PAINTING GUIDE

by aemme colori Dal 1947
INDUSTRIA VERNICI E SMALTI

Contents

GENERAL TIPS

In order to get best results when painting a boat, whether old or new, before and during maintenance work it is very important to comply with the relevant basic rules . So let's not forget that….

The best way to guarantee a professional finish and take full advantage of all the products featured is proportional to the time and care dedicated to the preparation of the surface to be coated.

A careful and scrupulous surface preparation of the substrate to be coated followed by the application of Skipper's products will enable you to achieve the best result for your boat, both from an aesthetic and practical point of view, as well as a long lasting finish. At the risk of being repetitive we would like to remind you of the basic procedures essential for a good result.

Dampen the area surrounding the boat in order to prevent dust from settling on the freshly painted surfaces.

Do not apply in the bright sunshine because all paints, especially topcoats, could wrinkle, bubble or flow poorly due to accelerated solvent evaporation causing the top layer to cure quickly while leaving the undercoat soft.

Do not paint when raining or when the temperature is lower than 5°C, or when the relative humidity is higher than 80% as it may slow the drying time causing sagging problems or flatten the gloss due to condensation caused by high humidity.

In particular, the anticorrosive paints should not be applied when raining or misty because they would suffer a substantial loss of anticorrosion power. Two component paints, epoxy or polyurethane based, should not be applied when the temperature is lower than 10°C.

Never apply a two-component product over a one-component product.

Only use our recommended thinners at the specified thinning ratio. Do not add other material which would affect the characteristics of the paint and the final result.

Stir thoroughly before application to remove any pigment sedimentation and provide an even mixture (especially for anticorrosive paints). Paint tins must be kept tightly closed when not in use. All equipment should be cleaned with suitable thinner.

Allow 15-20 minutes waiting period after mixing two-component products (A+B) before starting application and use the mixture within the specified Pot Life (after which the product's composition is altered and not suitable for further use).

All surfaces to be coated should be adequately prepared, cleaned and degreased before starting paint application. A clean surface is a necessary requirement in order to obtain the desired adhesion, protection and durability. Sanding between coats is always recommended to provide good adhesion between the different coats of paint and throughout the entire coating system.

WOODEN BOATS

Wood is a natural material that has been used for boat construction since ancient times. It makes maintenance work more demanding, but gives the boat a unique look of class and elegance

TOPSIDES AND SUPERSTRUCTURES TREATMENT

BARE SURFACES

Wood affected by mould or subjected to very damp conditions over a long period of time tends to deteriorate. It is therefore particularly important to ensure that moisture does not exceed 13% and that wood is dry and well degreased, especially resinous types of wood such as pine. Before applying any type of paint or varnish, clean the wood properly with methylated spirit and sand thoroughly using 60/80 grit dry sandpaper. Repeat sanding with 100/120 grit sandpaper and proceed with the advised painting system.

PREVIOUSLY PAINTED SURFACES

In good conditions. If the existing paint is in good condition and it only needs to be repainted because it is dull, dirty or slightly powdering but with good adhesion to the substrate with no cracking or blisters, then it is possibile to proceed with thorough cleaning and degreasing followed by a suitable sanding with medium-fine sandpaper (180-240 grit). Thoroughly remove all dust and sanding residue and apply 1 to 3 coats of enamel or varnish compatible with the pre-existing paint.

In poor conditions. If the existing paint is in poor maintenance condition with cracking or flaking parts, it is then necessary to remove the old paint back to bare wood, by scraping, sanding (80-100 grit) or with Svernigraf paint remover . Then proceed with the surface preparation as described for BARE SURFACES and follow up with the recommended painting system.

Coating systems for new or restored boats

One-component enamel coating system

N° coats	Product	Brush/Roller		Spray/Airless spray		Recoat time (hours)	Coverage m²/lt	Dry film thickness µm
		Dilution	Thinner	Dilution	Thinner			
1	EVIOX CROMOMINIO	25-35%	107	35-40%	107	24	7-9	40-50
1	SINTOFILLER	0%	(107)	0%	(107)	24-48	5	120
2	SOTTOFONDO NAUTICA	10- 20%	107	20-30%	900	18-24	9-10	40-50
2	TOPKAPI ENAMEL (or): SINTLAC ENAMEL	10- 20%	107/109	10-25%	900	18-24	11-13	40-50

Two-component enamel coating system

N° coats	Product	Brush/Roller		Spray/Airless spray		Recoat time (hours)	Coverage m²/lt	Dry film thickness µm
		Dilution	Thinner	Dilution	Thinner			
1	EPOWOOD	Ready to use	765	Ready to use	765	12-24	12-15	20
2	EPOFOND AM-9	10-15%	765	15-25%	765	12-24	8-9	50
1	POLIFOND	15-30%	205	25-35%	203	12-24	14-15	35-40
2	ACRIGLASS (or):	15-25%	205	20-35%	203	24	10	40
2	SPACE TOP (or):	20-30%	201/205	20-35%	205/203	18-24	13-14	40
2	WHITEXT	5-10%	205	5-10%	203	24	5-6	100

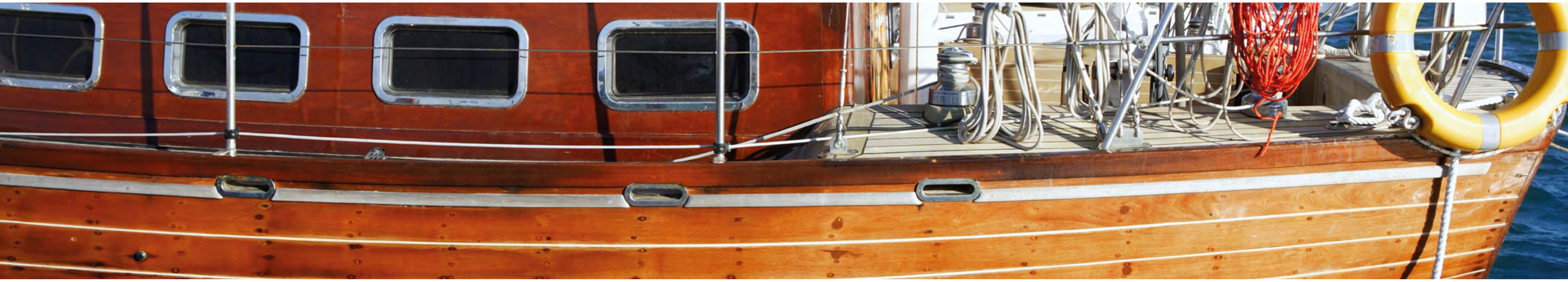
TOPSIDES AND SUPERSTRUCTURES

One-component clear varnish coating system

N° coats	Product	Brush/Roller		Spray/Airless spray		Recoat time (hours)	Coverage m²/lt	Dry film thickness µm
		Dilution	Thinner	Dilution	Thinner			
1	POLIGLASS	50-100%	205	50-100%	203	8-10	10	20
1	POLIGLASS (or):	20-30%	205	20-30%	203	8-10	10	20
1	POLIGLASS GEL UV	10-15%	205	10-20%	203	8-10	8	60
4-8	TOPKAPI UV (or):	10-15%	107/109	10-20%	900	24	12-14	40
4-8	STARWIND UV	10-15%	107/109	10-20%	900	24-48	12-13	40

Two-component clear varnish coating system

N° coats	Product	Brush/Roller		Spray/Airless spray		Recoat time (hours)	Coverage m²/lt	Dry film thickness µm
		Dilution	Thinner	Dilution	Thinner			
1	POLIGLASS	50-100%	205	50-100%	203	8-10	10	20
4-6	POLIGLASS (or):	20-30%	205	20-30%	203	8-10	10	20
2-3	POLIGLASS GEL UV	10-15%	205	10-20%	203	8-10	8	60
4-6	ACRIGLASS UV (or):	10-15%	205	20-30%	203	24	10-12	40
4-6	SPACE CLEAR UV (or):	10-15%	201/205	10-20%	205/203	24	12	35
2	POLISATIN (or):	0-5%	205	5-10%	203	8-12	8	40
2	POLIMAT	5-10%	205	10-20%	203	8-12	8	40



HULL TREATMENT BELOW THE WATERLINE

PREVIOUSLY PAINTED SURFACES

In good conditions. If the pre-existing antifouling is in good condition, you generally only need to remove any powdering or loose parts of the old antifouling paint with fine grit sandpaper and proceed with the application of 2 coats of new antifouling compatible with the pre-existing paint. If the old antifouling is of unknown nature we recommend to apply one coat of Solver Primer intermediate undercoat before applying the new antifouling paint.

In poor conditions. If the old paint is in poor maintenance condition, it will be necessary to completely remove the old antifouling paints back to bare wood by scraping or by using Svernigraf or Stripcarena-water-soluble paint remover.
After thoroughly cleaning, degrease and sand the surface and follow up with the recommended painting system. Surface uneveness, cavities or holes in the wood near the screws can be filled in with Polistuk or Epoxy light filler.

Coating systems for new or restored boats

BELOW THE WATERLINE

One-component coating system

N° coats	Product	Brush/Roller		Spray/Airless spray		Recoat time (hours)	Coverage m²/lt	Dry film thickness µm
		Dilution	Thinner	Dilution	Thinner			
1	EVIOX CROMOMINIO	25-35%	107	35-40%	107	24	7-9	40-50v
3	SOLVER PRIMER	10-25%	400	15-30%	400	6-12	4-6	60-70
2-3	ANTIFOULING	0-5%	400	5-8%	400	8-12	9-10	40-60

Two-component coating system

N° coats	Product	Brush/Roller		Spray/Airless spray		Recoat time (hours)	Coverage m²/lt	Dry film thickness µm
		Dilution	Thinner	Dilution	Thinner			
1	EPOWOOD	Ready to use	765	Ready to use	765	12-24	12-14	20
2	EPOFOND AM-9	10-15%	765	15-25%	765	12-24	8-9	50
1	SOLVER PRIMER	10-25%	400	15-30%	400	6-12	4-6	60-70
2-3	ANTIFOULING	0-5%	400	5-8%	400	8-12	9-10	40-60

STAR TEAK LINE

The wide range of products available for wood treatment is completed by the Star Teak line, which consists of three products specially formulated for tropical woods like teak, mahogany and iroko. These types of wood are not usually coated with painting products, but in order to keep their natural appearence they require maintenance to withstand ageing, due to sun exposure.
The Star Teak line includes three practical and effective products:
Star Teak Cleaner: formulated to remove traces of salt, oil stains and grease from teak surfaces.
Star Teak Brightener: used to brighten the colour of wood and remove any blackish or greyish shades caused by ageing due to sun exposure.
Star Teak Sealer: for the protection and maintenance of teak and other exotic woods; it penetrates deeply into the wood fibres enhancing its natural appearence. A UV version is also available.

AGED TEAK

It is advisable not to treat external teak surfaces with traditional varnishes; this is because exotic woods contain particular substances that if released could lead to peeling, crazing or blistering problems and also performing slippery surface when wet.

Our line includes two types of teak sealer. One is completely colourless and has UV filters (particularly suitable for new teak) . The other has an amber hue and is useful for restoring aged and greying teak. Both giving the surface a silky finish and a soft tread.
The range is completed by a bleaching solution for *brightening* greying teak and a cleaner for removing oils and grease.

Wet the wood surface with fresh water and apply S.T Cleaner evenly over the surface, diluted with 3 or more parts of water. Leave on for a few seconds, then scrub vigorously with a scrubbing brush and finally rinse the surface with fresh water. Do not use wire brushes as they may leave residue that could oxidise and stain the wood.

After cleaning the surface it may be necessary to brighten the colour of wood or remove any grey or blackened areas due to ageing; in that case apply Star teak Brightener evenly with a paint brush over the wet surface.

Allow the Brightener to rest on the surface for a few minutes, and then scrub the surface with a nylon brush (do not use wire brushes) to increase the brightening action of the product. Finally rinse the surface with plenty of fresh water and allow the surface to dry. The process can be repeated if required. Do not apply the brightener in hot direct sunlight.

The surface should be clean, dry and lightly sand papered; remove all dirt and dust before the application of Star Teak Sealer. Apply one coat of S.T.Sealer at least once a year by either brush or a soft cloth evenly on to the surface and allow to dry for 24 hours. If the wood is particularly dry, it may be necessary to repeat the application process several times, waiting 1 to 2 hours between each application.

