

# Epifanes Bilge Paint

One-component tough paint for bilges, etc.



## PRODUCT DESCRIPTION

A protecting one-component paint for use in bilge spaces, engine rooms etc. where a tough paint system is required. Can be applied over most substrates with one-component primer systems.

**Field of use:** In a new system for wood, steel, GRP and aluminium in combination with the appropriate primer. Fiberglass/GRP - Steel - Wood - aluminum: Bilges, chain lockers and other wet areas in conjunction with the appropriate primer system.

## PRODUCT INFORMATION

<b>Type</b>	Air drying
<b>Base</b>	Modified alkyd resin
<b>Gloss</b>	Semi gloss
<b>Colour</b>	White - Grey
<b>Density at 20°C.</b>	1,27 g/cm <sup>3</sup>
<b>Viscosity</b>	40 seconds ISO-cup 6 mm
<b>Solids Contents</b>	50-55 ± 2 vol. %
<b>VOC-level</b>	347 gr./l
<b>Packing</b>	750ml. –2000ml.
<b>Shelf life</b>	In closed unopened container stored in a dry room at temperatures between 41-86°F approx. 3 years.
<b>Rec. filmthickness</b>	2.5-3 mil wet = 1.5 - 1.75 mil dry
<b>Thinner brush</b>	Epifanes Brushthinner for Paint & Varnish or a good quality white spirit
<b>Thinner spray</b>	Epifanes Spraythinner for Paint & Varnish or denaturated alcohol
<b>Thinning in general</b>	Thinning ratio depends on product temperature and working area. Avoid overthinning. For thinning ratios, we refer to the Epifanes paint systems.

Drying times	50°F	59°F	68°F	77°F
Dust dry	4 hours	3 hours	2 hours	1,5 hours
Sandable/Recoatable	48 hours	36 hours	24 hours	18 hours

The above mentioned drying times are indicative at 65% RAH and 1.5 mil dry filmthickness. Drying also depends on the amount of ventilation and applied wet filmthickness. Higher wet filmthickness and/or poor ventilation results in longer drying times. Especially horizontal parts may take longer to dry due to high wet filmthickness. Allow each coat sufficient time to dry. Do not apply wet-on-wet!

**Theoretical coverage** 100ft<sup>2</sup> per liter @ 1.5 mil dry film thickness

**Practicle coverage** Dependent on condition of substrate, loss of material due to factors such as application technique, shape of object, circumstances during application.



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## APPLICATION

<b>Conditions during application</b>	<b>Temperature</b>	<b>minimal 47°F - maximal 86°F</b>
	<b>Relative air humidity</b>	<b>minimal 50% - maximal 85%</b>

Best results are achieved by using a roller, longhaired soft brush or by spray. Evenly distribute the paint over the surface and do not retipp. Do not apply wet-on-wet. Do not apply excessive wet films to avoid the formation of curtains and drying problems. Avoid painting in direct sunlight or much wind. A rapid loss of solvents will occur under these conditions and will decrease the flowing ability. The maximum difference in temperature between the surface and the paint is 5°F. In case the product “pulls” and is difficult to apply, 10% Epifanes Brush thinner may be added. After drying, lightly sand the surface with P400 or Scotch Brite before applying the next coat. Always sand fresh coats by hand.

### Guidelines for spray application:

Thinning volume	Nozzle	Pressure	Visco DIN-cup 4 mm
10-15%	1.5 mm - 1.8 mm	2-3 Bar	20-24 sec.

<b>Substrates</b>	<b>Bare GRP</b>	Clean and degreased with Epifanes Fibreglass Prep Cleaner Sanded with P220-240 and apply 1 primer coat first.
	<b>Bare wood</b>	Clean, dry and degreased with Epifanes Spraythinner for Paint & Varnish Sanded with P220-240 and apply 1 or 2 primer coats first.
	<b>Bare Steel</b>	Clean, dry, free of corrosion and degreased with Epifanes Cleaning Solution Sanded with P60 and apply 3 primer coats first.
	<b>Existing paintwork</b>	Well bonding, dry and degreased with Epifanes Spraythinner for Paint & Varnish Sanded with P220-240
<b>Appropriate primer</b>	All substrates	: Epifanes Multi Marine Primer - Epifanes Undercoat
	Wood	: Epifanes Woodprimer.
	New aluminium	: Epifanes Washprimer AQ

GRP	Steel	Wood	Aluminium
1 - 2 primer coats	3 primer coats	1 - 2 primer coats	1 - 2 primer coats

	After curing, sand every primer coat with P180-220 before applying finishing coats		
<b>Bilge conditions</b>	Clean bilge thoroughly with a powerful and suitable cleaner. Remove any remaining oil, diesel or rust by adding a biodegradable Thoroughly flush bilge with fresh water and allow to fully dry.		
<b>Recoatibility with other Epifanes products</b>	Epifanes Mono-urethane Yacht Paint Epifanes Non-skid deck coating Epifanes Nautiforte Yacht Paint	Epifanes Yacht Enamel Epifanes Flat Black Epifanes Waterline Paint	
<b>Safety</b>	The user of this product should obey all national laws and legislation concerning health, safety and environmental hazard. For more information on health and safety, we refer to the Material Safety Data Sheet of this product.		

Although the facts and suggestions in this product information sheet are based on our own research and field experiences and are believed reliable, we cannot simply be held responsible for performance or results obtained through the use of this product. Ineffectiveness or other unintended consequences may result, because of such factors as weather, conditions, presence or other materials or the manner of preparation, use or application all of which are beyond W. Heeren & Zoon's control. All such risks are assumed by user.

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W. Heeren & Zoon BV  
PO box 166  
1430 AD Aalsmeer  
Netherlands  
Phone +31 297 – 360366  
info@epifanes.nl  
www.epifanes.nl

