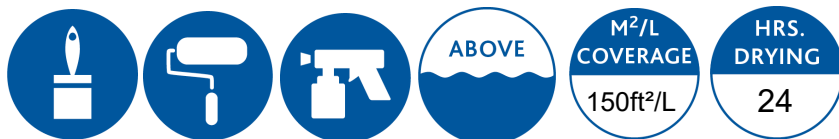


Epifanes Poly-urethane Yacht Coating

Two component high gloss PU paint with high end UV filters



PRODUCT DESCRIPTION

An extreme high gloss yacht paint using the latest UV filters. The UV filter protect against discoloration and prevents loss of gloss of the paint system. Suited to withstand all natural elements, even in tropical climates. This coating is scratch resistant and offers excellent water resistance. After full cure polishable. Note: when polishing it is advised to apply a final coat of Epifanes Poly-urethane Clear gloss..

Field of use: Suitable on all existent Epoxy and Poly-urethane paints regardless of brand. In a system of wood, steel and aluminum in combination with the appropriate primer. Can be applied directly to a FRP gelcoat without the use of a primer. On older gelcoat showing cracks, etc. always use an appropriate primer first.

PRODUCT INFORMATION

| | |
|-------------------------------|--|
| Type | Chemical drying |
| Base | Polyester resin with isocyanate hardener |
| Gloss | High gloss |
| Colour | 24 standard colours according to Epifanes colour fan (800-numbers) Custom made colours available in high gloss and satin (RAL K7 palette) |
| Density at 68°F. | 1,10 - 1,30 g/cm ³ |
| Viscosity | 30 seconds ISO-cup 6 mm |
| Solids Contents | 65 ± 2 weight % = 55 ± 2 vol. % |
| VOC-level | 467 g/l |
| Packing | 500gr. Component A + 250gr. Component B = 750gr. 2 kg. Component A + 1 kg. Component B. = 3 kg. |
| Shelf life | In closed unopened container stored in a dry room at temperatures between 41 - 86°F Base component A 3 years after production date Curing component B 1 year after production date |
| Rec. Film Thickness | 2-2.5 mil wet = 1-1.5 mil dry |
| Induction time @ 68°F. | 10 minutes |
| Thinner brush | Epifanes Poly-urethane Brush Thinner / Epifanes PU Slow Reducer |
| Thinner spray | Epifanes Poly-urethane Spray Thinner Note: for spray applications, use Epifanes PU Speedcoat instead |
| Thinning in general | Thinning ratio depends on product temperature and working area. Avoid overthinning. |

| Drying times | 50°F. | 59°F. | 68°F. | 77°F. |
|----------------------|----------|----------|----------|-----------|
| Dust dry | 4 hours | 3 hours | 2 hours | 1 hour |
| Sandable/Recoatable | 48 hours | 30 hours | 24 hours | 20 hours |
| Potlife after mixing | 5 hours | 4 hours | 3 hours | 1.5 hours |

The above mentioned drying times are indicative at 65% RAH and 1 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!



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APPLICATION

Conditions during application **Temperature** minimal 50°F. - maximal 86°F.
Relative air humidity minimal 50% - maximal 75%

Best results are achieved by using a longhaired soft brush or a foam roller. (replace foam rollers in time). Evenly distribute the paint on the surface without overworking the paint. Avoid retipping too much. 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. Avoid large difference in temperature of the product, surface to be painted and working area. In case the product "pulls" and is difficult to apply, 10% thinner may be added. After drying, lightly sand the surface with 320G.

TIP: Spray application is possible. However for best results by spray gun, we recommend Epifanes PU Speedcoat Colour. This professional PU Yacht Coating is dedicated to spray applications. See the technical datasheet.

Guidelines for spray application:

| Thinning volume | Nozzle RP | Pressure | Visco DIN-cup 4 mm |
|-----------------|-----------------|-----------|--------------------|
| 15-20% | 1.2 mm - 1.5 mm | 30-37 psi | 18-20 sec. |

SYSTEM BUILD UP

| | FRP* | Steel | Wood | Aluminium |
|---------------------|---|--|--|--|
| Primer** | Epifanes Epoxy Primer or Poly-urethane Primer | Epifanes Epoxy Primer or Epoxy HB coat | Epifanes Epoxy Primer or Epoxy HB coat | Epifanes Epoxy Primer Epoxy HB coat |
| Primer coats | 1-2 coats | 3 coats | 2 coats | 2 coats |
| PU coats | At least 3 coats Total of 4 mil dry | At least 3 coats Total of 4 mil dry | At least 3 coats Total of 4 mil dry | At least 3 coats Total of 4 mil dry |

Note * After degreasing with Epifanes Fibreglass Cleaner and sanding 220G, may be applied directly on intact FRP gelcoat without hair cracks, etc. without the use of a primer.

Note ** Sand final primer coat with 220G.

Existing paint work

After degreasing with Epifanes Cleaning Solvent and sanding 220G, also suited for maintenance of discoloured and/or dull PU finishes.

**Theoretical coverage
Practicle coverage**

150ft² per liter @ 1.5 mil dry filmthickness
 Dependent on condition of substrate, loss of material due to factors such as application technique, shape of object, circumstances during application.

Polishing

For extra high gloss or in case of polishing, finish by applying one or more coats Epifanes Poly-urethane Clear Gloss. Polishing: After full cure 7 days @ 68°F

Recoatable with itself

Within 24 - 48 hours without sanding. If applied after 48 hours, always sand with 220G. For a smoother finish, intercoat sanding with wetdry 320G is advised.

Recoatibility with other Epifanes topcoats

| | |
|-------------------------------------|---|
| Epifanes Yacht Enamel | 1-C High gloss alternative |
| Epifanes Mono-urethane Yacht Paint | 1-C High gloss alternative |
| Epifanes Satin finish | 1-C Matt finish for interior / exterior use |
| Epifanes Poly-urethane colour satin | 2-C Satin finish with UV Filter |
| Epifanes PU Speedcoat Colour | 2-C Spray finish for interior / exterior use with UV filter |

Safety

The user of this product should obey all 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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