Coating systems for new teak

TEAK

N° coats	Product	Brush/Pad		Spray/Airless spray		Recoat time (hours)	Coverage m²/lt	Dry film thickness µm
		Dilution	Thinner	Dilution	Thinner			
4	STARTEAK SEALER	-	-	-	-	2	10	for sealing the wood

Coating systems for restoring aged teak

TEAK

N° coats	Product	Brush/Pad		Spray/Airless spray		Recoat time (hours)	Coverage m²/lt	Dry film thickness µm
		Dilution	Thinner	Dilution	Thinner			
1	STARTEAK CLEANER	300%	Water	-	-	0	10	-
2	STARTEAK BRIGHTENER	-	-	-	-	0	10	-
2-3	STARTEAK SEALER	-	-	-	-	2	10	for sealing the wood

STEEL BOATS

Steel is a material used to build large boats.
It is preferred to fibreglass for its impact resistance, although it has a significant effect on the weight of the boat and tends to develop corrosion

TOPSIDES AND SUPERSTRUCTURES

BARE SURFACES

It is of the utmost importance to adequately prepare the surface as this will significantly influence the outcome of the whole painting process.
All surfaces to be coated must be free from rust, fouling or traces of oil. The best way to ensure that a surface is suitably prepared is to sandblast it carefully to SA 2.5 standard. If it is not possible to carry out this procedure, it is recommended to scrub the surface with wire brushes, scrapers or sanders in order to remove all traces of rust. Traces of grease, oil and dust may be removed by degreasing with a suitable solvent. Proceed then with the painting step by following our recommended coating system.

PREVIOUSLY PAINTED SURFACES

In good conditions. If the existing paint is in good condition and there is no rust, cracking or blistering within the current coating system and you only need to overcoat the old paint, it is recommended to thoroughly clean, degrease and sand the coated surface with a medium-fine abrasive paper (180-240 grit) in order to provide a suitable adhesion. All dust and sanding residues should be thoroughly removed from the surface before painting. Then apply 1 to 3 coats of topcoat enamel compatible with the pre-existing paint.

In poor conditions. If the old paint is in poor condition of maintenance with cracking or flaking paint or showing traces of corrosion, it is then necessary to completely remove the old paint back to bare steel with Svernigraf remover. Then proceed with surface preparation as described above for “BARE SURFACES” and follow up with the suggested coating system.

Coating systems for new or restored boats

TOPSIDES AND SUPERSTRUCTURES

One-component coating system

N° coats	Product	Brush/Roller		Spray/Airless spray		Recoat time (hours)	Coverage m²/lt	Dry film thickness µm
		Dilution	Thinner	Dilution	Thinner			
1	EVIOX CROMOMINIO	25-35%	107	35-40%	107	24	7-9	40-50
2	SOLVER PRIMER	10-25%	400	15-30%	400	6-12	4-6	60-70
2	SOTTOFONDO NAUTICA	10- 20%	107	20-30%	900	18-24	9-10	40-50
2	TOPKAPI ENAMEL (or): SINTLAC ENAMEL	10- 20%	107/109	10-25%	900	18-24	11-13	40-50

Two-component coating system

N° coats	Product	Brush/Roller		Spray/Airless spray		Recoat time (hours)	Coverage m²/lt	Dry film thickness µm
		Dilution	Thinner	Dilution	Thinner			
1	EPOFOND AM-9	10-15%	765	15-25%	765	12-24	8-9	50
1	EPOXY LIGHT FILLER	-	-	-	-	24-48	2	500
1	EPOFOND AM-9	10-15%	765	15-25%	765	12-24	8-9	50
2	POLIFOND	15-30%	205	25-35%	203	12-24	14-15	35-40
2	ACRIGLASS (or):	15-25%	205	20-35%	203	24	10	40
2	SPACE TOP* (or):	20-30%	201/205	20-35%	205/203	18-24	13-14	40
2	WHITEXT	5-10%	205	5-10%	203	24	5-6	100

* Use Thinner 201 with temperatures above 23°C or Thinner 205/203 with temperatures below 23°C.

HULL TREATMENT BELOW THE WATERLINE

PREVIOUSLY PAINTED SURFACES

In good conditions. If the existing paint is in good condition, it is generally enough to remove any powdering or loose parts of the old antifouling paint with fine grit sandpaper and proceed with the application of 2 coats of new antifouling paint compatible with the old paint. If you do not know what type of antifouling paint was used, we recommend that you firstly apply 2 coats of Solver Primer as an intermediate undercoat before applying the new antifouling paint.

In poor conditions. If the existing paint is in poor condition of maintenance or an excessive number of paint layers have built up, it will be necessary to completely remove the old antifouling paints down to bare steel by scraping or by using Svernigraf or Stripcarena paint remover. Then proceed with surface preparation as described above for "BARE SURFACES" and follow up with the recommended coating system.

Coating systems for new or restored boats

BELOW THE WATER LINE

One-component coating system

N° coats	Product	Brush/Roller		Spray/Airless spray		Recoat time (hours)	Coverage m²/lt	Dry film thickness µm
		Dilution	Thinner	Dilution	Thinner			
2	EVIOX CROMOMINIO	12-25%	107	15-30%	107	24	7-9	40-50
2	SOLVER PRIMER	10-25%	400	15-30%	400	6-12	4-6	60-70
2-3	ANTIFOULING	0-5%	400	5-8%	400	8-12	9-10	40-60

Two-component coating system

N° coats	Product	Brush/Roller		Spray/Airless spray		Recoat time (hours)	Coverage m²/lt	Dry film thickness µm
		Dilution	Thinner	Dilution	Thinner			
2	EPOFOND AM-9	10-15%	765	15-25%	765	12-24	8-9	50
2	SOLVER PRIMER	10-25%	400	15-30%	400	6-12	4-6	60-70
2-3	ANTIFOULING	0-5%	400	5-8%	400	8-12	9-10	40-60

Coating system for propellers, flaps and stern drives

N° coats	Product	Brush/Roller		Spray/Airless spray		Recoat time (hours)	Coverage m²/lt	Dry film thickness µm
		Dilution	Thinner	Dilution	Thinner			
1	ELIPRIMER 2C	20-35%	765	20-35%	765	12-24	8-9	30-40
2	CONTENDER ELICHE	0-5%	400	5%	400	24	8	50

FIBREGLASS BOATS

Fibreglass is by now commonly used in the manufacturing of small, medium and medium-large boats. It is easy to process, it does not weigh much and can be used to build boats that are much lighter than those made from steel or wood

TOPSIDES AND SUPERSTRUCTURES

BARE SURFACES

Fibreglass boats may have moulding defects which can cause surface irregularities in the finished product. This in turn means that over time the surface will become less waterproof leading to the "osmosis" problem, which will be dealt with a separate chapter.
For this reason, it is necessary to degrease the surfaces of new boats using suitable cleaners by wiping with cloths dampened with synthetic Thinner 107 (replace with new cloths regularly). Then thoroughly sand the surfaces with medium-fine grit sandpaper in order to provide suitable adhesion for the following coats.

PREVIOUSLY PAINTED SURFACES

In good conditions. If the existing paint is in good condition and there is no rust, cracking or blistering within the current coating system and you only need to overcoat the old paint, it is recommended to thoroughly clean or degrease the coated surface with synthetic thinner 107 and sand with medium-fine sandpaper (180-240 grit)
All dust and sanding residues should be thoroughly removed from the surface before overcoating. Then apply 1 to 3 coats of topcoat enamel compatible with the pre-existing paint.

In poor conditions. If the old paint is in poor condition of maintenance with cracking or flaking paint, it is then necessary to completely remove the old paint with either a remover such as Stripcarena or by scraping or sand papering. Then proceed with surface preparation as described for "BARE SURFACES" and follow up with the recommended coating system.

Coating systems for new or restored boats

TOPSIDES AND SUPERSTRUCTURES

One-component enamel coating system

N° coats	Product	Brush/Roller		Spray/Airless spray		Recoat time (hours)	Coverage m²/lt	Dry film thickness µm
		Dilution	Thinner	Dilution	Thinner			
1	UNIFIBER	0-5%	765	10-20%	765	6-12	10	15
2	SOTTOFONDO NAUTICA	10-20%	107	20-30%	900	18-24	9-10	40-50
2	TOPKAPI ENAMEL (or): SINTLAC ENAMEL	10- 20%	107/109	10-25%	900	18-24	11-13	40-50

Two-component enamel coating system

N° coats	Product	Brush/Roller		Spray/Airless spray		Recoat time (hours)	Coverage m²/lt	Dry film thickness µm
		Dilution	Thinner	Dilution	Thinner			
1	POLIFIBER (or):	15-30%	203/205	25-35%	203	18-24	10	50
1	EPOFOND AM-9	15-30%	205	25-35%	203	12-24	14-15	35-40
1	POLIFOND	15-30%	205	25-35%	203	12-24	14-15	35-40
2-3	ACRIGLASS (or):	15-25%	205	20-35%	203	24	10	40
2-3	SPACE TOP* (or):	20-30%	201/205	20-35%	205/203	18-24	13-14	40
2-3	WHITEXT	5-10%	205	5-10%	203	24	5-6	100

*Use Thinner 201 with temperatures above 23°C or Thinner 205/203 with temperatures below 23°C.

HULL TREATMENT BELOW THE WATERLINE

PREVIOUSLY PAINTED SURFACES

In good conditions. If the existing paint is in good condition, it is generally enough to remove any powdering or loose parts of the old antifouling paint with fine grit sandpaper and proceed with the application of 2 coats of new antifouling paint compatible with the old paint. If you do not know what type of antifouling paint was used, we recommend the application of 2-3 coats of Solver Primer intermediate undercoat before applying the new antifouling paint.

In poor conditions. If the existing coating is in poor conditions of maintenance, it will be necessary to remove the old antifouling paints completely, by scraping, or by wet or dry sandpapering. Paint stripping can only be carried out using Stripcarena paint remover, suitable for fibreglass surfaces. (Do not use Svernigraf paint remover since it could damage the gelcoat layer). Then prepare the surface as previously described for BARE SURFACES and follow up with the recommended painting system.

Coating systems for new or restored boats

BELOW THE WATERLINE

One-component coating system

N° coats	Product	Brush/Roller		Spray/Airless spray		Recoat time (hours)	Coverage m²/lt	Dry film thickness µm
		Dilution	Thinner	Dilution	Thinner			
1	UNIFIBER	0-5%	765	10-20%	765	6-12	10	15
1	SOLVER PRIMER	10-25%	400	15-30%	400	6-12	4-6	60-70
2-3	ANTIFOULING	0-5%	400	5-8%	400	8-12	9-10	40-60

Two-component coating system

N° coats	Product	Brush/Roller		Spray/Airless spray		Recoat time (hours)	Coverage m²/lt	Dry film thickness µm
		Dilution	Thinner	Dilution	Thinner			
1	POLIFIBER	15-30%	203/205	25-35%	203	18-24	10	50
1	SOLVER PRIMER	10-25%	400	15-30%	400	6-12	4-6	60-70
2-3	ANTIFOULING	0-5%	400	5-8%	400	8-12	9-10	40-60

ALUMINIUM AND LIGHT ALLOYS BOATS

Aluminium is a material used for medium and medium-small sized boats. Its main characteristic is the absolute resistance to corrosion and a lighter weight compared to steel and wooden boats

TOPSIDES AND SUPERSTRUCTURES

BARE SURFACES

Fibreglass is a difficult material to be coated. It is therefore extremely necessary to degrease the substrate properly with solvents or even better with a mild solution of phosphoric acid. Remove aluminium oxides from the surface by mechanical sanding or light sandblasting . Only apply epoxy based primers suitable for difficult surfaces like Epofond AM-9. Particular care must be taken when choosing the antifouling paint. This must be formulated with copper thiocyanate instead of copper oxide in order to avoid galvanic interactions which may corrode and in some cases even pierce the aluminium substrate.

PREVIOUSLY PAINTED SURFACES

In good conditions. If the existing paint is in good condition and it only needs to be repainted because it is dull, dirty or slightly powdering but still with good adhesion to the substrate with no cracking or blisters, then it is possibile to proceed with thorough cleaning and degreasing followed by a suitable sanding with medium-fine sandpaper (180-240 grit). Thoroughly remove all dust and sanding residue and apply 1 to 3 coats of topcoat enamel compatible with the pre-existing paint.

In poor conditions. If the existing paint is in poor condition of maintenance with cracking or flaking paint, it is then necessary to completely remove the old paint back to bare aluminium by scraping, sanding with coarse grit sandpaper (80-100) or stripping with Svernigraf paint remover. Then prepare the surface as previously described for BARE SURFACES and follow up with the recommended painting system.

Coating systems for new or restored boats

TOPSIDES AND SUPERSTRUCTURES

One-component enamel coating system

N° coats	Product	Brush/Roller		Spray/Airless spray		Recoat time (hours)	Coverage m²/lt	Dry film thickness µm
		Dilution	Thinner	Dilution	Thinner			
2	EPOFOND AM-9	10-15%	765	15-25%	765	12-24	8-9	50
2	SOLVER PRIMER	10-25%	400	15-30%	400	6-12	4-6	60-70
1	SOTTOFONDO NAUTICA	10-15%	107	15-20%	107	6-12	4-8	50-60
2	TOPKAPI ENAMEL (or): SINTLAC ENAMEL	10- 20%	107/109	10-25%	900	18-24	11-13	40-50

Two-component enamel coating system

N° coats	Product	Brush/Roller		Spray/Airless spray		Recoat time (hours)	Coverage m²/lt	Dry film thickness µm
		Dilution	Thinner	Dilution	Thinner			
1	EPOFOND AM-9	10-15%	765	15-25%	765	12-24	8-9	50
1	EPOXY LIGHT FILLER	0%	(765)	0%	(765)	24-48	2	500
1	EPOFOND AM-9	10-15%	765	15-25%	765	12-24	8-9	50
2	POLIFOND	15-30%	205	25-35%	203	12-24	14-15	35-40
2-3	ACRIGLASS (or):	15-25%	205	20-35%	203	24	10	40
2-3	SPACE TOP* (or):	20-30%	201/205	20-35%	205/203	18-24	13-14	40
2-3	WHITEXT	5-10%	205	5-10%	203	24	5-6	100

*Use Thinner 201 with temperatures above 23°C or Thinner 205/203 with temperatures below 23°C.

