Epifanes Epoxy Coating HS

Two-component epoxy body coating for use on steel, aluminium, (ply)wood and fiberglass (osmosis prevention & repair). For interior and exterior use, above and below the waterline - immersion in fresh and salt water. Excellent mechanical properties, high impact - and abrasion resistance.

Type: Drying and curing by reaction of components
Base: Epoxy resin and zinc phosphate
Colour: Light grey, blue, redbrown and black
Gloss: Semi gloss
Package: all colours 750 ml ; black and light grey also 4000 ml.
Density: 1.60 kg/dm³ (mixed product)
Solids content: 75 ± 2 vol.% (mixed product)

Drying times -100 µm wft = 50 dft at 20°C / 68ºF 65% RAH -

Dust dry	Tack free	Recoatable	Full cure
1 hour	2 hours	16 hours	7 days

Compatibility: Recoatable with all Epifanes epoxy and polyurethane based paints.

Mixing ratio

	By volume	By weight
Base (component A)	100	100
Cure (component B)	100	100

Potlife mixed produkt: 2 hours at 20°C / 68ºF
Application temperature: 10ºC / 50ºF minimum

Application

	Airless spray	Air spray	Brush / roller
Thinner	D-601	D-601	D-601
Volume.%	5 - 8	15 - 20	10 -15
Nozzle	0.021” - 0.023”	2.0 - 3.0 mm	
Pressure in Bar	200	3-5	

Coverage: 13 m² per litre @ 60 µm dry film thickness
Practical coverage is dependent on many factors, such as application method, roughness and condition of substrate, loss of material due to shape of object, conditions and circumstances during application, etc.

Guide lines for
brush application: 90% of TC
spray application: 70% of TC (large areas) - 50% of TC (small areas)

Recommended dry film thickness

Above water	Under water	Inside hull	Wet areas
200 micron	400 micron	150 micron	400 micron

Recommended primers

Steel	Epifanes Epoxy Primer
Aluminium	Epifanes Washprimer AQ
Fibreglass	Epifanes Epoxy Primer or Epifanes Interimcoat
Wood	No specific primer - apply first coat thinned approx. 25%

Surface conditions: Surface must be clean, degreased, dry, well sanded and free of dust.
Remove all salt and other water soluble dirt with fresh water. Remove grease and oil with water and ammonium solution or Epifanes Spraythinner for Paint and Varnish or other suitable detergent.

Application conditions: Temperature of paint, object and working area during application and drying should not be lower than 10ºC / 50ºF. Relative air humidity should not exceed 85%. Temperature of object during application and drying should be at least 3ºC / 38ºF above dew point.

Application tips: Subsequent coats, applied within 72 hours, can be thinned with Epifanes Thinner D-100. This slower evaporating thinner will allow a better flow.
If next coat is applied within 72 hours, no sanding is needed.
If this overcoating period is missed , first degrease the coat and sand with 180 grit abrasive paper used dry.