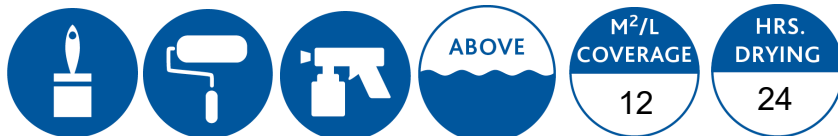


Epifanes Poly-urethane Yacht Coating

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 GRP 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 + RAL 9010) Custom made colours available in high gloss and satin (RAL K7 and maritime related)
Density at 20°C.	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 5 - 30°C Base component A 3 years after production date Curing component B 1 year after production date
Rec. Film Thickness	60 - 70 µm wet = 35 - 40 µm dry
Induction time @ 20°C.	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	10°C.	15°C.	20°C.	25°C.
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 35 µm dry filmthickness. Drying also depends on the amount of ventilation and applied wet filmthickness. Higher wet filmthickness and/or poor ventilation results in longer drying times. Especially horizontal parts may take longer to dry due to high wet filmthickness. Allow each coat sufficient time to dry. Do not apply wet-on-wet!



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APPLICATION

Conditions during application Temperature minimal 10°C. - maximal 30°C.
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 P360-400.

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	2-2.5 Bar	18-20 sec.

SYSTEM BUILD UP

	GRP*	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 100 µm dry	At least 3 coats Total of 100 µm dry	At least 3 coats Total of 100 µm dry	At least 3 coats Total of 100 µm dry

Note * After degreasing with Epifanes Fibreglass Cleaner and sanding P220, may be applied directly on intact GRP gelcoat without hair cracks, etc. without the use of a primer.

Note ** Sand final primer coat with P180-220.

Existing paint work

After degreasing with Epifanes Cleaning Solvent and sanding P220, also suited for maintenance of discoloured and/or dull PU finishes.

**Theoretical coverage
Practicle coverage**

14m² per liter @ 40 µm 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 @ 20°C

Recoatable with itself

Within 24 - 48 hours without sanding. If applied after 48 hours, always sand with P220. For a smoother finish, intercoat sanding with waterproof P360 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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