

Epifanes Yacht Enamel (all colours)

One-component traditional high gloss enamel

Type	Oxidative drying
Base	Linseed oil / modified alkyd resin
Properties	A high gloss, one-component, traditional marine finish. This enamel has very good flowing and covering properties and provides long lasting gloss retention and excellent weather durability.
Field of application	GRP - 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 which brand.
Colours	46 Standard colours according to colour fan. Custom made colours on request
Gloss	High gloss
Density	0,95-1,30 kg/dm ³ dependent on colour
Viscosity	110-120 seconds DIN-cup 4 mm dependent on colour
Solids contents	50-55 +/- 2 vol. %
VOC - level	371 grams/liter
Packing	750ml. - Various colours also in 2000ml.
Shelf life	In closed original container stored in a dark location between 5 - 25°C approx. 3 years.
Conditions during application and drying	Temperature minimal 10°C. - maximum 28°C. Relative air humidity minimal 50% - maximum 75%
Thinner for brush applications	Epifanes Brushthinner for Paint & Varnish
Thinner for spray applications	Epifanes Spraythinner for Paint & Varnish
Application tools	Soft, longhaired brush (oval or round style), foam roller or conventional air spray
Recommended filmthickness / coat	80-90 µm wet = 40-55 µm dry
Application recommendations	Stir well prior to use. Do not overbrush. Do not apply wet-in-wet. In order to secure ample wetfilm apply preferably by brush. If needed roll out by roller. Do not apply excessive wet films to avoid the formation of curtains and drying problems. Avoid painting in direct sunlight or too much wind. A rapid loss of solvents will occur under these conditions and decrease the flowing ability.
Theoretical coverage	15m ² per litre @ 40µm 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.
Substrate conditions	Intact well adhering cleaned, degreased and sanded, one- and two-component paint or primer systems

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Application details

	Air spray	Airless spray	Brush
Thinning volume	10 %	0-8%	0-5%
Nozzle	1.3 mm-1.8 mm	0.013 - 0.015 "	
Pressure in bar	3	140-160	
Visc. DIN-cup 4 mm	20-22 sec.	60 - 80 sec.	

For necessary intercoat adhesion and a smoother finish, lightly sand every coat of Epifanes Yacht Enamel with P400 wet abrasive paper. Preferably by hand.

Drying times @ 20°C. / 65% RAH and 40 µm dry filmthickness

Dustdry	Sandable	Recoatable
3 hours	24 hours	24 hours

Preferred primer build up

GRP	Steel	Wood	Aluminium
Epifanes Multi Marine Primer			
1-2 coats	3 coats	1-2 coats	1-2 coats

Other suitable primers

Existing layers - Epifanes Undercoat
 Fibreglass - Epifanes Fibreglass Primer
 Steel - Epifanes Metalprimer
 Wood - Epifanes Woodprimer

Remark regarding primer system

Sand every primer coat with P 220 dry. On **new** aluminium, first apply one thin coat Epifanes Washprimer AQ.

Application advise

If needed, thin down up to 10% to enhance the flowing ability. More coats will provide deeper lustre and provide additional UV protection. On wood always apply along the wood grain and allow sufficient time to settle. Avoid retipping.

Recoatable with

Epifanes Mono-urethane Yacht Paint - Epifanes Nautiforte Yacht Paint
 Epifanes Nonskid Deckcoating - Epifanes Waterline Paint
 Epifanes Multiforte

For longterm outdoor durability and gloss retention a total of 100-120 µm dry filmthickness should be applied. This equals 3 coats (4 coats if applied by roller)

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, 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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