

Outboards/Superstructures and Masts

Boats to be repainted



Preparation:

Scrape the areas that are scaling. Sand dry with P 220/240 or red Scotch Brite; remove all dust and clean. If profiling is necessary apply a coat of DELTA 2000 directly on the nude sanded surface and then surface with EPOLIGHT for large imperfections and/or EPOMAR or EPOXYCOQUE to shave.

Nr. coats	Product Code	Interval between coats		Thickness of layer in µm per coat		Theor. coverage mq/L per coat	Thinner (%)	Application remarks
		min. (hrs)	max. (hrs)	wet	dry			
Two-component cycle on old two-component enamel								
1	DELTA UC HB ^(*) 636.051	12	72	325	150	3,5	693 (15)	Sand with P280.
1	FUTURA UC 655.001 or EPOPLY 962	8	24	250	125	4	696 (15)	Sand with P400.
1		12	36	250	125	4	693 (5)	
2	Glossy finish FUTURA 668. ...	12	36	100	40	13	697 ^(**) (30)	Sand dry between coats with P500.
2	or alternatively CHALLENGER HI-TECH 684. ...	12	36	125	50	8	697 (20-30)	See above.
2	orange-peel semi-glossy finish BISE 635.001	8	48	210	100	5	697 (5-15)	If 48 hours pass between coats, sand with P240 or grey Scotch Brite.
Single component cycle on old synthetic enamel								
1	ANCHORPRIMER 627	6	48	50	10	19	693 (10)	Sand with P360.
2	ALTURA 92 640. ...	18	...	75	35	14	703 (5)	Sand between coats with P400 or grey Scotch Brite

^(*) apply if the surface is in poor condition (microporosity).

^(**) To spray the enamel please consult the technical sheets.

New or restored boats



Preparation:

Rub with P360/400. Carefully wash by hand with a grease and wax detergent SIRIO to remove all traces of wax from the mould and then rinse with fresh water. Let dry completely.

Nr. coats	Product Code	Interval between coats		Thickness of layer in µm per coat		Theor. coverage mq/L per coat	Thinner (%)	Application remarks
		min. (hrs)	max. (hrs)	wet	dry			
Two-component cycle								
1	FUTURA UC ^(*) 655.001 or EPOPLY 692.001	8	24	250	125	4	696 (15)	Sand with P400.
1		12	36	250	125	4	693 (5)	
2	Glossy finish FUTURA 668. ...	12	36	100	40	13	697 (30)	Sand dry between coats with P500.
2	or alternatively CHALLENGER HI-TECH 684. ...	12	36	125	50	8	697 (20-30)	See above.
2	orange-peel semi-glossy finish BISE 635.001	8	48	210	100	5	697 (5-15)	If 48 hours pass between coats, sand with P240 or grey Scotch Brite.
Single component cycle								
1	ANCHORPRIMER 627	6	48	50	10	19	693 (10)	Sand with P360.
2	ALTURA 92 640. ...	18	...	75	35	14	703 (5)	If 48 hours pass between coats, sand with P400 or grey Scotch Brite.

^(*) apply if the surface is in poor condition (microporosity).

Outboards/Superstructures and Masts

Wood



New or restored boats

Preparation:

The wood must be perfectly dry and free from all traces of dirt, grease, dust or old paint. Sand with P 100. If profiling is necessary, apply DELTA 2000 directly on the wood and then apply EPOLIGHT for large imperfections and/or EPOMAR or EPOXYCOQUE 401 to shave.

Nr. coats	Product Code	Interval between coats		Thickness of layer in µm per coat		Theor. coverage mq/L per coat	Thinner (%)	Application remarks
		min. (hrs)	max. (hrs)	wet	dry			
Two-component cycle								
max. wood dampness 18%								
2	RESIN W.S. 660.105 + hardener of choice 661.205 o 661.206	3	24	100	100	10 ⁽¹⁾	-	If 24 hours pass between coats and before applying DELTA UC HB, wash with fresh water using grey Scotch Brite.
1	DELTA UC HB 636.051	12	72	325	150	3,5	693 (15)	Sand with P280.
1	FUTURA UC 655.001 or	8	24	250	125	4	696	Sand with P400.
1	EPOPLY 962	12	36	250	125	4	693 (5)	
2	Glossy finish FUTURA 668. ...	12	36	100	40	13	697 (30)	Sand dry between coats with P500.
2	or alternatively CHALLENGER HI-TECH 684. ...	12	36	125	50	8	697 (20-30)	See above.
2	orange-peel semi-glossy finish BISE 635.001	8	48	210	100	5	697 (5-15)	If 48 hours pass between coats, sand with P240 or grey Scotch Brite.
Single component cycle								
max. wood dampness 20%								
1	MISTRAL undercoat 628.051	8	...	120	40	7	703 (30)	Apply directly to the wood with a penetrating function.
1	MISTRAL undercoat 628.051	8	...	150	60	5,5	703 (10)	Apply thickly for waterproofing.
1	SYNTHETIC UNDERCOAT 957	24	...	75	40	15	703 (10-20)	Sand with P400.
2	ALTURA 92 640. ...	18	...	75	35	14	703 (5)	Sand between coats with P400 or grey Scotch Brite

