



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

### Preparation of aluminium

New aluminum has a greasy residue on the surface which must be removed (do not sand). Use Epifanes Spraythinner for Paint & Varnish for degreasing aluminium. On new aluminium we recommend applying one thin coat Epifanes Washprimer AQ. The Washprimer AQ provides excellent adhesion for the first primer coat on aluminium.

Although aluminum hardly corrodes, a thin layer of oxidation can be formed which must be removed. The existing aluminum surface must therefore be well degreased and sanded with 80 dry. Apply first coat Epifanes Multi Marine Primer (one-component) or Epifanes Epoxy Primer (two-component) as soon as possible.

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

| After surface preparation | Step 1   | Step 2  | Step 3                 | Step 4   |
|---------------------------|--|---|------------------------|--|
| <b>Product</b>            | EPIFANES Washprimer AQ   | EPIFANES Epoxy Primer   | EPIFANES Epoxy Primer  | EPIFANES Poly-urethane Yacht Coating                             |
| <b>Number of coats</b>    | 1  | 1   | 2                      | 3  |
| <b>Thinner</b>            | Do not thin  | EPIFANES Thinner D-601  | EPIFANES Thinner D-601 | EPIFANES Poly-urethane Thinner                                   |
| <b>Percentage</b>         | -  | 25%   | 5-10%                  | 0-5%   |
| <b>Drying time @ 18°</b>  | 2 hours  | 12 hours  | 12 hours               | 24 hours   |
|                           | Do not sand  | P180 - 220 - dry  | P180 - 220 - dry       | P400 -wet  |
| <b>Remarks</b>            | Use Epifanes Washprimer AQ only on new aluminium . If used, apply thin coats and avoid curtains. | If needed, fill between primer coats with Epifanes Epoxy Filler 1500. |                        | If recoated within 48 hours, sanding is not absolutely required. |