

# Epifanes Yacht Enamel

Classic Yacht Enamel for interior and exterior use on wood, steel fibreglass and aluminium above the waterline in conjunction with the appropriate primers. Provides excellent flow, wet edge and covering properties. Vivid colour brilliance. Outstanding gloss, weather durability and gloss retention. Sweet- and salt water resistant

Type	Air drying																				
Base	Oil modified alkyd resins.																				
Colour	Standard range of colours according to Epifanes colour chart.																				
Gloss	Ultra high gloss																				
Density	0.95 - 1.30 kg/dm <sup>3</sup> ( dependent on colour )																				
Viscosity	40 seconds Din Cup 6 mm.																				
Solids content	50 - 55 ± 2 vol.% ( dependent on colour )																				
Drying times at 20°C. / 65% RAH	dust dry after 3 hours, recoatable after 24 hours																				
Application	<table border="1"> <thead> <tr> <th></th> <th>Airless spray</th> <th>Conv. air spray</th> <th>Brush/roller</th> </tr> </thead> <tbody> <tr> <td>Vol.% thinner</td> <td>5 - 10</td> <td>15 - 20</td> <td>0 - 5</td> </tr> <tr> <td>Nozzle</td> <td>0.011" - 0.013"</td> <td>1.5 - 1.8 mm</td> <td></td> </tr> <tr> <td>Pressure ( Bar )</td> <td>80 - 100</td> <td>2 - 3</td> <td></td> </tr> <tr> <td>Visc. Din Cup 4mm</td> <td>35 - 50</td> <td>20 - 24</td> <td>120</td> </tr> </tbody> </table>		Airless spray	Conv. 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
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Thinner																					
- spray application	Epifanes Spraythinner for Paint & Varnish																				
- brush/roller application	Epifanes Brushthinner for Paint & Varnish																				
Theoretical coverage	15 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	70 - 80 µm, ( = 35 - 40 µm dryfilmthickness )																				
Application	Do not apply wet-on-wet and do not apply excessive wet films in order to avoid the formation of curtains and drying problems.																				
Sanding	<u>Lightly sand between coats with wetordry abrasive apasper nr. 400</u>																				
Recommended primers	<table border="1"> <tbody> <tr> <td>Wood</td> <td>Werdol Woodprimer</td> </tr> <tr> <td>Steel</td> <td>Werdol Metalprimer</td> </tr> <tr> <td>Fibreglass</td> <td>Epifanes Fibrerglass Primer</td> </tr> <tr> <td>Aluminium</td> <td>Epifanes Washprimer AQ + Epigrond Prelacquer</td> </tr> </tbody> </table>	Wood	Werdol Woodprimer	Steel	Werdol Metalprimer	Fibreglass	Epifanes Fibrerglass Primer	Aluminium	Epifanes Washprimer AQ + Epigrond Prelacquer												
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Substrate conditions																					
- primer coats	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.																				
- existing coats																					
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.																				
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%. Temperature of object during and drying should be at least 3°C above dew point.																				