HULL TREATMENT BELOW THE WATERLINE

PREVIOUSLY PAINTED SURFACES

In good conditions. If the existing paint is in good condition, it is generally enough to remove any powdering or loose parts of the old antifouling paint with fine grit sandpaper and proceed with the application of 2 coats of new antifouling paint compatible with the old paint. If you do not know what type of antifouling paint was used, we recommend to apply one coat of Solver Primer intermediate undercoat before applying the new antifouling paint.

In poor conditions. If the existing coating is in a poor conditions of maintenance, it will be necessary to remove the old antifouling paints completely back to bare aluminium by scraping or by using Svernigraf paint remover. Then prepare the surface as previously described for BARE SURFACES and follow up with the recommended painting system.
Please note: according to our painting system for aluminium hulls, we advise to use only antifouling paints free from copper oxides and labelled with the wording "STC", meaning that they are suitable for aluminium and light alloys.

Coating systems for new or restored boats

BELOW THE WATERLINE

Two-component coating system

N° coats	Product	Brush/Roller		Spray/Airless spray		Recoat time (hours)	Coverage m²/lt	Dry film thickness µm
		Dilution	Thinner	Dilution	Thinner			
2	EPOFOND AM-9	10-15%	765	15-25%	765	12-24	8-9	50
2	SOLVER PRIMER	10-25%	400	15-30%	400	6-12	4-6	60-70
2-3	ANTIFOULING STC	0-5%	400	5-8%	400	8-12	9-10	40-60

ANTI-OSMOSIS TREATMENT

Osmosis is a flaw to which the hulls of fibreglass boats are susceptible. This problem occurs due to a poor moulding process, producing a non-perfect waterproof surface

CURING

Once the boat has been removed from the water, wait at least 60 days until it is completely dry. Remove all air bubbles and swellings by light sandblasting or mechanical sanding, and extend this to the surrounding areas.
Remove all residues of the old paint and wash the surface with fresh water.
Let the surface dry for 30/60 days. During this time wash the surface frequently in order to remove any residual matter originating from the fibreglass.
Before proceeding with the treatment, use the appropriate device to make sure that the humidity level does not exceed 10%.
Later on, after having ensured that the surface is dry and free of moisture, apply the first coat of Eposealer Antiosmosis with a stiff bristle paint brush, painting over the cavities several times where the bubbles have been removed to reach a thickness of at least 200 microns wet.
Leave to dry for 24 hours and sand down with wet sandpaper.
If cavities are particularly deep, it will be necessary to add Tecnocel microfibres to Eposealer Antiosmosis in a +100/200% ratio until you obtain a strong, high density filler, that will be

suitable to definetely fill up the cavities. Press the product firmly to prevent gaps forming. After 18/24 hours, apply a second coat of Eposealer Antiosmosis and if necessary, a third coat, allowing the recommended recoating time between coats.

PREVENTION

The application of EPOFOND H.B. two-component epoxy primer to a new fibreglass boat allows you to effectively prevent problems related to osmosis. To obtain maximum protection, first we advise to degrease the gelcoat surface and sand it with medium grit sandpaper. Once the preparation procedure has been carried out, apply 2-3 coats of EPOFOND H.B. to build up a total dry film thickness of approx. 150-200 microns. (For new boats we advise however to wait at least a month before proceeding with the prevention treatment). EPOFOND H.B. may also be used as a basecoat or intermediate coat in coating systems below the waterline without sanding.
When overcoated with two-component paints within 30 days provides outstanding adhesion on any type of surface.
If overcoated with one-component paints, including antifouling paints, a recoat time of 6-8 hours at temperatures exceeding 20°C or 12-24 hours at temperature between 10 and 20°C should be allowed.

Anti-osmosis coating systems

BELOW THE WATERLINE

Anti-osmosis "prevention system"

N° coats	Product	Brush/Roller		Spray/Airless spray		Recoat time (hours)	Coverage m²/lt	Dry film thickness µm
		Dilution	Thinner	Dilution	Thinner			
2	EPOFOND H.B.	10-15%	765	15-20%	765	12-24	4-5	150
1	SOLVER PRIMER	10-25%	400	15-30%	400	6-12	4-6	60-70
2	ANTIFOULING	0-5%	400	5-8%	400	8-12	9-10	40-60

Anti-osmosis "curing system"

N° coats	Product	Brush/Roller		Spray/Airless spray		Recoat time (hours)	Coverage m²/lt	Dry film thickness µm
		Dilution	Thinner	Dilution	Thinner			
1	EPOSEALER IMPR.ANT.	15-20%	765	20-25%	765	18-24	5	100
1	EPOSEALER IMPR.ANT.	5-10%	765	10-15%	765	18-24	5	100
1	EPOXY LIGHT FILLER	-	-	-	-	24-48	2	500
2	EPOSEALER IMPR.ANT.	5%	765	5-10%	765	18-24	5	100
1	EPOFOND AM-9	10-15%	765	15-25%	765	12-24	8-9	50
2-3	ANTIFOULING	0-5%	400	5-8%	400	8-12	9-10	40-60

Products

ENAMELS

The maintenance of a boat's topcoat enamel expresses and well defines the character, style and personality of a boat owner

An enamel finish is not just an aesthetic factor, but is also the first protective barrier against aggressive factors such as sunlight, salt, scratches and rain. Skipper's paints have been formulated with a constant research into the optimisation of quality products ensuring maximum resistance against environmental factors.
Enamels are divided into two categories: one-component and two-component.
One-component enamels are easier to use, they do not require to be activated with a hardener and can be applied by spray or paint brush.
Two-component enamels provide much higher weather resistance properties, but on the other hand they require a great deal of care during use since they must be activated with a hardener correctly in order to prevent drying problems and loss of their main characteristics. Once the two-components have been mixed, the paint must be used within its specified pot-life otherwise it will harden and become unsuitable for use. They are preferably applied by spray since they normally dry very quickly, hence unallowing optimum flowing if applied by brush.
To overcom this limit, the Skipper's range includes an excellent two-component paint performing similar flowing properties as one-component paint, even when applied by roller or paint brush: this is the "Space-top" enamel.

ONE-COMPONENT ENAMELS

TOPKAPI LUCIDO – Gloss polyurethane enamel

A polyurethane, one-component and non-yellowing high quality enamel providing a brilliant long-lasting finish. Its pure colour, high stability and gloss finish, as well as its outstanding weather resistance in the marine environment make this product the best choice for giving your boat a quality finish. Topkapi is available in a wide range of colours and can be applied either by spray or with a paintbrush.

Code: 2QT & 2RT **Pack.:** 0,75l 2,5l

Colour: See colour card
Brush, Roller: 10-20% Thinner 107 or 109
Spray: 10-25% Thinner 900
Ford cup viscosity Ø8 at 20°C: 14-16"
Dust free: 2-3 hours (at 20°C.)
Recoat time: 18-24 hours (at 20°C.)
T. Coverage: 11-13 m^2/Lt at 40-50 dry microns

TOPKAPI SATINATO – White satin enamel

A polyurethane, one-component and non-yellowing satin enamel, for a high quality satin finish. Its resistance to marine environment make this product the best choice for the painting of boats and for all those requirements where a pleasant satin finish is desired.

Code: 2Q5326 **Pack.:** 0,75l 2,5l

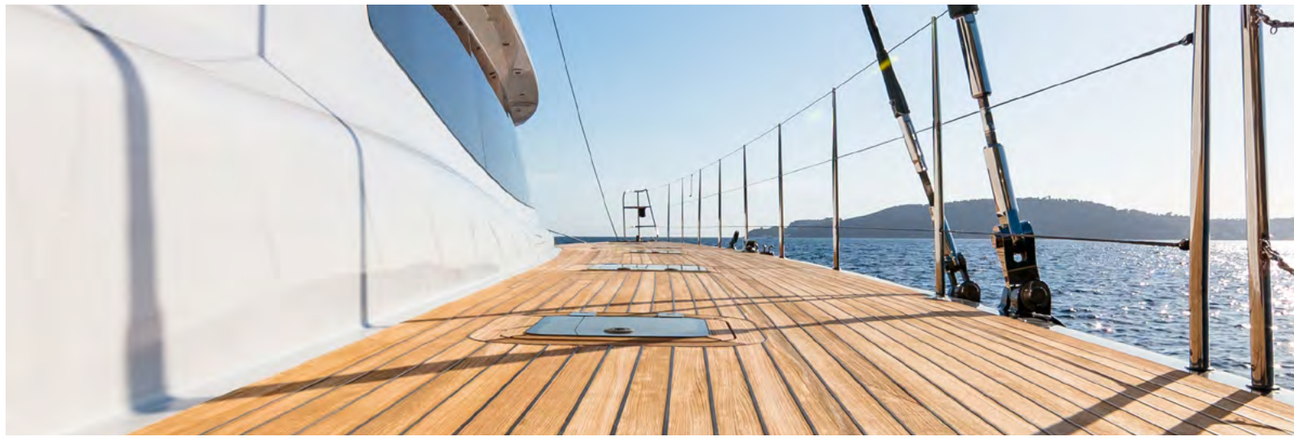
Colour: Satin white
Brush, Roller: 10-20% Thinner 107 or 109
Spray: 10-25% Thinner 900
Ford cup viscosity Ø8 at 20°C: 20-25"
Touch dry: 3-4 hours (at 20°C.)
Recoat time: 18-24 hours (at 20°C.)
T. Coverage: 11-13 m^2/Lt at 40-50 dry microns

INTERNO SCAFI – Bilge paint

One-component product specifically formulated for application on interiors of hulls to provide adequate protection on steel, fibreglass or wooden boats. It is a fast drying paint with excellent resistance to sea water and fuels. Recommended for bilges, floors and engine rooms. The application of at least two coats is recommended.

Code: 4S3909 **Pack.:** 0,75l 2,5l

Colour : Grey, White
Brush, Roller : 5-10% Thinner 400
Spray: 10-30% Thinner 900
Ford cup viscosity Ø8 at 20°C: 14-16"
Dust free: 2 hours (at 20°C.)
Recoat time: 18-24 hours (at 20°C.)
T. Coverage: 10-12 m^2/Lt at 40-50 dry microns



ONE-COMPONENT ENAMELS

SINTLAC - One component gloss enamel

Synthetic-oil based enamel for boats, with good gloss and coverage characteristics.

Code: D86 **Pack.:** 0,75l 2,5l 4l 25Kg

Colour: See colour card

Brush, Roller: 5% Thinner 107 or 109

Spray: 5-10% Thinner 900 or 107

Touch dry at 20°C: 2-4 hours

Recoat time at 20°C: 24 hours

Relative humidity: Below 80%

T. Coverage: 10 m²/Lt at 40 dry microns

SMALTO PER COPERTA - Deck paint

Special paint for boat decks. A special anti-slip additive can be added to provide a non-slippery surface.

Code: D813 **Pack.:** 2,5l

Application: Brush, roller and spray

Brush, Roller: 5-10% Thinner 107

Colours: green, red, white

Spray: 10-15% Thinner 900

Touch dry at 20°C: 1-2 hours

Relative humidity: Below 80%

T. Coverage: 9-10 m²/Lt at 40-50 dry microns

AGENTE ANTISDRUCCIOLO – Anti-slip additive

Anti-slip additive based on silica sand generally added to deck paints (Smalto per coperta) to provide a hard-wearing non-slippery surface.

Code: N00700 **Pack.:** 0,32Kg

Application: Add approx.20-30% by weight

Touch dry: according to the paint used

Relative humidity: Below 80%

Colour: Colourless

SMALTO MOTORI MARINI – Marine engine enamel

Fast-drying gloss enamel withstanding service temperatures of marine engines.

Code: MM0 **Pack.:** 0,75l

Application: Brush, roller and spray

Brush, Roller (touch ups): 10-15% Thinner 400

Spray: traditional colours 20-30% Thinner 400 - Metallic colours 30-40% Thinner 765

Touch dry at 20°C: 2-4 hours

Application temp.: Between +10°c and +40°c

Colours: most common marine engine colours

T. Coverage: 10-12 m²/Lt at 40 dry microns

EPOXY A/1 - Solvent-free epoxy

Solvent-free, non-toxic epoxy paint for the coating of fish tanks and food storage containers. Approved for contact with drinking water and foodstuffs.

Code: 3S **Pack.:** 1Kg 3Kg 25Kg

Application: Brush, roller and spray

Mixing ratio by weight A+B: 100 parts of Sol.A with 25 of Sol.B

Pot life A+B (20°C): Use mixture within 30-50 min.

