

Epifanes Mono-urethane Yacht Paint

Hard one-component high gloss yacht paint



PRODUCT DESCRIPTION

A hard, one-component, high gloss finishing yacht paint. Provides superior covering and filling, long lasting weather durability and high gloss retention. Offers rapid initial curing and provides (after through hardening) the application ease of a traditional enamel with the hard durability of an urethane resin based paint.

Field of use: FRP - Steel - Wood - Aluminium: suitable for interior and exterior use above the waterline in combination with the appropriate primer. Maintenance of existing one- and two-component systems regardless of brand. May also be applied on well degreased and sanded fiberglass without the use of a primer.

PRODUCT INFORMATION

Type	Oxidative drying
Base	Urethane resin / Alkyd resin
Gloss	High gloss
Colour	24 Standard colours. Custom made colours (RAL K7) are available on request
Density at 68°F.	0,95 - 1,30 g/cm ³ depending on colour
Viscosity	40 seconds ISO-cup 6 mm
Solids Contents	55 - 60 ± 2 vol. %
VOC-level	284 g/l
Packing	750ml. - Mono-urethane white also in 2000ml.
Shelf life	In closed unopened container stored in a dry room at temperatures between 41 - 86°F approx. 3 years.
Rec. Film thickness	2.5-3 mil wet = 1.5 mil dry
Thinner brush	Epifanes Brushthinner for Paint & Varnish or 100% mineral spirits (NOT low VOC).
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	50°F.	59°F.	68°F.	77°F.
Dust dry	6 hours	4 hours	3 hours	2 hours
Sandable/Recoatable	48 hours	36 hours	24 hours	18 hours

The above mentioned drying times are indicative at 65% RAH and 1.5 mil dry film thickness. Drying also depends on the amount of ventilation and applied wet film thickness. Higher wet film thickness and/or poor ventilation results in longer drying times. Especially horizontal parts may take longer to dry due to high wet film thickness. Allow each coat sufficient time to dry. Do not apply wet-on-wet!

Theoretical coverage 150ft² per liter @ 1.5 mil dry film thickness

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 47°F. - maximal 86°F.
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 films to avoid the formation of curtains and drying problems. Avoid painting in direct sunlight or much wind. A rapid loss of solvents will occur under these conditions and will decrease the flowing ability. The maximum difference in temperature between the surface and the paint is 38°F. In case the product “pulls” and is difficult to apply, 10% Epifanes Brush thinner may be added. After drying, lightly sand the surface with 320G 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	30-45 psi	20-22 sec.

Substrates	Bare GRP	Clean and degreased with Epifanes Fibreglass Prep Cleaner Sanded with 220G. On intact FRP no primer is needed.
	Bare wood	Clean, dry and degrease with Epifanes Spraythinner for Paint & Varnish Sanded with 220G. One or two primer coats
	Bare Steel	Clean, dry, free of corrosion and degreased with Epifanes Cleaning Solution Sanded with 60G. Three primer coats
	Existing paintwork	Well bonding, dry and degreased with Epifanes Spraythinner for Paint & Varnish Sanded with 220G. No primer is needed
Appropriate primer	All substrates	: Epifanes Multi Marine Primer - Epifanes Undercoat
	Wood	: Epifanes Woodprimer.
	New aluminium	: Epifanes Washprimer AQ (do not sand)

FRP	Steel	Wood	Aluminium
If needed 1 - 2 primer coats	3 primer coats	1 - 2 primer coats	1 - 2 primer coats

After curing, sand each primer coat with 220G before applying finishing coats

System build up After priming, finish with 3 full bodied coats of Epifanes Mono-urethane Yacht Paint. Lightly sand between coats with 320G 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 150ft² per liter @ 1.5 mil 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.

Recoatibility with other Epifanes products

Epifanes Yacht Enamel	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, we refer to the Material Safety Data Sheet of this product.

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