



## EPIFANES YACHT ENAMEL

Flexibility and durability!

<b>Type</b>	One-component yacht coating based on oil modified alkyd resins.
<b>Color</b>	42 Colors. See Epifanes Color chart.
<b>Gloss</b>	Ultra high gloss.
<b>Recommended use</b>	Finishing coat for wood, steel, aluminum and fiberglass in conjunction with the appropriate primers. For interiors and exteriors above the waterline. Absolutely the best for traditional wood construction.
<b>Film characteristics</b>	Superior flow, gloss and durability. Excellent flexibility and water resistance in all climatic conditions. Fresh and salt water resistant. Vivid color brilliance. Outstanding wet edge and covering properties.
<b>Container Size</b>	All colors 750 ml. White also available in 2000 ml. and 4000 ml.
<b>Density</b>	0.95 - 1.30 kg./liter (dependent on color)
<b>Solids Content</b>	50 - 55 +/- 2 vol. % (dependent on color)
<b>Recommended film thickness</b>	Per coat wet 60 - 70 micron Per coat dry 30 - 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 - 3 hours Dry - 24 hours Tape free - 24 hours Recoatible - 24 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, 14 - 18 seconds Ford Cup 4. 1.5 mm. - 1.8 mm. Pressure 2 - 3 Bar.
<b>Additives</b>	Epifanes Accelerator, Epifanes Retarder
<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 Yacht Enamel 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 Yacht Enamel

**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 Epiground
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 Type	Coverage per ltr.	Thinner	Airspray	Airless
First	Epifanes Yacht Enamel	Epifanes Brush- thinner P & V	5	24	360 Wet	160 sq. ft. 15 sq. m.	Ratio	Sprayth. P. V 15-20%	Sprayth. P. V 5-10%
At least two	Epifanes Yacht Enamel	Epifanes Brush- thinner P & V	0-5	24	400 Wet	160 sq. ft. 15 sq. m.	Viscosity DIN	20-24 sec. Cup 4	35-50 sec. Cup 4
							Nozzle Pressure	1.6-1.8 mm 2-3 bar	0.011-0.013” 80-100 bar

**Maintenance:** If existing paint system is intact and only loss of gloss is noticed, one or more fresh coats Epifanes Yacht Enamel 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.