Touch dry at 20°C: 2-4 hours

Colours: White, Red

Dilution: Ready for use or thinned with 3% fo-od-grade alcohol

Relative humidity: Below 80%

T. Coverage: 2-2,3 m2/Kg at 200 dry microns

TWO COMPONENT ENAMELS

ACRIGLASS – Polyacrylic gloss finish

High quality polyurethane-acrylic two component enamel. Completely non- yellowing, with outstanding properties of gloss retention and colour stability. Recommended for a professional yacht finish. Applied over an epoxy primer like Epofond AM-9 provides a long lasting finish highly resistant to marine environment. Available in a wide range of colours as per colour card.

Code: 2W **Pack.:** 0,75l 3l

Colour: See colour card

A+B Mix: 3 parts Sol.A + 1 Sol. B by volume

Pot life: 6-8 hours at 20°C.

Brush, Roller: 15-25% Thinner 205

Spray: 20-35% Thinner 203

Ford cup viscosity Ø 4 at 20°C:120-180"

Dust-free: 1-2 hours (at 20°C.)

Recoat time: 24 hours (at 20°C.)

T. Coverage: 10 m²/Lt at 40 dry microns

SPACE TOP – High flowing gloss finish

Modified polyurethane enamel providing excellent flowing, specially formulated for a brilliant finish on yachts and classic boats. Its application allows a full gloss finish both by spray and brush, with remarkable resistance to weathering and marine environments. The Space Top enamel is part of the Space Top line, which includes the Space Clear UV varnish and a range of special additives used to withstand particular application and weather conditions.

Code: 2W **Pack.:** 0,75l 3l

Colour: Pure/Sail/Ice White, Marine Blue

A+B Mix: 2 parts of Sol.A + 1 Sol. B by volume

Pot life: 6-8 hours at 20°C.

Brush, Roller: 20-30% with Thinner 201 (at temperatures above 23°C) or Thinner 205 (at temperatures below 23°C)

Spray: 20-35% with Thinner 201 (at temperatures above 23°C) or Thinner 205 and/or Thinner 203 (at temperatures below 23°C)

Ford cup viscosity Ø 4 at 20°C.: 90-120"

Dust-free: 3-4 hours (at 20°C)

Recoat time: 18-24 hours (at 20°C)

T. Coverage: 13-14 m²/Lt at 40 dry microns

WHITEXT – White textured finish

Semi-gloss textured white finish with excellent properties of flexibility and weather resistance in marine environment. Gives an "orange-peel" finish recommended for topsides and superstructures of yachts and where it may be necessary to reduce surface uneveness. A special spray equipment suitable for textured paint is required for spray application. The level of "orange-peel" finish can be modified by adjusting the percentage of thinning.

Code: 4P3902 **Pack.:** 1l 3l

Colour: White

A+B Mix: 3 parts of Sol. A + 1 of Sol.B by volume

Pot life: 6-8 hours at 20°C

Brush, Roller: 5-10%* Thinner 205

Spray: 5-10%* Thinner 203 (light texture)

Ford cup viscosity Ø 4 at 20°C.: Thixotropic

Dust-free: 30-40 min.(at 20°C.)

Recoat time: 24 hours (at 20°C.)

T. Coverage: 5-6 m²/Lt at 100 microns dry

VARNISHES

A well applied varnish enhances the natural beauty of wood, performing a protective barrier against climatic factors such as sunlight, moisture and salinity

Varnishes, like enamels, come in two different types: ONE-COMPONENT and TWO-COMPONENT. They have the same characteristics as enamels with the only difference of being transparent. To obtain the best results with one-component varnishes it is essential to use brushes with high quality bristles and dilute the products exclusively with our recommended thinners.

ONE-COMPONENT VARNISHES

TOPKAPI UV – Polyurethane gloss

One-component, clear gloss polyurethane, non-yellowing varnish for a long lasting finish highly resistant to the marine environment. Easy to apply is recommended for the exterior clear finish of wooden boats. Formulated with addition of UV filters to withstand sun exposure.

Code: 6BUV00 **Pack.:** 0,75l 2,5l

Brush, Roller: 10-15% Thinner 107 or 109
Spray: 10-20% Thinner 900
Ford cup viscosity Ø 4 at 20°C.: 90-120"
Touch dry: 4 hours at 20°C.
Recoat time: 24 hours at 20°C
T. Coverage: 12-14 m²/Lt for 40 dry microns

TOPKAPI OPACA – Polyurethane matt

One-component clear matt varnish for wood. Recommended for a matt finish on interiors of wooden boats, for furniture, doors, windows and all wood substrates. Easy to brush provides good characteristics of adhesion and resistance in marine environment.

Code: 6BA000 **Pack.:** 0,75l

Brush, Roller: 15-20% Thinner 107 or 109
Spray: 20-30% Thinner 900
Spray: 10-25% Thinner 900
Ford cup viscosity Ø 8 at 20°C.: 20-25"
Touch dry: 6 hours at 20°C.
Recoat time: 24 hours at 20°C.
T. Coverage: 10 m²/Lt for 40 dry microns

STARWIND UV - Extra gloss

High quality transparent varnish for wooden boats based on a phenolic resin and with UV filters added providing high protection to sunlight exposure. The phenolic modification combined with a fine quality resin and the high solid content make this varnish a high performance product for a long term resistance in the marine environment. Do not exceed the recommended thickness, allowing the required recoat time between coats.

Code: 6ZUV00 **Pack.:** 0,75l

Brush, Roller: 10-15% Thinner 107 or 109
Spray: 10-20% Thinner 900
Ford cup viscosity Ø 8 at 20°C.: 20"
Touch dry: 8-12 hours (at 20°C)
Recoat time: 24-48 hours (at 20°C)
T. Coverage: 12-13 m²/Lt for 40 dry microns*
*(Do not exceed the recommended thickness)

SUPERWIND LUCIDA – Traditional urethane gloss

Traditional urethane gloss varnish with excellent filling power and resistance in the marine environments. Recommended for use on wooden boats, handrails, doors and windows, shutters,and panelling in general.

Code: 6Z0000 **Pack.:** 0,75l

Brush, Roller: 10-15% Thinner 107
Spray: 10-20% Thinner 900
Ford cup viscosity Ø 4 at 20°C.: 120-130"
Touch dry: 6-8 hours (at 20°C)
Recoat time: 24 hours (at 20°C)
T. Coverage: 12-13 m²/Lt a 40 dry microns

ONE-COMPONENT VARNISHES

SUPERWIND SATINATA – Urethane satin

Satin urethane varnish with excellent filling power. Recommended for use on wooden boat interiors, handrails, windows and doors, shutters, and panelling in general where a satin finish is required.

Code: 6ZA **Pack.:** 0,75l

Brush, Roller: 10-15% Thinner 107
Spray: 10-20% Thinner 900
Ford cup viscosity Ø 8 at 20°C.: 18-20"
Touch dry: 6-8 hours (at 20°C)
Recoat time: 24 hours (at 20°C)
T. Coverage: 12-13 m²/Lt for 40 dry microns

TROPICAL – Tung-oil and phenolic-modified alkid resins high gloss

A classic very high gloss clear marine varnish formulated with special oils providing excellent flow and brushability. Specifically recommended for application on marine plywood and resinous tropical wood with outstanding adhesion on a previously well cleaned substrate (e.g. teak, iroko). Performs a high build film of extreme gloss with long lasting resistance even in tropical environment. Applied on wooden boats and wooden parts designed for the boating industry.

Code: 6XUV00 **Pack.:** 1l

Brush, Roller: 10-15% Thinner 107 or 109*
Spray: 20-30% Diluente 900
Ford cup viscosity Ø 6 at 20°C.: 60-90"
Touch dry: 8-12 hours (at 20°C)
Recoat time: 24-36 hours (at 20°C)**
T. Coverage: 12-13 m²/Lt for 40 dry microns

*In the summer season or when temperature is above 20°C, it is recommended the use of Thinner 109 for brush application.
** Do not apply "wet on wet" or high thickness in a single coat to avoid non-drying or wrinkling problems

BEKOL LUCIDA – Glycerophtalic flatting gloss

General purpose yacht varnish based on glycerophtalic resin. Used where a good performance, general purpose varnish economically priced is required. Easy to apply provides a flexible film with good characteristics of brushability and good outdoor resistance. Applied on wooden boats, windows , doors, chairs, etc.

Code: 6A0000 **Pack.:** 0,75l

Brush, Roller: 10-15% Thinner 107 or 109
Spray: 10-20% Thinner 900
Ford cup viscosity Ø 4 at 20°C.: 120"
Touch dry : 3-4 hours (at 20°C)
Recoat time: 24 hours (at 20°C)
T. Coverage: 8-10 m²/Lt at 40-50 dry microns

TWO-COMPONENT VARNISHES

ACRIGLASS UV – Polyacrylic high gloss

Extra-gloss clear non-yellowing varnish with UV filters added, providing a long lasting gloss and flexible finish both on new and classic old wooden boats. Protects against ageing due to sun exposure.

Code: 5WUV00 **Pack.:** 0,75l

A+B Mix: 2 parts Sol. A + 1 Sol.B by volume
Pot life: 4-6 hours at 20°C.
Brush, Roller: 10-15% Thinner 205
Spray: 20-30% Thinner 203
Ford cup viscosity Ø 4 at 20°C.: 45"
Dust free: 40-50 min.(at 20°C)
Recoat time: 24 hours (at 20°C.)
T. Coverage: 10-12 m²/Lt at 40 dry microns

TWO-COMPONENT VARNISHES

SPACE CLEAR UV – High flowing polyester gloss

Gloss polyurethane varnish with outstanding flowing characteristics for brush or spray application on wooden boats. Formulated with UV filters for long term resistance in marine environment. Gives a clear gloss non yellowing finish recommended for a professional brush or spray finish. Space Clear UV is part of the Space Top line, which includes Space Top enamel and a range of special additives helping product application in the most severe weather conditions.

Code: 5W5049 **Pack.:** 0,75l

A+B Mix: 2 parts Sol. A + 1 of Sol. B by volume
Pot life: 2-4 hours at 20°C.
Brush, Roller: 10-15% with Thinner 201 (at temperatures above 23°C) or Thinner 205 (at temperatures below 23°C)
Spray: 10-20% with Thinner 201 (at temperatures above 23°C) or Thinner 205 and/or Thinner 203 (at temperatures below 23°C)
Ford cup viscosity Ø 4 at 20 C.: 35-40"
Recoat time: min. 24 hours ***
T. Coverage: 12 m²/Lt at 35 dry microns

***Note. Overcoating after a minimum waiting period of 6-8 hours can only be of 2 coats (1+1), after which it is advisable to wait at least 24 hours before applying further coats of varnish. This is because the product contains slow drying solvents and in order to provide an even flow of the varnish needs more time than conventional products to fully evaporate.

SPACE CLEAR 3/1 - High flowing polyester gloss

Gloss polyester varnish with excellent flowing properties for brush or spray application on wooden boats. Formulated with UV filters to provide long lasting resistance in the marine environment. Particularly suitable as a gloss non-yellowing topcoat on classic wooden boats.

Code: 5WSC00 **Pack.:** 1l 3l

A+B Mix: 3 parts Sol. A + 1 Sol. B by volume
Pot life: 2-4 hours at 20°C.
Brush, Roller: 10-15% with Thinner 201 (at temperatures above 23°C) or Thinner 205 (a temperatures below 23°C)
Spray: 10-20% with Thinner 201 (for temperatures above 23°C) or Thinner 205 and/or Thinner 203 (for temperatures below 23°C)
Ford cup viscosity Ø 4 at 20 C.: 35-40"
Recoat time: min. 24 hours ***
T. Coverage: 12 m²/Lt at 35 dry microns

***Note. Overcoating after a minimum waiting period of 6-8 hours can only be of 2 coats (1+1), after which it is advisable to wait at least 24 hours before applying further coats of varnish. This is because the product contains slow drying solvents and in order to provide an even flow of the varnish film, needs more time than conventional products to fully evaporate.

POLIGLASS - Polyurethane fast drying

Fast drying, clear wood varnish allowing quick varnishing process. When thinned 50-100% (depending on the absorption of the wood) with Thinner 203 it can be used as a wood basecoat in polyurethane coating systems. It can be polished with abrasive and polishing products if left as a finish.

Code: 5X0000 **Pack.:** 0,75l 3l

A+B Mix: 2 parts Sol. A + 1 Sol. B by volume
Pot life: 4 hours at 20°C
Brush, Roller: 10-15% Thinner 205
Spray: 10-20% Thinner 203
Ford cup viscosity Ø 4 at 20°C.: 45-50"
Dust-free drying time: 15-20 min
Recoat time: 8-10 hours (at 20°C.)
T. Coverage: 10 m2/Lt at 50 dry microns

TWO-COMPONENT VARNISHES

POLIGLASS GEL UV – Polyurethane fast drying

This is a modified version of Poliglass varnish providing a high thickness build up with the application of less coats of varnish resulting in a substantial product and labour saving, while maintaining its chemical and physical characteristics unchanged. This product has also been improved in terms of "shrinkage", with a good compromise between thickness applied and thickness left over time. Provides a hard wearing finish also recommended in traditional coating system for wooden floors. Contains UV filters.

