component finish paint based on silicon reinforced modified alkyd resins.
<b>Color</b>	White, #24 Oyster, #25 Off white.
<b>Gloss</b>	Ultra high gloss. A degree of gloss is activated by exposure to Ultra Violet.
<b>Recommended use</b>	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 polyurethane.
<b>Film characteristics</b>	Superior flow, gloss and durability. Excellent flexibility and water resistance in all climatic conditions. Non-yellowing, minimal dirt retention. Easy application and rapid wet film drying. Optimum covering and filling capacity.
<b>Container Size</b>	750 ml., White also available in 2000 ml.
<b>Density</b>	1.18 kg./liter
<b>Solids Content</b>	50 +/- 2 vol. %
<b>Recommended film thickness</b>	Per coat wet - 70 micron Per coat dry - 35 micron
<b>Application</b>	Brush, roller, conventional air spray, H.V.L.P., airless.
<b>Drying times at 65F / 65% RH</b>	Tack free - 2 hours Dry - 24 hours Tape free - 18 hours Recoatible - 18 hours
<b>Spray Application</b>	Conventional air: Thin as needed up to 20% with Epifanes Spray Thinner for Paint & Varnish. Spray viscosity 18 - 22 seconds Din Cup 4. Nozzle 1.5 mm. - 1.8 mm. Pressure 2 - 3 Bar.
<b>Additives</b>	None (may effect gloss, flow or non-yellowing characteristics).
<b>Application conditions</b>	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 Nautiforte is compatible with most other types of one-component alkyd or urethane based paints and over two-component paints. Any existing finish must be intact, degreased and sanded prior to recoating.

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## Finishing Epifanes Nautiforte

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

	Wood / 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

Topcoat	Product	Thinner (brush/roller)	Thinning Ratio %	Drying time in hours at 65 F.	Abrasive Paper Grit	Coverage per ltr.	Thinner	Airspray	Airless
First	Epifanes Nautiforte	Epifanes Brush-thinner P & V	5	24	360	150 sq. ft. 14 sq. m.	Ratio	Sprayth. P. V	Sprayth. P. V
At least two	Epifanes Nautiforte	Epifanes Brush-thinner P & V	0-5	24	400	150 sq. ft. 14 sq. m.	Viscosity	20%	5%
							DIN	20-22 sec.	35-50 sec.
							Nozzle	Cup 4	Cup 4
							Pressure	0.12-0.16 mm	0.011-0.013”
								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 Epifanes Nautiforte 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.