

# Epifanes Bilge Paint

One-component protecting paint for use in bilge spaces, engine rooms, etc. where a tough paint system is required. For use on steel, wood, fibreglass and aluminium in conjunction with the appropriate one-component primer system.

Type	Air drying
Base	Oil modified alkyd resins.
Colour	White and grey
Gloss	Semi gloss
Density	1.30 kg/dm <sup>3</sup>
Viscosity	120-130 seconds Din Cup 4 mm.
Solids content	55 ± 2 vol.% (dependent on colour)
Drying times at 20°C. / 65%RAH	dust dry after 3 hours, recoatable after 24 hours

Application	Airless spray	Air spray	Brush/roller
Vol.% thinner	5 - 10	15 - 20	0 - 5
Nozzle	0.011" - 0.013"	1.5 - 1.8 mm	
Pressure ( Bar )	80 - 100	2 - 3	
Visc. Din Cup 4mm	35 - 50	20 - 24	120

Thinner	
- spray application	Epifanes Spraythinner for Paint & Varnish
- brush/roller application	Epifanes Brushthinner for Paint & Varnish

Theoretical coverage	13,75 m <sup>2</sup> per litre @ 40 µm dryfilmthickness
Practicle coverage	Dependent on application methode, kind and condition of substrate, loss of material due to shape of object, circumstances during application, etc.

Recommended wetfilmthickness Application	70 - 80 µm, ( = 35 - 40 µm dryfilmthickness ) Do not apply wet-on-wet and do not apply too high a wetfilmthickness in order to avoid the formation of curtains and drying problems
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Recommended primers	Wood	Werdol Woodprimer
	Steel	Werdol Metalprimer
	Fibreglass	Epifanes Fibreglass Primer
	Aluminium	Epifanes Washprimer AQ + Epigrond Prelacquer

Substrate conditions	
- Untreated bilges	Well clean bilge with a powerful detergent. Remove all leftovers of (gas-) oil, smut , etc. by adding a suitable detergent to the bilge water that will break down biologically. Allow the mixture 1 hour before removing it. Well clean the bilge with fresh water.
- Primer coats	Well cleaned, degreased, dry, sanded and free of dust.
- Existing coats	If bilge has already been painted, remove all loose parts. Well clean, degrease and sand. Surface must be dry and free of dust.

Application guide lines	Before applying, stir thoroughly. 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 health hazards 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.
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Application conditions	Temperature of paint, object and work area during application and drying should not be lower than 5°C. Relative air humidity should not exceed 85%. Temperatrure of object during and drying should be at least 3°C above dew point.
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