

# Epifanes Waterline paint

One component paint, especially designed for use at the waterline on full paint systems on wood, steel fibreglass and aluminium. Outstanding gloss, weather durability and gloss retention. Sweet- and salt water resistant. It is recommended to strike the boot top 5-10 cm above the waterlevel at full loaded ship, to avoid constant immersion in water.

Type	Air drying
Base	Modified urethane/alkyd resins.
Colour	White, Blue #7, Red #16, Black #19 and Green #218
Packaging	250 ml
Gloss	High gloss
Density	1.00 - 1.30 kg/dm <sup>3</sup> ( dependent on colour )
Viscosity	120 seconds Din Cup 4 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

	Air spray	Brush and roller
Vol.% thinner	15 - 20	0 - 5
Nozzle	1.5 - 1.8 mm	
Pressure ( Bar )	2 - 3	
Visc. Din Cup 4mm	20 - 24	120

## Thinner

- spray application
- brush/roller application

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

## Theoretical coverage

3.75 m<sup>2</sup> per 250 ml @ 40 µm dft

## Practicle coverage

Dependent on application methode, kind and condition of substrate, loss of material due to shape of object, circumstances during application, etc.

## Filmthickness per coat

70 - 80 µm wft = 35 - 40 µm dft.

## 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.

## Intercoat sanding

Lightly sand between coats with wetordry abrasive paper nr. 400

## Sanding when overcoating :

Product	Min. drying time at 20°C before taping	Sanding
Epifanes Yacht Enamel	7 days	320 wetordry
Epifanes Monourethane	7 days	320 wetordry
Epifanes Nautiforte	7 days	320 wetordry
Epifanes Polyurethane	4 days	220 wetordry

Remove tape within 1 hour after applying the waterline paint.

## Substrate conditions

- existing coats

Remove all salt and other water soluble dirt with fresh water. Remove grease and oil with water and ammonium solution or Epifanes Spray-thinner 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%. Temperature of object during and drying should be at least 3°C above dew point.