

# Epifanes PU Speedcoat Colour

A professional topcoat finish for spray applications



## PRODUCT DESCRIPTION

A professional two-component high gloss finish with outstanding flowing properties. Dedicated to spray application with extremely short overcoating times. Provides long lasting gloss retention and is scratch - and weather resistant. After full cure polishable.

**Field of use:** Solely for spray application on FRP / Steel / Aluminum / Plywood. Protecting finish for interior and exterior use in combination with the correct priming system. This product is **not** suited for brush/roller applications.

## PRODUCT INFORMATION

|                               |   |
|-------------------------------|---|
| <b>Type</b>                   | Chemical drying   |
| <b>Base</b>                   | Acrylic poly-ol   |
| <b>Gloss</b>                  | Extreme high gloss  |
| <b>Colours</b>                | On request: Epifanes colours, maritime related colours and RAL colours  |
| <b>Density at 68°F.</b>       | 1,10 - 1,30 g/cm³ depending on colour   |
| <b>Viscosity</b>              | 40 seconds ISO-cup 4 mm   |
| <b>Solids Contents</b>        | 40 ± 2 vol. % by volume - 50 ± 2 vol. % by weight   |
| <b>VOC-level after mix</b>    | 569 g/l   |
| <b>Packing</b>                | 2 kg. Component A + 1 kg. Component B. = 3 kg   |
| <b>Shelf life</b>             | In closed unopened container stored in a dry room at temperatures between 41 - 86°F<br>Component A: 3 years after production date - Component B: 1 year after production date         |
| <b>Mixing ratio by weight</b> | 2 parts base component A : 1 part curing component B  |
| <b>Mixing instructions</b>    | Well stir base component A prior to adding curing component B. Stir both components together for at least 5 minutes to a homogeneous substance. (2 minutes with mechanical stirring). |
| <b>Thinner</b>                | Slow : Epifanes PU Speedcoat Spray Thinner<br>Fast : Epifanes Poly-urethane Spray Thinner   |
| <b>Thinning guideline</b>     | Add thinner after mixing both components. Thinning ratio depends on product temperature and working area. Avoid overthinning.   |
| <b>Induction time 68°F.</b>   | 10 minutes  |
| <b>Rec. film thickness</b>    | 2-2.5 mil wet = 1 mil dry   |

| Drying times         | 59°F.     | 68°F.    | 77°F.     |
|----------------------|-----------|----------|-----------|
| Dust dry             | 1.5 hours | 1 hour   | 1 hour    |
| Recoatible           | 2 hours   | 1 hour   | 1 hour    |
| Sandable             | 30 hours  | 24 hours | 20 hours  |
| Potlife after mixing | 4 hours   | 3 hours  | 1.5 hours |

The above mentioned drying times are indicative at 65% RAH and 1 mil dry film thickness. Drying also depends on the amount of ventilation and applied wet film thickness. Higher wet film thickness and/or limited ventilation result in longer drying times. Especially horizontal parts may take longer to dry due to high wet film thickness.

**Substrate conditions** Well cured, cleaned, degreased, sanded, intact two component paint systems. In new systems, build up with Epifanes Epoxy Primers and Epifanes Poly-urethane Primer.  
Polishing: After 1 week at 68°F.



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### APPLICATION

|                                      |                              |                                      |
|--------------------------------------|------------------------------|--------------------------------------|
| <b>Conditions during application</b> | <b>Temperature</b>           | <b>minimal 59°F. - maximal 86°F.</b> |
|                                      | <b>Relative air humidity</b> | <b>minimal 50% - maximal 75%</b>     |

This product is dedicated to spray application by conventional air, HVLP and RP spray guns. Finest results however are achieved by RP gun. Evenly distribute the coating on the surface. Do not apply excessive wet films to avoid the formation of curtains and drying problems. Avoid large difference in temperature of the product, surface to be coated and working area. Wet-on-wet application is possible when the solvents have evaporated. When applying a subsequent coat after 48 hours, always sand.

#### Guidelines for spray application:

|                  | Thinning volume | Nozzle          | Pressure  | Visco DIN-cup 4 mm |
|------------------|-----------------|-----------------|-----------|--------------------|
| Air / HVLP spray | 15-20%          | 1.2 mm - 1.6 mm | 37-50 psi | 17 - 20 seconds    |
| RP spray         | 15-20%          | 1.1 mm - 1.3 mm | 30-37 psi | 17 - 20 seconds    |

|                                 |   |                 |  |
|---------------------------------|---|-----------------|--|
| <b>Application remarks</b>      | Airless spray not advised. Pressure feed paint container: Pot life will be shortened due to temperature increase in the container. Before spraying, check filter house and filters on contamination.  |                 |  |
| <b>Theoretical coverage</b>     | 130ft² per kg. @ 1 mil dry film thickness   |                 |  |
| <b>Practicle coverage</b>       | Dependent on condition of substrate, loss of material due to factors such as applica-<br>tion technique, shape of object, circumstances during application.   |                 |  |
| <b>Recoatability wet-on-wet</b> | With itself after 60-90 minutes @ 68°F.   |                 |  |
| <b>Recoatability</b>            | For additional gloss and depth one or more coats Epifanes PU Speedcoat Clear<br>Gloss may be applied on top of Epifanes PU Speedcoat Colour.<br>This is also recommended in case of polishing.  |                 |  |
| <b>Polishing</b>                | After 7 days @ 68°F.  |                 |  |
| <b>Intercoat sanding</b>        | Not required (wet-on-wet application.)<br>Only sand if subsequent coat is applied after 48 hours @ 68°F.  |                 |  |
| <b>System build up</b>          | <b>Amount of coats</b>  | 3 coats or more |  |
|                                 | <b>Film thickness per coat wet</b>  | 2-3 mil wft     |  |
|                                 | <b>Film thickness per coat dry</b>  | 1-1.5 mil dft   |  |
|                                 | <b>Total film thickness</b>   | 3.5-4.5 mil dft |  |
| <b>Safety</b>                   | The user of this product should obey all all national laws and legislation concerning<br>health, safety and environmental hazard. For more information on health and safety,<br>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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