Code: 5X4006 **Pack.:** 0,75l 3l

A+B Mix: 2 parts Sol. A + 1 Sol. B by volume
Pot life: 4 hours at 20°C
Brush, Roller: 10-15% Thinner 205
Spray: 10-20% Thinner 203
Ford cup viscosity Ø 4 at 20°C.: 60-80"
Recoat time: 8-10 hours (at 20°C.)
T. Coverage: c.ca 6-7 m2/Lt depending on the thickness applied
Thickness: up to max.150 dry microns per coat

POLISATIN – Polyurethane satin

Two-component polyurethane satin varnish (40 gloss) for a high quality finish for interiors of wooden boats Enhances the wood grain and its natural colour. Applied on parquets and for all wooden surfaces with good resistance to most common stains providing a pleasant satin finish.

Code: 5P0000 **Pack.:** 0,75l

A+B Mix: 2 parts Sol. A + 1 Sol. B by volume
Pot life: 4-6 hours at 20°C.
Brush, Roller: 0-5% Thinner 205
Spray: 5-10% Thinner 203
Ford cup viscosity Ø 4 at 20°C.: 15-20"
Dust free: 5-15 min.at 20°C
Recoat time: 8-12 hours (at 20°C.)
T. Coverage: 8 m²/Lt for 40 dry microns

POLIMAT - Polyurethane matt

Two-component, polyurethane matt varnish widely used for interior of boats, furniture, windows, doors etc. Gives a non-reflecting, tough film enhancing the grain and the original appearance of the wood.

Code: 5Z0000 **Pack.:** 0,75l

A+B Mix: 2 parts Sol. A + 1 Sol. B by volume
Pot life: 6-8 hours at 20°C.
Brush, Roller: 5-10% Thinner 205
Spray: 10-20% Thinner 203
Ford cup viscosity Ø 4 at 20°C.: 20-25"
Dust free: 15-20 min.at 20°C
Recoat time: 8-12 hours (at 20°C.)
T. Coverage: 8 m²/Lt for 40 dry microns

UNDERGLASS – Wood sealer

This varnish is particularly recommended for preparation works on wood and marine plywood, both on interior and exterior of boats. For its outstanding penetrating power provides excellent waterproofing characteristics and resistance to humid environments. Recommended as a basecoat it can be overcoated by two-component polyurethane clear varnish or enamel but also with further coats of topcoat varnish or synthetic undercoat. Sandpapering between coats is recommended in order to provide suitable adhesion before overcoating.

Code: 5XUND0 **Pack.:** 0,75l 3l

A+B Mix: 2 parts Sol. A + 1 Sol. B by volume
Pot life: 2-3 hours at 20°C
Brush, Roller: 10-15% Thinner 205
Spray: 15-20% Thinner 203
Ford cup viscosity Ø 4 at 20°C.: 45-50"
Dust free: 10-15 min
Recoat time: 8-10 hours (at 20°C.)
T. Coverage: 8-10 m²/Lt for 40 dry microns

STAR TEAK LINE

STAR TEAK SEALER – Amber coloured teak sealer

Solvent based protective teak oil sealer, with a slight amber colour, specifically formulated for the treatment and maintenance of teak and other fine quality woods, providing a durable protection to sunlinght and weather exposure in marine environment. It is widely used on teak decks and similar woods enhancing the natural grain of wood.

Code: 6D4892 **Pack.:** 0,75l

Colour: Amber
Brush: Ready for use or with Thinner 107
Ford cup viscosity Ø 4 at 20°C.: 15-18"
Dust free: 1-2 hours at 20°C.
Recoat time: after 1-2 hours at 20°C.
Theoretical coverage: 9-13m²/Lt according to wood absorption

STAR TEAK SEALER UV – Colourless with UV filters

Solvent based colourless protective teak oil sealer specifically formulated for the treatment and maintenance of teak and other fine quality woods, providing a durable protection to sunlinght and weather exposure in marine environment. It is widely used on teak decks and similar woods enhancing the natural grain of wood. Contains UV filters for extended duration.

Code: 6D4892 **Pack.:** 0,75l 5l

Colour: Transparent
Brush: Ready for use or with Thinner 107
Ford cup viscosity Ø 4 at 20°C.: 15-18"
Dust free: 1-2 hours at 20°C.
Recoat time: 1-2 hours at 20°C.
Theoretical coverage: 9-13m²/Lt according to wood absorption

STAR TEAK CLEANER – Teak cleaner

Concentrated alkaline detergent used for cleaning teak decks and most surfaces onboard. Removes the most ingrained dirt, restoring the original colour of wood.

Code: 6D6414 **Pack.:** 1l

Colour: Fluorescent light blue
Brush: Dilute with fresh water
Dilution: 1 part of product with 3 or more parts of fresh water

STAR TEAK BRIGHTENER – Teak Brightener

Brightening solution for the restoration of teak decks blackened by oxidation and sunlight exposure.
S.T.Brightener is a real solution to achieve best results for restoring teak wood.

Code: 6D6420 **Pack.:** 1l

Colour: Straw yellow
Brush: ready to use
Dilution: Product ready to use

ANTIFOULING PAINTS

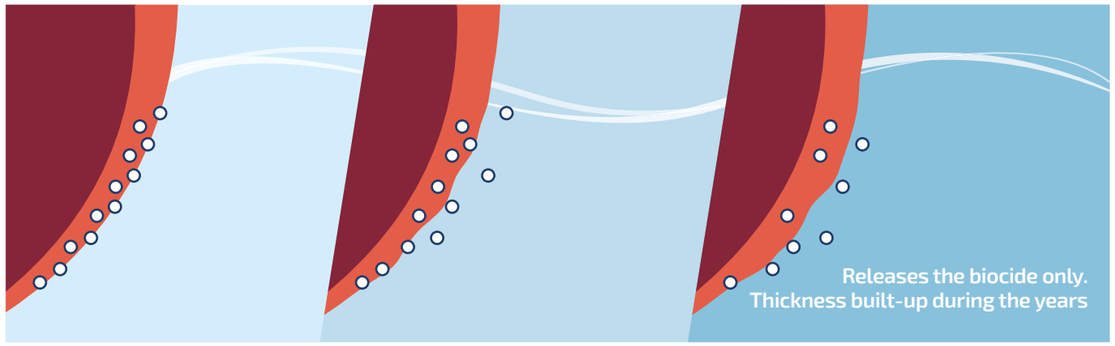
Antifouling paint is an underwater hull coating applied to prevent the growth of barnacles and weeds on the hull

Without the protection of an effective antifouling paint the growth of vegetation and marine organisms can seriously impair the hull below the waterline, causing friction that decreases the speed of the boat and raising fuel consumption considerably. We must therefore remember the saying “those who spend more spend less” and avoid therefore to skimp and save on the cost and quality of the antifouling.
Antifouling paints are formulated with a mix of several resins the content of which determines the final product as “self-polishing” or “hard matrix”; they contain one or more categories of biocides, used in preventing the growth of fouling, colour pigments and solvents to make it easy to apply.

HARD MATRIX

Hard-Matrix antifouling paints release their active ingredients slowly (slow release) regardless the movement of the boat; they are suitable for fast boats but also for medium speed boats often sailing such as ferries or public motorboats. As the paint film is being slowly released this will produce a thickness build-up during the years, so that after several dry dockings it will be necessary to remove the built-up layer much earlier than it would be required with a self-polishing antifouling instead.

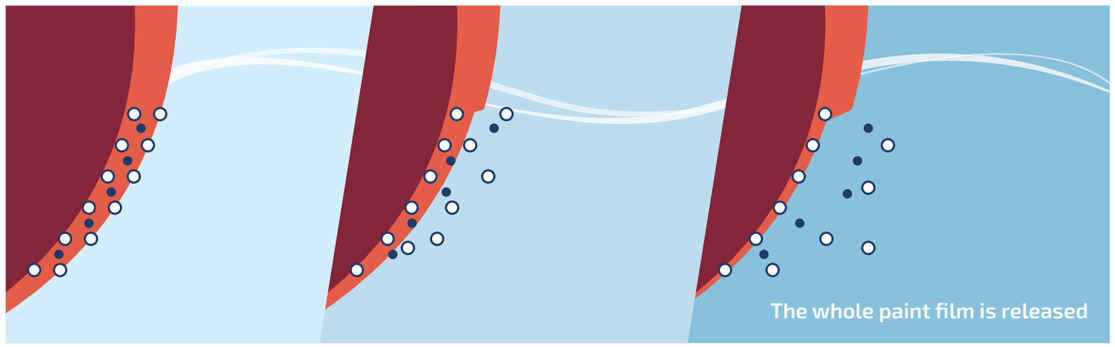
ANTIFOULING RELEASE



SELF POLISHING

The biocides contained in the paint are released into the water as the paint film is dissolved and consumed upon contact with water whilst the boat is sailing.
These antifouling paints wear out while the boat is sailing , thereby avoiding thickness build-up while providing a steady release of the biocides throughout the entire life of the product.
For this type of antifouling paint, the higher the thickness the longer the protection from fouling will last (two or three coats are recommended)

ANTIFOULING RELEASE



ANTIFOULING CONSUMPTION SCHEME

Indicative paint consumption

BELOW THE WATER LINE

Length of the hull		PRIMER (one coat)		ANTIFOULING (two coats)	
		Sailing boats (consumption in litres)	Motor boats (consumption in litres)	Sailing boats (consumption in litres)	Motor boats (consumption in litres)
5 Mt.	16,40 ft.	0,6	0,7	1,4	1,6
6 Mt.	19,68 Ft.	0,8	1,0	1,9	2,3
7 Mt.	22,96 Ft.	1,0	1,4	2,3	3,2
8 Mt.	26,24 Ft.	1,3	1,8	2,9	4,1
9 Mt.	29,52 Ft.	1,5	2,3	3,5	5,1
10 Mt.	32,80 Ft.	1,9	2,8	4,2	6,2
11 Mt.	36,08 Ft.	2,2	3,3	4,9	7,5
12 Mt.	39,37 Ft.	2,5	3,9	5,7	8,7
13 Mt.	42,65 Ft.	2,9	4,4	6,5	10,0
14 Mt.	45,93 Ft.	3,3	5,0	7,5	11,3
15 Mt.	49,21 Ft.	3,7	5,6	8,4	12,6
16 Mt.	52,49 Ft.	4,2	6,3	9,5	14,1
17 Mt.	55,77 Ft.	4,7	6,9	10,5	15,5
18 Mt.	59,05 Ft.	5,2	7,6	11,7	17,0
19 Mt.	62,33 Ft.	6,5	13	11,9	20
20 Mt.	65,61 Ft.	8,5	20	12	25
25 Mt.	82,02 Ft.	15	30	17	35
30 Mt.	98,42 Ft.	20	45	22	50
35 Mt.	114,82 Ft.	25	55	27	60
40 Mt.	131,23 Ft.	30	65	32	70
45 Mt.	147,63 Ft.	35	68	37	75
50 Mt.	164,04 Ft.	40	70	42	80

PRODUCT CHOICE

Two factors may influence the choice of the antifouling:

Speed. For boats speed of up to 30 knots a self-polishing antifouling paint is advisable, while for boats with speed over 30 knots, racing boats, or even boats that don't exceed 30 knots but sail daily (e.g.ferries, public motor boats etc.) the use of a hard matrix type antifouling is advisable.

Substrate. Aluminium is the only construction material requiring a different type of antifouling . Antifoulings formulated with copper oxides cannot be used on aluminium hull because these two metals have a very close electrical conductivity values and may undergo to galvanic interactions which could corrode or even pierce the aluminium substrate.
This inconvenience could be avoided with the application of a high thickness epoxy primer between the aluminium substrate and the antifouling, but is best however to avoid such procedure.

USEFUL TIPS

If you know the existing antifouling paint overcoat with the same type of product.
If you want to change the product you may apply a self-polishing antifouling directly over a hard matrix antifouling as long as it is in good condition and has been sanded.

Conversely, if you want to apply a hard matrix onto a self-polishing antifouling you must first apply an intermediate coat of "Solver Primer"

If the existing paint system is not in a good condition, completely remove the old antifouling paint with a suitable paint remover (e.g. Svernigraf for wood or steel boats or Stripcarena for fibreglass boats), then sand and apply a suitable primer according to the different type of surface.

Once a high quality antifouling paint has been chosen, for best results some precautionary measures must be followed: the recommended paint thickness should be achieved with several coats and not with just one excessively thick coat as this would lead to solvent entrapment causing an irregular and uneven release of the active ingredients; this means that if the biocides are released too quickly the antifouling power of the product will be considerably shortened.
This also applies in case the boat is launched too soon after painting ; we recommend to wait at least 48 hours before launching the boat into the water.

STANDARD PLUS – Self-polishing copper based

Self-polishing antifouling formulated with copper salts for use on wood, steel and fibreglass hulls with speed up to 30 knots.