⁽¹⁾ apply if the surface is in poor condition (microporosity).

New or restored boats

aluminium



Preparation:

Wash, using pressurised water if possible, using a suitable detergent and rinse with fresh water. Roughening sandblast with fine sand or sand dry with P100. blow well with air and remove all dust.

Nr. coats	Product Code	Interval between coats		Thickness of layer in µm per coat		Theor. coverage mq/L per coat	Thinner (%)	Application remarks
		min. (hrs)	max. (hrs)	wet	dry			
Two-component cycle								
1	DELTA 2000 653. ...	12	72	95	40	11	693 (10)	If 72 hours pass from application, sand with P 180.
(*)	EPOLIGHT WIN 656.001	24	72	5 mm	5 mm	0,2	-	Sand dry between coats with P80.
(*)	EPOMAR 604.001	24	72	1 mm	1 mm	1	-	Sand with P120.
1	DELTA UC HB 636.051	12	72	325	150	3,5	693 (15)	Sand with P280.
1	FUTURA UC 655.001 or	8	24	250	125	4	696 (15)	Sand with P400.
1	EPOPLY 962	12	36	250	125	4	693 (5)	
2	Glossy finish FUTURA 668. ...	12	36	100	40	13	697 (*) (30)	Sand dry between coats with 3M 255 P500.
2	or alternatively CHALLENGER HI-TECH 684. ...	12	36	125	50	8	697 (20-30)	See above.
2	orange-peel semi-glossy finish BISE 635.001	8	48	210	100	5	697 (5-15)	If 48 hours pass between coats, sand with P240 or grey Scotch Brite.

(*) The number of coats to apply varies based upon the desired thickness

(**) To spray the enamel please consult the technical sheets.

EPOLIGHT: max. recommended thickness 2 cm. EPOMAR: max. recommended thickness 3 mm.

New or restored boats

steel



Preparation:

Sandblast to grade SA 2,5 or, for small surfaces, sand with P100. Note: immediately following the sandblasting apply the ZP 632 galvaniser.

Nr. coats	Product Code	Interval between coats		Thickness of layer in µm per coat		Theor. coverage mq/L per coat	Thinner (%)	Application remarks
		min. (hrs)	max. (hrs)	wet	dry			
Two-component cycle								
1	ZP 632 632.051	8	...	75	30	16	693 (20)	
1	DELTA 2000 653. ...	12	72	95	40	11	693 (10)	If 72 hours pass from application, sand with P 180
(*)	EPOLIGHT WIN 656.001	24	72	5 mm	5 mm	0,2	-	Sand dry between coats with P80.
(*)	EPOMAR 604.001	24	72	1 mm	1 mm	1	-	Sand with P110.
1	DELTA UC HB 636.051	12	72	325	150	3,5	693 (15)	Sand with P280.
1	FUTURA UC (*) 655.001 or	8	24	250	125	4	696 (15)	Sand with P400.
1	EPOPLY 962	12	36	250	125	4	693 (5)	
2	Glossy finish FUTURA 668. ...	12	36	100	40	13	697 (*) (30)	Sand dry between coats with P500.
2	or alternatively CHALLENGER HI-TECH 684. ...	12	36	125	50	8	697 (20-30)	See above.
2	orange-peel semi-glossy finish BISE 635.001	8	48	210	100	5	697 (5-15)	If 48 hours pass between coats, sand with P240 or grey Scotch Brite.

(*) The number of coats to apply varies based upon the desired thickness

(**) To spray the enamel please consult the technical sheets.

EPOLIGHT: max. recommended thickness 2 cm. EPOMAR: max. recommended thickness 3 mm.