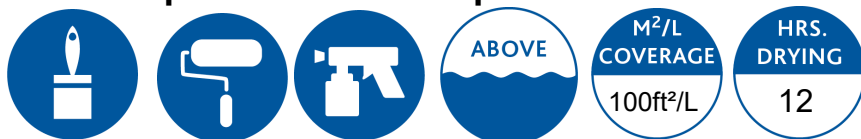


Epifanes Multi Marine Primer

One component all-in one primer



PRODUCT DESCRIPTION

Universal one component, fast drying and easy to sand primer for above the waterline. This primer has the ability to protect steel and aluminum surfaces, gives a perfect adhesion to FRP and a very good bonding to wood. With that ability it is a one step primer system for all surfaces above the waterline.

Field of use: Bare surfaces of wood, steel, aluminium, FRP, zinc or any other hard fabrics. Spot repair in one and two component systems. In combination with the Epifanes Washprimer AQ it is even applicable on glass. It is also possible to use this primer on top of painted surfaces to close the system down. With this primer it is possible to seal the current one-component system to make the switch to Epifanes Poly-urethane. It is highly recommended to sand the primer well before applying the first topcoat

PRODUCT INFORMATION

Type	Oxidative drying
Base	Modified epoxy resin
Gloss	Satin
Colour	White - Grey - Black - Redbrown
Density at 68°F.	1,250 - 1.350 g/cm³
Viscosity	35 seconds ISO-cup 6 mm
Solids Contents	50 ± 2 vol. %
VOC-level	465 g/l
Packing	750ml. - 2000 ml White and Grey also available in 4000 ml
Shelf life	In closed unopened container stored in a dry room at temperatures between 41 - 86°F approx. 3 years.
Rec. filmthickness	4 mil wet = 2 mil dry
Thinner brush	Epifanes Brushthinner for Paint & Varnish or 100% mineral spirits (NOT low VOC).
Thinner spray	Epifanes Spraythinner for Paint & Varnish or denatured 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 at 65% RLV	50°F.	59°F.	68°F.	77°F.
Dust Dry	2 hours	1.5 hours	1 hour	45 min.
Sandable/Recoatable	12 hours	8 hours	6 hours	3-4 hours
Recoatable with 1-C.	Min. 24 hours	Min. 18 hours	Min. 12 hours	Min. 10 hours
Recoatable with PU 2-C.	Min. 96 hours	Min. 72 hours	Min. 48 hours	Min. 48 hours

Attention! Do not apply the Multi Marine Primer at temperatures below 50°F. The above mentioned drying times are indicative at 65% RAH and 2 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 paint coat sufficient time to dry. Do not apply wet-on-wet!



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APPLICATION

Conditions during application Temperature **minimal 50°F. - maximal 86°F.**
 Relative air humidity **minimal 50% - maximal 85%**

Best results are achieved by using a roller, a longhaired soft brush or by spray. Evenly distribute the paint over the surface and do not retip. 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 that 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, firmly sand the surface with 220G before applying the next coat. Always sand fresh coats by hand.

Guidelines for spray application:

Thinning volume	Nozzle	Pressure	Visco DIN-cup 4 mm
10 - 15%	1.5 mm - 2.0 mm	45-60 psi	20 - 24 sec.

Surface In all cases the surface has to be clean, degreased and sanded.

FRP	Steel	Wood	Aluminium
Degrease with Epifanes Fiberglass Prep Cleaner	Degrease with Epifanes Cleaning Solvent or Acetone	Degrease with Epifanes Spray Thinner or Acetone	Degrease with Epifanes Cleaning Solvent or Acetone
Sand with 220G	Sand with 60G	Sand with 220G	Sand with 60G
1 - 2 coats	3 coats	1 - 2 coats	1 - 2 coats
First coat 5-10% thinned	First coat 20-25% thinned	First coat 20-25% thinned	First coat 15-20% thinned

- Additional remark** Sand every primer coat with dry sandpaper 220G. At new aluminium it is recommended to apply 1 coat of Epifanes Wasprimer AQ.
- Existing painted surface** Clean the surface well and degrease with Epifanes Spray Thinner. You may now sand the surface with 220G. Always clean and degrease again with Epifanes Spray Thinner.

When using the Epifanes Multi Marine Primer as a barrier coat for Poly-urethane, always apply at least 2 coats of Primer and let it cure for 72 hours at 68°F. When possible, let it cure for a week.
- Theoretical coverage** 100ft² per liter @ 1.75 mil dry film thickness.
- Practicle coverage** Practicle coverage is dependent on wet film thickness, the surface, application technique and use of any thinners.
- Recoatable one component** Epifanes Mono-urethane Yacht coating - Epifanes Bilgepaint
Epifanes Nautiforte Yacht Coating - Epifanes Yacht Enamel - Epifanes Satin Finish
- Recoatable two component** Epifanes Poly-urethane Yacht Coating - Epifanes Poly-urethane Primer
(Only possible after at least 72 hours curing at 68°F)
- Fillers** After 48 hours it is possible to apply Epifanes Combi Filler (1-C) or Epifanes Epoxy Filler 1500 (2-C).
- 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.

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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W. Heeren & Zoon BV
 Postbus 166
 1430 AD Aalsmeer
 tel. 0297 – 360366
 info@epifanes.nl
 www.epifanes.nl

