

# Epifanes Monourethane

A one-component urethane yacht paint for interior and exterior use on wood, steel fibreglass and aluminium above the waterline in conjunction with the appropriate primers. Provides (after through hardening) the application ease of a traditional enamel with the hard durability of a urethane resin base. Provides excellent covering properties, vivid colour brilliance, outstanding gloss, weather

Type	Air drying
Base	Urethane resin / alkyd resin.
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	120 - 140 seconds Din Cup 4 mm.
Solids content	50 - 55 ± 2 vol.% ( dependent on colour )
Drying times at 20°C. / 65% RAH	dust dry - 1 hour recoatable - 24 hours
Application :	

	Airless spray	Air spray	Brush/roller
Vol.% thinner	5 - 10	15 - 20	0 - 5
Nozzle	0.011" - 0.013"	1.4 - 1.8 mm	
Pressure ( Bar )	80 - 100	2 - 3	
Visc. Din Cup 4mm	35 - 50	20 - 24	

Thinner  
- spray application  
- brush/roller application

Epifanes Spraythinner for Paint & Varnish  
Epifanes Brushthinner for Paint & Varnish

Theoretical coverage  
Practicle coverage

15 m<sup>2</sup> per litre @ 40 µm dryfilmthickness  
Dependant 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 excessive wet films in order to avoid the formation of curtains and drying problems.

Sanding

Lightly sand between coats with wetordry abrasive paper nr. 400

Recommended primers

Wood	Werdol Woodprimer
Steel	Werdol Metalprimer
Fibreglass #	Epifanes Fibreglass Primer
Aluminium	Epifanes Washprimer AQ + Epigronnd Prelacquer

# : May be directly applied on well degreased and sanded fibreglass.

Substrate conditions  
- primer coats  
- existing 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.

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%.  
Temperatrure of object during and drying should be at least 3°C above dew point.