Code: 3E **Pack.:** 0,75l 2,5l 15l

Colour: Red ox. ,Black ,Sky Blue, Blue Universe

Brush, Roller: Ready to use or with max. 5% Thinner 400

Spray: 10% with Thinner 400

Ford cup viscosity Ø 8 at 20°C: 12"

Touch dry: 3-4 hours at 20°C.

Recoat time: 18-24 hours (at 20°C.)

Launching time: after minimum 24-48 hours

Theoretical coverage: 10-12 m^2/Lt for 50-60 dry microns

STANDARD PLUS STC - Self-polishing white

Self-polishing white antifouling formulated with copper thyocianate for use on all types of boats, including aluminium and light-alloys. Recommended on boats with speed up to 30 knots. The application of minimum 3 coats is recommended.

Code: 3E6411 **Pack.:** 0,75l 2,5l 15l

Colour: White

Brush, Roller: Ready to use or with a max. of 5% Thinner400

Spray: 5-8% Thinner 400

Ford cup viscosity Ø 8 at 20°C.: 13-15"

Touch dry: 3-4 hours at 20°C.

Recoat time: minimum 12 hours (at 20°C.)

Launching time: after minimum 24-48 hours

T. Coverage: 10-11 m^2/Lt for 40-50 dry microns

CONTENDER – EXTRA hard matrix

Highly reliable long lasting hard matrix antifouling paint formulated with a high content of copper oxides and special ingredients for use specially in warm seas. Provides appropriate protection to the hull once applied over a suitable primer. It can be applied on wood, steel and fibreglass boats with speed also over 30 knots. Not suitable for aluminium boats.

Code: 3F66 **Pack.:** 0,75l 2,5l 15l

Colour: Red, Black, Blue, Sky-blue

Brush, Roller: Ready to use or with a max. of 5% Thinner400

Spray: 5-8% Thinner 400

Ford cup viscosity Ø 4 at 20°C.: 10-14"

Touch dry: 2-3 hours at 20°C.

Recoat time: 8 hours

Launching time: minimum 24-48 hours

T. Coverage: 5-8 m^2/Lt for 60-90 dry microns

CONTENDER STC – EXTRA hard matrix white

Hard matrix white antifouling formulated with copper thyocianate providing high antifouling power and excellent coverage properties. For application on all types of hulls, including aluminium, since the copper salt used does not develop galvanic interactions. Recommended for boats with speed also over 30 knots.

Code: 3F6611 **Pack.:** 0,75l 2,5l 15l

Colour: White

Brush, Roller: Ready to use or with a max. of 5% Thinner 400

Spray: 5-8% Thinner 400

Ford cup viscosity Ø 4 at 20°C.: 14-15"

Touch dry: 2-3 hours at 20°C.

Recoat time: minimum of 12 hours at 20°C.

Launching time: after minimum 24-48 hours

T. Coverage: 9-10 m^2/Lt for 50-60 dry microns

SERENISSIMA – EXTRA self-polishing

High quality, long lasting idrophilic matrix antifouling paint. The high content of coprous oxide and other valuable additives, combined to the particular vehicle formulation, allow this product to provide an excellent antifouling power in the most varied conditions. The hydropfilic nature of the vehicle improves wettability and flowing characteristics of the hull in the water. It can be effectively used also in warm seas and miscellaneous water. Provides a controlled speed release of the antifouling salts which makes this product recommended on both medium speed boats and sailing boats. Not suitable on aluminium boats. Recommended for boats with speed up to 30 knots.

Code: 3F **Pack.:** 0,75l 2,5l 15l

Colour: Black, Sky-blue, Red ox., Dark Blue

Brush, Roller: Ready to use or with max. 5% Thinner.400

Spray: 10-15% Thinner 400

Ford cup viscosity Ø 8 at 20°C.: 12-15" ± 2

Touch dry: 1-2 hours at 20°C.

Recoat time: after minimum 12 hours at 20°C.

Launching time: minimum 24-48 hours

T. Coverage: 8-10 m^2/Lt for 40-50 dry microns

SERENISSIMA STC – EXTRA self-polishing

Self-polishing antifouling formulated with copper thyocianate for all type of boats, including aluminium. Its soluble matrix formulation performs a constant release of the antifouling ingredients which allows the paint film to be always active during sailing. It does not need to be sanded at time of repainting. A minimum of 3 coats is recommended for best results. The release of the paint film varies according to speed and service of the boat. Recommended for medium speed boats of up to 30 knots.

Code: 3F6270 **Pack.:** 0,75l 2,5l 15l

Colour: White, Black

Brush, Roller: ready to use or with max 5% Thinner. 400

Spray: 5-8% Thinner 400

Ford cup viscosity Ø 4 at 20°C.: 13-15"

Touch dry: 1-2 hours at 20°C.

Recoat time: minimum 12 hours at 20°C.

Launching time: after minimum 24-48 hours

T. Coverage: 9-10 m2/Lt at 50-60 dry microns

ANTIFOULING PAINTS

CONTENDER ELICHE

Acrylic antifouling paint for propellers, stern-drives and flaps. Provides high adhesion and stress resistance. The application of 2 coats over a prior coat of Eliprimer is recommended. The substrate should be at first sanded with coarse grain sandpaper and degreased with a water-soluble detergent solution (do not use solvents for degreasing). Elifax New can be applied directly on previous compatible paints in good conditions. Do not apply over different types of antifouling.

Code: 3E **Pack.:** 0,25l

Colour: White, Grey Black
Brush, Roller: Ready to use or with max. 5% Thinner 400
Spray: 5% Thinner 400
Ford cup viscosity Ø 8 at 20°C.: 13-15"
Touch dry: 3-4 hours at 20°C.
Recoat time: 24 hours at 20°C.
Launching time: minimum 24-48 hours
T. Coverage: 8-10 m²/Lt for 40-50 dry microns

VENOX SUPER – Classic antifouling

Copper based antifouling paint formulated with a high content of coprous oxide and other antifouling ingredients. Particularly suitable in warm seas and in difficult service conditions. Its antifouling power develops over a period of 12 months (based on a dry film thickness of 100-120 microns). Suitable on work boats with speed of up to 30 knots. It can be applied on wood, steel or fibreglass hulls.

Code: B654 **Pack.:** 0,75l 2,5l 15l

Application: Brush, roller and spray
Brush, Roller: Ready to use or max. 5% Thin.400
Spray: 5-10% Thinner 400
Ford cup viscosity Ø 8 at 20°C.: 12-15"
Touch dry: 2 hours (20°c)
Launching time: Min 24-28 hours
Recoat time: 4-6 hours (20°c)
Colour: Red ox., Black, Sky-Blue, Dark Blue
T. Coverage: 6-7 m²/Lt for 60-90 dry microns

COSTIERA T.F. – Hard matrix

Hard matrix, high performance antifouling formulated with high copper content and special ingredients for use on any sea. Provides appropriate protection to the hull once applied over a suitable primer. It can be applied on wood, steel and fibreglass hulls with speed also over 30 knots. Not suitable for aluminium boats. Please note: Red/Black/Blue suitable for wood, steel and fibreglass boats (not suitable on aluminium boats) – White STC: suitable for alla types of boats (including aluminium boats).

Code: B65514 **Pack.:** 0,75l 2,5l 15l

Application: Brush, roller,spray
Brush, Roller: Ready to use or with max. 5% Thinner 400
Spray: 5-8% Thinner 400
Touch dry: 2-3 hours (20°c)
Recoat time: 8 hours (20°c)
Colour: Red, Black, Blue
Thickness: 60-90 microns per coat
T. Coverage: 8-10 m²/Lt at 40-50 dry microns

SIRENA ABR – EXTRA self-polishing

Special self-polishing antifouling based on copper oxide with non-polluting anti-slime and anti-algae compounds. The synthetic copolymers that the binder is made of allow a controlled release of the antifouling salts into the water. With a thickness of 120 dry microns it can last from a minimum of 12 months to a maximum of 16 months. It can be applied on wooden, fibreglass and steel hulls with speeds of up to 20-25 knots.

Code: A671 **Pack.:** 0,75l 2,5l 15l

Application: Brush, Roller
Brush, Roller: Ready to use or with a max. 5% Thinner.400
Spray: 10-15% Thinner 400
Touch dry: 2-3 hours (20°c)
Recoat time: 8-12 hours (20°C)
Colour: Red ox., Black, Dark Blue, Sky Blue
T. Coverage: 8-10 m²/Lt at 40-50 dry microns

THINNERS

The Skipper's range of thinners are specifically formulated and balanced to enhance the quality of our paints. All our paints must be diluted exclusively with our recommended thinners, the use of different thinners may affect application and the final painting result

THINNER 107
Thinner for synthetic, alkyd, glycerophtalic and polyurethane one-component paints and varnishes.

THINNER 109
Retardant thinner for synthetic and polyurethane one component paints and varnishes.

THINNER 900
Thinner for spray application of synthetic and polyurethane one-component paints and varnishes.

THINNER 400
Thinner for brush application of antifouling paints and chlorinated rubber based one component paints.

THINNER 723
Thinner for nitro-based paints.

THINNER 203
Thinner for polyurethane and polyacrylic two-component paints and varnishes.

THINNER 205
Retardant thinner for polyurethane and polyacrylic two-component paints and varnishes.

THINNER 765
Thinner for epoxy two-component paints.

THINNER 201
Retardant thinner for two component polyurethane paints and varnishes, used with Space Top, Space clear and Acriglass UV

REDILFAST
Drying acelerator for synthetic one-component paints or polyurethane aliphatic two-component paints. It is added in the percentage of 20% as a replacement of the usual product thinner.

PRIMERS

Primers have the specific purpose of providing adequate adhesion to the following coats of paint.The achievement of an excellent finish depends on the quality of the primer and its correct application. Undercoats are the following coats applied after the primer, acting as a preparatory coating for the finishing coats

USEFUL TIPS

Do not apply primers in environments that are excessively hot or cold, under direct sunlight or in the presence of strong wind.
Wet the surrounding area to prevent build-up of dust over the freshly applied paint.
Stir paint thoroughly before and during application.
Use a high quality brush or roller suitable for solvent paints (e.g. mohair brush or sponge roller)
Use the mixture of two-component paints within the specified pot life.
Always allow the recommended waiting time between coats as specified in our product data sheets, specially for two-component paints.
Sand the surface with medium-coarse grain sandpaper as indicated in our tables.
Sandblasting is the best surface preparation method for steel surfaces;
If sandblasting is not possible , sand lightly or mechanically with coarse grain sandpaper.
Do not polish steel surfaces as this will adversely affect paint adhesion.
Apply the required primer coats as recommended in our coating systems.
Finally, overcoat with the recommended topcoat enamel or antifouling paint.

TWO-COMPONENT PRIMERS

EPOFOND AM-9 – Epoxy primer

Two-pack epoxy paint for steel, aluminium, light alloys, fibreglass, cement and wood surfaces. Used as a primer or undercoat for marine coating systems and also widely applied on flooring and tanks containing oils, naphta, kerosene and soda solutions, Develops a non toxic resistant film overcoatable with chlorinated based, acrilyc or polyurethane paints, providing strong adhesion and long effective anticorrosive barrier.

Code: 5G **Pack.:** 0,75l 2,78l 27Kg

Application: Brush, roller and spray
A+B Mix by volume: 4 parts Sol.A with 1 part Sol.B
A+B Mix by weight: 100 parts Sol.A with 20 parts Sol.B
A+B Pot life (20°c): Use mix within 6-8 hours
Brush, Roller: 10-15% Thinner 765
Spray: 15-25% Thinner 765
Touch dry: 2 hours (20°C)
Recoat time: 12-24 hours (20°c)
Colour: White, Grey, Red
T. Coverage: 8-9 m^2/Lt, 5-6 m^2/Kg at 50 dry microns

EPOFOND HB – High-build epoxy

High-build epoxy satin coating for all types of surfaces recommended as osmosis prevention treatment on fibreglass boats. The advantage to build up a thickness of 100-150 dry microns per coat allows sensible reduction of labour costs. Overcoatable with chlorinated rubber, epoxy or polyurethane coatings for high quality long lasting anticorrosive coating systems. Provides outstanding chemical resistance in the marine environment for applications both above and below the waterline.

Code: 5G1145 **Pack.:** 2,78l 0,75l

Application: Brush, roller and spray
A+B Mix by volume: 4 parts Sol. A with 1 Part Sol. B
A+B Mix by weight: 100 Part Sol. A with 16 Part Sol. B
A+B Pot life (20°C): Use mix within 6-8 hours
Brush, Roller: 10-15% Thinner 765
Spray: 15-25% Thinner 765
As a primer on bare wood: 15-20% Thinner 765
Touch dry: 2-3 hours (20°C)
Recoat time: 12-24 hours (20°C)
Colour: White
T. Coverage: 4-5 m^2/Lt for 150 dry microns

EPOWOOD – Epoxy wood basecoat

Two-component, low-viscosity epoxy coating, specifically formulated to also withstand humidity in the wood substrate. Its formulation allows easy penetration and wettability of the substrate performing a protective waterproof barrier. Applied on wooden boats in particular to reinforce wood fibre and prepare it adequately for the following coats. It is strongly advised to wash well the substrate with fresh water and let it dry before the application of Epowood.

