



## Two-component paint system on steel above the waterline

### General surface preparation

#### Cleaning

Make sure that the steel surface is dry and all dirt, wax or other contamination have been removed.

#### Rust removal and sanding

Steel surface must be free of rust and mill scale. Preferably by sandblasting SA 2,5. If sandblasting is not possible, sand the entire surface manually or by machine using P60-80 dry abrasive paper. If necessary use Tercoo disc.. All welding spots/drops must be removed and sharp edges must be grinded round. Areas that are difficult to derust should be prepared with Epifanes Rust Remover.

After cleaning, derusting and sanding, apply the first (thinned) primer coat as soon as possible to ensure the least amount of renewed oxidation. The temperature of the (bare) steel must at least 3°C (41°F.) above the dew point

#### Filling

Above the waterline fill irregularities with Epifanes Epoxy Filler. After the filler has dried, sand with P180-220 dry. Apply the filler between sanded primer coats.

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After surface preparation	Step 1	Step 2	Step 3
Product	EPIFANES Epoxy Primer	EPIFANES Epoxy HB Coat	EPIFANES Poly-urethane Yacht Coating
Number of coats	1	2	3
Verduunning	EPIFANES Thinner D-601	EPIFANES Thinner D-601	EPIFANES Poly-urethane Thinner
Percentage	25%	5-10%	0-5%
Drying time @18°C.	12 hours	6 hours	24 hours
	P180 - 220 - dry	P180 - 220 - dry	P400 - wet
Remarks	Thin this first coat by 25% and apply with a stiff brush. If needed, fill with Epifanes Epoxy Filler 1500.	Sand with P180 if subsequent coat is applied after 48 hours	Thin first PU coat 5-10%. Within 48 hours without sanding. After 48 hours always sand.