

# Epifanes Multi Marine Primer

## One-component all-in-one-primer

<b>Type</b>	Air drying	
<b>Base</b>	Modified phenolic rosin alkyd resin / zinc phosphate	
<b>Properties</b>	A multi purpose tie-coat or sanding and adhesion primer combining all characteristics of separate substrate primers in one. Offers excellent adhesion to wood, fibreglass, steel, stainless steel, aluminium, galvanized metal, copper and most other bare or painted substrates. Features include exceptional covering capability, high build, good grain filling and corrosion prevention on steel.	
<b>Field of application</b>	GRP - Hard plastics - Steel - Wood - Aluminium - Zink: bonding and transition primer for interior and exterior use above the waterline. Repair and filling primer on existing one- and two-component primers/paints and fully cured, degreased and coarsely sanded epoxy layers. Transition coat between one-component and two-component PU finish and reverse.	
<b>Colours</b>	White - grey - redbrown - black	
<b>Gloss</b>	semi gloss	
<b>Density</b>	1,25 kg/dm <sup>3</sup>	
<b>Viscosity</b>	35 seconds ISO-cup 6 mm	
<b>Solids contents</b>	60 +/- 2 vol. %	
<b>VOC - level</b>	435 grams/liter	
<b>Packing</b>	750ml. - 2000ml. White and grey: also in 4000ml.	
<b>Shelf life</b>	In closed original container stored in a dark location between 5 - 25°C approx. 3 years.	
<b>Conditions during application and drying</b>	Temperature	minimal 10°C. - maximum 28°C.
	Relative air humidity	minimal 50% - maximum 75%
<b>Thinner for brush applications</b>	Epifanes Brushthinner for Paint & Varnish	
<b>Thinner for conv. spray applications</b>	Epifanes Spraythinner for Paint & Varnish	
<b>Thinner for airless spray applications</b>	Epifanes Thinner D-100	
<b>Application tools</b>	Moltopren foam roller, soft, longhaired brush or conventional air spray	
<b>Recommended filmthickness / coat</b>	80 µm wet = 45 µm dry Do not apply higher wet film.	
<b>Application recommendations</b>	<p>Stir well prior to use and during application. Do not overbrush. Do not apply wet-in-wet. Avoid excessive wet films to avoid the formation of curtains and through drying problems. Application by roller is advised.</p> <p>Avoid painting in direct sunlight or too much wind. A rapid loss of solvents will occur under these conditions and degrease the flowing ability. The application and drying should occur in well ventilated areas. Always secure sufficient air circulation for supply of fresh air and disposal of solvent fumes and in order to avoid drying problems.</p>	
<b>Theoretical coverage</b>	8-10m <sup>2</sup> per liter @ 45µm dry filmthickness	
<b>Practicle coverage</b>	Dependent on condition of substrate, loss of material due to factors such as application technique, shape of object, circumstances during application.	
<b>Substrate conditions</b>	Temperature of paint, object and work area during application and drying should not be lower than 10°C. Relative air humidity should not exceed 85%.	

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### Application details

	Air spray	Airless spray	Roller
Thinning volume	10 - 15%	0-8%	0-5%
Nozzle	1.5 mm-2.0 mm	0.015 - 0.018 "	
Pressure in bar	3 - 4	140-160	
Visc. DIN-cup 4 mm	20-24 sec.	60 - 80 sec.	

### Intercoat sanding

For necessary intercoat adhesion, sand every coat of Epifanes Multi Marine Primer with P180-220 dry abrasive paper.

### Drying times @ 20°C. / 65% RAH and 45 µm dry filmthickness

Dustdry	Sandable by hand	Recoatable	
2 hours	6 hours	1-comp. Finish	At least 12 hours
		2-comp. PU finish	At least 48 hours

### Substrate condition

GRP	Steel	Wood	Aluminium
Degreased and sanded with P 220-280 dry	Degreased and sanded with P 60 dry	Degreased and sanded with P 220-240 dry	Degreased and sanded with P 60 dry
1-2 coats	3 coats	1-2 coats depending on wood-grain	1-2 coats

### Remarks regarding primer system

On **new** aluminium, first apply one thin coat Epifanes Washprimer AQ.

### Previously painted surfaces

Well bonding, dry, clean, well degreased, sanded with P240-280 dry and dust free.

### Remarks regarding build up

If topcoated with Epifanes PU Yachtcoating. Every coat of Multi Marine Primer must dry for at 48 hours (20°C.). Preferably longer.

### Recoatability one-component

Epifanes Yacht Enamel - Epifanes Mono-urethane Yacht Paint  
 Epifanes Bilge Paint - Epifanes Nautiforte Yacht Paint  
 Epifanes Undercoat - Epifanes Multiforte

### Recoatability two-component

Epifanes Poly-urethane Yacht Coating  
 Epifanes Poly-urethane Primer

### Recoatability limitations

Do not apply epoxy based primers and/or coatings on Multi Marine Primer.

### Suitable filler

Epifanes Combi Filler (max. 1 mm per coat)  
 Epifanes Epoxy Filler 1500 (after 48 hours drying time)

### 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, refer to the Material Safety Data Sheet of this product.

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