Code: 3P5958 **Pack.:** 1,5l 5l

Application: Brush, roller and spray
A+B Mix by volume: 1 Part Sol. A with 1 of Sol. B
Pot life A+B (20°C): Use mixture A+B within 4 hours
Brush, Roller: Ready to use or with Thinner 765
Touch dry: 2 hours (20°C)
Recoat time: min. 6 max. 24 hours (20°C) Sand after 24 hours
Relative humidity: Below 80%
Thickness: according to absorption
Theoretical coverage: 12-14 m^2/Lt

TWO-COMPONENT PRIMERS

ELIPRIMER 2C – Primer for propellers

Two-component epoxy primer for steel, bronze, brass, cast iron and light alloys surfaces. Specifically applied as a primer on propellers, flaps,drive shafts, axles and cast-iron bulbs, provides an excellent anchor base and a long lasting anticorrosion barrier.
Overcoatable with Elifax New antifouling.

Code: 5GBC00 **Pack.:** 0,50l

Application: Brush, roller and spray
A+B Mix by volume: 4 Parts Sol. A with 1 Sol. B
Pot life A+B (20°C): Use the mixture within 6-8 hours
Brush, Roller: 20-30% Thinner 765
Spray: 25-35% Thinner 765
Touch dry: 2 hours (20°C)
Recoat time: 12-24 hours (20°C)
Colour: White
T. Coverage: 8-9 m²/Lt for 30-40 dry microns

POLIFOND – Polyurethane undercoat

Two-component polyurethane white undercoat for boats and applications in the automotive field, with excellent coverage and good filling power. Used as intermediate coat for wood, steel or fibreglass surfaces or as a pre-treatment primer before overcoating with two-component enamels (e.g. Acriglass, Space Top or Whitext).

Code: 5S0000 **Pack.:** 3,5l 1l

Application: Brush, roller and spray
A+B Mix: Mix by volume 5 parts of Sol.A with 2 of Sol. B
Pot life A+B: Use mixture within 6-8 hours
Brush, Roller: 15-30% Thinner 205
Spray: 25-35% Thinner 203
Touch dry: 3-4 hours (20°C)
Recoat time: 12-24 hours (20°C)
Colour: White
T. Coverage: 14-15 m²/Lt at 35-40 dry microns

TWO-COMPONENT PRIMERS

POLIFIBER PRIMER – For fibreglass

Special two-component primer formulated to provide excellent adhesion to fibreglass surfaces. Applied as a base coat on superstructures, topsides and hulls below the waterline of fibreglass boats.
It can be applied direct onto gelcoat provided that a suitable surface degreasing and light sanding with fine abrasive paper is being carried out before its application.

Codice: 4S4182 **Pack.:** 1l

Application: Brush, roller and spray
A+B Mix: Mix by volume 10 parts Sol.A with 3 of Sol. B
Pot life A+B (20°C): Use mixture within 4-6 hours
Brush, Roller: 15-30% Thinner 203 or 205
Spray: 25-30% Thinner 203
Touch dry: 2-3 hours (20°C)
Recoat time: 18-24 hours (20°C)
T. Coverage: 10 m²/Lt at 50 dry microns
Colour: white

ONE COMPONENT PRIMERS

SOLVER PRIMER – Intermediate undercoat

Chlorinated rubber based universal intermediate one-component undercoat formulated with aluminium and selected anti-corrosive pigments. Recommended for traditional and chlorinated-rubber based coating systems and particularly as an intermediate coat between old and new antifoulings. Provides outstanding resistance on metal structures exposed to marine and industrial environment.

Code: 2U3900 **Pack.:** 0,75l 2,5l 18l

Application: Brush, roller and spray
Brush, Roller: 10-25% Thinner 400
Spray: 10% Thinner 400
Touch dry: 2-3 hours (20°C)
Recoat time: minimum of 6 hours (20°)
Application temp.: Between +10°C and +40°C
Colour: Golden Yellow
T. Coverage: 4-6 m²/Lt at 60-70 dry microns

UNIFIBER – For fibreglass

One-component, low thickness primer for direct application onto fibreglass hulls. Recommended also as intermediate coat between epoxy and/or polyurethane two-component products and one-component finishes. Overcoatable with Topkapi enamel for topsides and superstructures or with appropriate antifouling for the hull below the waterline.

Codice: 4S705 **Pack.:** 0,75l 2,5l

Application: Brush, roller and spray
Brush, Roller: 0-5% Thinner 765
Spray: 10-20% Thinner 765
Recoat time: minimum of 6 hours (20°c)
Touch dry: 20-30 minutes (20°c)
Application temp.: Between +10°C and +40°C
Colour: Green
T. Coverage: 10 m²/Lt for 15 dry microns

ELIPRIMER 1C – For propellers

One-component primer for direct application on metals such as brass, bronze, aluminium and stainless steel. It can be both overcoated with one or two-component paints and in particular, for boat propellers, with ELIFAX NEW antifouling paint. Provides excellent adhesion to the substrate and for the following coats.

Code: 4P5241 **Pack.:** 0,25l

Application: Brush, roller and spray
Brush, Roller: 5-10% Thinner 765
Spray: 5-10% Thinner 765
Touch dry: 60 minutes (20°c)
Recoat time: minimum of 4 hours (20°c)
Colour: Metallic grey
T. Coverage: 10 m²/Lt at 20 dry microns

EVIOX MINIO OLEOFENOLICO – Anti corrosive primer

Anticorrosive primer formulated with red lead and chromate-molibdates with a good rust inhibiting power. The product is easy to apply and provides outstanding coverage. Recommended in synthetic coating systems for a long term protection. Suggested as a basecoat on new wooden boats but also widely used in the carpentry and construction field. **FOR PROFESSIONAL USE.**

Code: F40130 **Pack.:** 2,5l

Application: Brush, roller and spray
Brush, Roller: 10-15% Thinner 107
Spray: 15-25% Thinner 900
Touch dry: 3-5 hours (20°c)
Recoat time: 12-24 hours (20°c)
Application temp.: Between +10°c and +40°c
Colour: Orange
T. Coverage: 11 m²/Lt at 40 dry microns

EVIOX CROMOMINIO – Anti corrosive primer

General purpose anticorrosive one component paint formulated with red lead and anti-decay additives to provide excellent anticorrosive barrier, high coverage and strong adhesion. Designed to withstand marine and industrial environments with good flexibility and adhesion properties. Based on a modified long-oil alkyd resin binder with waterproofing characteristics. Recommended in synthetic coating systems on wood and steel boats. **FOR PROFESSIONAL USE.**

Code: F40008 **Pack.:** 2,5l

Application: Brush, roller and spray
Brush, Roller: 10-15% Thinner 107
Spray: 15-25% Thinner 900
Touch dry: 2-3 hours (20°c)
Recoat time: 16-24 hours (20°c)
Application temp.: Between +10°c and +40°c
T. Coverage: 9 m²/Lt at 30 dry microns
Colour: Orange

SOTTOFONDO ARANCIO MINIO – Anti corrosive primer

Synthetic anticorrosive orange primer, providing good sealing power and rust inhibiting properties. Formulated with synthetic long-oil resins and rust/mildew inhibiting pigments. Provides good characteristics of flexibility and adhesion. **FOR PROFESSIONAL USE.**

Code: F30242 **Pack.:** 2,5l

Application: Brush, roller and spray
Brush, Roller: Max 10-15% Thinner 107
Spray: 15-25% Thinner 900
Touch dry: 3-4 hours (20°c)
Recoat time: 24 hours (20°c)
Application temp.: Between +10°c and +40°c
T. Coverage: 9 m²/Lt at 40 dry microns
Colour: Orange

SOTTOFONDO ARANCIO AT – Anti corrosive primer

General purpose anticorrosive one component primer formulated with a high content of active pigments providing good anticorrosion power and anti-decay properties. Recommended in synthetic coating systems for a long term protection. Easy to apply, it is fast drying and provides good adhesion to the substrate and high coverage characteristics. Widely used in the marine industry and also in the carpentry and construction fields.

Code: 4R5240 **Pack.:** 0,5l

Application: Brush, roller and spray
Brush, Roller: 15-25% Thinner 107
Spray: 15-30% Thinner 900
Touch dry: 2-3 hours (20°c)
Recoat time: 24 hours (20°c)
Relative humidity: Below 80%
T. Coverage: 7-9 m²/Lt at 40-50 dry microns

SOTTOFONDO NAUTICA – White undercoat

Alkyd based white undercoat specially formulated for the marine industry for application on wood and steel boats exposed to marine environment. Used as a basecoat for the preparation of superstructures of boats it can be overcoated with one-component finishes (e.g.Topkapi enamel).

Code: 4SNA00 **Pack.:** 0,5l 2,5l

Application: Brush, roller and spray
Brush, Roller: 10-20% Thinner 107
Spray: 20-30% Thinner 900
Touch dry: 3-4 hours (20°c)
Recoat time: 18-24 hours (20°c)
Colour: White
T. Coverage: 9-10 m²/Lt (5-6 m²/kg) at 40-50 dry microns

AM/621 ANTIRUGGINE – Glicerophtalic anti corrosive primer

Anticorrosive basecoat formulated with glycerophtlalic resins and rust-inhibiting pigments of selected quality. Although fast to dry its formulation has been balanced to provide a good wetting power to the substrate. Provides good rust-inhibiting properties and good adhesion, it is recommended as a basecoat to be overcoated with synthetic topcoats. It can be applied on topsides and upperworks of boats and as a primer in conventional steel coating systems.

Code: 40 / 4N **Pack.:** 0,5l 2,5l 25Kg

Application: Brush, roller and spray
Brush, Roller: 15-30% Thinner 107
Spray: 15-35% Thinner 900
Dry to touch: 2-4 hours (20°c)
Recoat time: 24 hours (20°c)
Application temp.: Between +10°c and +40°c
Colour: Grey
T. Coverage: 8-9 m²/Lt at 40-50 dry microns

EVIOX GRIGIO R – Grey anti corrosive primer

Synthetic anticorrosive basecoat formulated with zinc phosphates providing a goods rust inhibiting power with good flexibility and adhesion properties.

Code: F40008 **Pack.:** 0,5l 2,5l

Application: Brush, roller and spray
Brush, Roller: max 10% Thinner 107
Spray: 15-20% Thinner 900
Dry to touch: 3-4 hours (20°c)
Recoat time: 12 - 24 hours (20°c)
Application temp.: Between +10°c and +40°c
Relative humidity: less than 80%
T. Coverage: 10 m²/Lt at 30 dry microns

FILLERS

Fillers are specifically formulated to repair and smooth any surface irregularities which can be present on the boat due to bumps, scratches or manufacturing faults

Fillers are usually applied by spatula or with a striker and may build-up high thicknesses. They are easy to sand and therefore suitable for restoring the original surface smoothness. Although they give a tough finish they are at the same time reasonably flexible to withstand cracking during the movement of the boat.

MAIN CHARACTERISTICS
Effective levelling and smoothing of the surface of the hull.

Minimal loss of thickness and volume after sanding.

Fillers should always be sandwiched between a suitable primer and overcoated with a suitable undercoat to prevent water penetration to the substrate.

There are different types of fillers (e.g. synthetic, polyester, epoxy) each specifically formulated for different surface requirements.

When possible the use of two-component epoxy fillers is always advisable, which guarantee better waterproofing, minimum water absorption, and outstanding solvent resistance; they are more flexible than polyester fillers(used in the automotive and building industry) and, if necessary, they may also be applied below the waterline.

Base and hardener of two component fillers are supplied in a different colour to ensure a correct mixing of the two components, until a uniform colour without streaks is obtained.

TWO-COMPONENT FILLERS

EXPOXY LIGHT FILLER NS – High thickness epoxy filler

Two-component light epoxy filler for high thickness surface levelling on steel, aluminium and light alloy boats and cement walls. This filler is very flexible and can be applied in a single coat. Its low specific gravity formulation allows to limit the product load onto the coated substrate. Widely used in boat coating systems.

Code: 7F5951 **Pack.:** 0,5l 5l 36l

Colour: Sol.A Light Green / Sol.B White A+B
A+B Mix by volume: 1 part Sol.A + 1 of Sol.B
Pot life: 1 hour at 20°C.
Spatula: Ready to use
Tool cleaning: Use Thinner 765
Ford cup viscosity 4 a 20 Ø C.: Thixotropic
Touch dry: 3-4 hours (at 20°c)
Sanding: after 24-48 hours (at 20°c)
Recoat time: after 24-48 hours (at 20°c)
T. Coverage: 0,1 m²/Lt with a thickness of 1 cm

PLAMUR FINISHER MDF – Finishing filler

Two-component epoxy finishing filler applied at low thickness for smoothing small and large surfaces of boats. Used in two-component coating systems. Once sanded provides a smooth and even finish ready to be overcoated.

Code: 7F6332 **Pack.:** 1l 5l

Colour: Sol.A White / Sol.B Grey
A+B Mix by volume: 1 part Sol.A + 1 part Sol. B
Pot life: 1 hour at 20°C.
Spatula: Ready to use
Ford cup viscosity Ø 4 at 20°C.: Thixotropic
Touch dry: 6-8 hours (at 20°C.)
Sanding: after 24 hours (at 20°C.)
Recoat: minimum 24-36 hours
T. Coverage: 4 m²/Lt at 300 microns

TWO-COMPONENT FILLERS

POLISTUK – Polyester filler

Two-component polyester filler widely used thanks to its easy application and general purpose characteristics. It can be used for high thickness application but also when a light surface levelling is required. Provides good adhesion and good sanding properties. It can be applied onto steel, cast iron, fibreglass and hard plastic material. The application of a suitable primer is recommended in case of application on aluminium, brass or zinc substrates.

Code: 7F6413 **Pack.:** 0,25l 0,75l

A+B Mix by weight:
from 0 to 10°C: + 3% of catalyst Sol.B
from 11 to 20°C: +2% of catalyst Sol.B
above 20°C: +1% of catalyst Sol.B

Pot life: from 0 to10°C: approx.9-12 minutes
from 11 to 20°C: approx.6-9 min
above 20°C: approx. 6 min.

Spatula: Ready for use

Tool cleaning: Thinner 765

Ford cup viscosity Ø 4 at 20°C.: Thixotropic

Touch dry: approx. 45 minutes (at 20°C)

Sanding: approx. 45 minutes (at 20°C)

Recoat time: 3-4 hours (at 20°C)

T. Coverage: 2 m²/Lt for 500 dry microns

ONE-COMPONENT FILLERS

SINTOFILLER – Synthetic filler

One component synthetic filler providing excellent adhesion and filling power with good sanding properties. It can be applied on wood but also on metals previously prepared with a suitable primer. Recommended for light surface levelling and to smooth and make even any irregular surface. It can be overcoated with any type of synthetic paint suitable for wood and metals. Sintofiller is widely used for surface levelling of boats in one component coating systems and also in the wood industry and for do-it-yourself purposes to fill up holes, cavities and any surface irregularity. Sintofiller makes the surface perfectly smooth and even before painting.

Code: H30580 **Pack.:** 0,5l 2,5l

Colour: White

Spatula: Ready to use

Equipment cleaning: Thinner 107

Ford cup viscosity Ø 4 at 20°C.: Thixotropic

Touch dry: approx. 45 minutes (at 20°C.)

Sanding: after approx.24 hours (at 20°C.)

Recoat time: 24-48 hours (at 20°C.)

T. Coverage: 1,8 m2/Lt for 500 dry microns

RESINS AND GELCOAT

EPOSEALER IMPREGNAZIONE E ANTIOSMOSI – Epoxy resin

It is a solvent free liquid epoxy resin, activated with a cyclo-aliphatic amine, with high insulation and adhesion power. Thanks to its characteristics of penetration, adhesion, flexibility and water resistance performs a waterproof film on the wood surface while maintaining its natural properties. It is therefore the most suitable product for the treatment and maintenance of wood. Provides also outstanding anti-osmosis properties when used on fiberglass boats.

Code: G44200 **Pack.:** 0,75l 1,5l 6l

Application: Brush, roller and spray

A+B Mix by volume: 2 Part Sol.A with 1 Part Sol.B

A+B Pot life (20°C): Use mixture within 30-40 min.

Brush, Roller: Ready to use / as a base coat on bare wood 40-50% Thinner 765 or Epowood

Recoat time: 24 hours (20°C)

Relative humidity: Below 80%

Thickness: 100 dry microns per coat

T. Coverage: 5 m²/Lt or 3-4 m²/Kg

EPOSEALER INCOLLAGGIO – Epoxy bonding resin

It is a solvent free liquid epoxy resin, activated with a cyclo-aliphatic amine, with high insulation and adhesion power. Used for bonding wood on wood, wood on fibreglass and fibreglass on fibreglass.

Code: G44201 **Pack.:** 0,75l 1,5l 6l

Application: Brush, roller and spray

A+B Mix by vol.: 2 Parts Sol.A with 1 Part Sol.B

A+B Pot life (20°C): Use mixture within 30-40 min.

Brush, Roller: Ready to use

Curing time: 7 days

Recoat time: 24 hours (20°c)

Relative humidity: Below 80%

Thickness: 100 microns per coat when dry

T. Coverage: 5 m²/Lt or 3-4 m²/Kg

RESINA POLIESTERE – Polyester resin

It is a medium reactive thixotropic and accelerated orthophthalic unsaturated polyester resin, specifically formulated for use in the nautical sector for the construction and restoration of boats. If necessary, glass-fibre strand mat or filling compounds (e.g.Microcel) can be added to the polyester resin.

Code: 3P6043 **Pack.:** 0,77l 4,1l 20,4Kg 230Kg

Application: brush

Mixing ratio by weight : Add 2% of activator

Temperature (A+B Pot life): 20°C

Brush, Roller: Ready to use

Recoat time: 24 hours (20°c)

Relative humidity: Below 80%

T. Coverage: 2 m²/Lt depending on thickness applied

GELCOAT – Paraffinated gelcoat

Paraffinated gelcoat formulated with ortophtalic-resins providing good light fastness and weather resistance. Gelcoat is the "skin" of the structure and its purpose is to protect from weather and sunlight exposure and in some cases against chemicals. Gives the substrate a continuous and smooth finish.

Code: 7F6375 & 94GE **Pack.:** 1.02Kg 5,1Kg

Application: Soft bristle brush and roller

Pot life A+B (20°c): Use mixture within 4-12 min.

Brush, Roller: Ready to use

Relative humidity: Below 80%

Thickness: 400-900 dry microns per coat

T. Coverage: 0,7-0,9 m² depending on thickness applied

Mixing ratio: Add 1.5-2% of MEKP

Tool cleaning: Use acetone

BINDERS AND COLOUR BASES

SPACE TOP – Binder for high flowing gloss enamel

Clear binder for two-component Space Top polyurethane enamel, to be used in combination with the concentrated colour bases of our colour mixing system, to obtain any desired colour for a high quality gloss finish. Performs the same coverage and brush application characteristics of Space Top enamel direct formulation.

Code: 2WNE00 **Pack.:** 1,1l

Application: Brush, Roller

A+B Mix by weight: 100 Parts Sol.A (70 p. Binder+ 30 p. Colour bases) with 40 Part.Sol.B

Pot life A+B (20°C): Use mixture within 6-8 hours

Brush,Roller: 20-30% Thinner 201 at temperature above 23°C or Thinner 205 for temperature below 23°C

Spray: 20-35% Thinner 201 at temperature above 23°C or Thinner 205 and/or Thinner 203 at temperature below 23°C

Dust free: 3-4 hours (20°c)

Recoat time: 24 hours (20°c)

T. Coverage: 13-14 m^2/Lt for 40 dry microns per coat

POLIURETANICO BUCCIATO – Binder for textured finish

Clear binder for two-component semi-gloss textured polyurethane enamel, to be used in combination with the concentrated colour bases of our colour mixing system. Gives an "orange-peel" finish recommended for topsides and superstructures of boats and where it may be necessary to reduce uneveness or imperfections of the surface. Resistant to agressive environments.

Code: 4DNE00 **Pack.:** 0,915l 1,83l

Application: Brush, roller and spray

A+B Mix by weight : 8 parts of Sol.A (75 p. Binder+ 25 p. Colour bases) with 1 of Sol.B

Pot life A+B (20°C): Use mixture within 4 hours

Brush, Roller, Spray: 2-5% Thinner 203

Dust-free : 30-40 minutes (20°C)

Recoat time: 24 hours (20°C)

Application temperature: Between +10° C and +40 °C

Relative humidity: Below 80%

T. Coverage: 3-4 m^2/Kg at 100 microns dry

CONCENTRATED COLOUR BASES

Concentrated colour bases used in combination with our clear binders in our colour mixing system.

Code: 8WP & 7R **Pack.:** 1l 3,5Kg 4Kg 6Kg

Colour:

White	Violet
Black	Red light
Yellow oxide	Purple
Red oxide	Yellow light
Yellow lemon	Yellow gold l.
Yellow chrome	Orange light
Orange molibdate	Yellow HR Bike
Green ftalo	Extender White
Blue ftalo	Matting addiitive
Bright Red	Drying solution

PAINT REMOVERS

STRIPCARENA – Water based

Water-soluble paint remover formulated with non-toxic compounds. Removes old antifouling paints from fibreglass hulls without impairing the gelcoat or the glass-fibres reinforced polyester material.

Code: 7K6015 **Pack.:** 0,75l 5l

Complete drying: 1-3 hours (at 20°C)

Application temperature: Between +10°C and +40°C

Relative humidity: Below 80%

T. Coverage: 2-3 m2/Lt a 500 dry microns

FIBREGLASS CHOPPED STRAND MAT & WOVEN ROVING

Reinforcement material for fibreglass structures. These reinforcing fibers are the mechanical structure of the composite and can be compared to steel tods used in reinforced concrete. These products are designed to be used in combination with ortophtalic and isophthalic resins, vinylesters, epoxies, etc. Used for the manufacturing and repair of boats, vehicles parts and sport equipments.

STRAND MAT: available in 45/50 Kg rolls (300 or 450 gr/m²) or in 1m2 sheets (300gr/m²)

WOVEN ROVING: available in 45/50 Kg rolls (300 or 500 gr/m²) or in 1m2 sheets (500gr/m²)

Code: 94MAT0 94STUO

MICROCEL – Ultralight micro-balloons

Microcel are very light glass microspheres of entirely mineral composition (glass or silicate), made up of perfectly spherical shaped and waterproof transparent bubbles which come in the form of very fine powder. Microcel are primarily used as a light filling compound (its specific gravity is equal to 100 g/Lt.) added to polyester and epoxy resins with the aim of obtaining an inexpensive low-density composite material . Directly mixed into the resin of up to 60-80% by volume they remarkably reduce the specific gravity of the mixture.

Usable as a filling compound in polyester and epoxy resins to obtain inexpensive composite products of low intensity and provide outstanding strenght to the structure.

Code: 7T6047 **Pack.:** 0,1Kg 25Kg

COMPLEMENTARY PRODUCTS

TECNOCEL – Microfiber filling compound

Microfiber of pure cellulose, used as functional filler. Its specific gravity is equal to grams 250/Lt. If mixed with epoxy resin acts as a high strenght filler. The filamentous nature of Tecnocel gives a multi-purpose solid compound providing high resistance to the structure and improved characteristics of flexibility. We recommend to add Tecnocel to the resin mixture up to 100-200% by volume.

Usable as a filling compound in polyester and epoxy resins to obtain inexpensive composite products of low intensity and provide remarkable strenght to the structure.

Code: 7T6041 **Pack.:** 0,25Kg 20Kg

ANTISKID – Microspheres

Glass microspheres that can be added to any type of paint (one or two-component enamel or varnish) to give a hard wearing non-slip surface.

Application: add to paint or varnish up to approx. 20-30% by weight. In alternative apply by sieving them onto the wet paint film.

Code: 7L0000 **Pack.:** 0,25Kg 25Kg 1Kg

SERENISSIMA SPRAY – Antifouling spray paint

Antifouling in a spray can that dries quickly for application on propellers and outdrives. Provides a good grip over fiberglass, plastics, metal and on previous applications. In case of aluminium surface it should be applied on a suitable primer. Protects surfaces from marine fouling.

Code: 94BAN **Pack.:** 0,4l

Colour: Grey, Black, White, Transparent
Application: Ready to use
Ford cup viscosity Ø 4 at 20°C.:12-14"
Touch dry: 15-20 minutes (at 20°C)
Recoat time: 24 hours (at 20°C)
Launching time: minimum 24-48 hours
T. Coverage: 2-4 m²/Lt at 20-30 dry microns

ENVIRONMENT, HEALTH AND SAFETY

This is a summary section where you can find our safety tips to minimize health and environmental hazards.The label that you find on each paint can contains all the precautionary measures to be taken before starting application

- Please carefully read all safety precautions indicated on the label or in the safety & technical data sheets.
- Wear protective equipment.
- Cover the application area with protective material such as plastic drop sheets etc.
- Follows local laws and regulations.
- Ensure there is sufficient space to carry out paint application and check weather conditions to ensure that paints can be applied and dries within the recommended time.
- Avoid inhalation of the products.
- Wet sanding is recommended if possible in order to avoid dust contamination.
- Apply in a well ventilated area.
- Wear suitable respiratory equipment when spraying.
- Wear suitable protective clothing and eye/face protection when using solvent based products.
- If possible use a dust extractor unit when sanding.
- Use suitable high quality tools (brushes rollers, etc.).
- Dispose of empty containers and paint residues to an authorized waste collection centre.

AEMME COLORI SRL
Via Patta 12
24020 Ranica (Italy)

Tel: +39 035.513373
Fax: +39 035.513211
Email: info@aemmecolori.it

www.aemmecolori.it

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