# YACHT ENAMEL 1 K

## Technical information

**Product components :** YACHT ENAMEL 1K (1-COMPONENT)

**Volume:** 750 ml
125 ml pure white (RAL 9010),

**Product Description :** 1K YACHT ENAMEL Sea-Line charactericed by:

- excellent flow
- hiding power
- stability
- high gloss
- UV and chalk resistance

Easy in application. It can be applied on laminates, steel and wood.

Applicable to exterior areas above the water line and interior areas

**Physiochemical characteristics :**

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| Colour of product: | pure white (RAL 9010),crem (RAL 9001), flame red (RAL 3000), gentiane blue (RAL 5010), jet black (RAL 9005) |
| Gloss: | high |
| Solid parts: | 65% |
| Theoretical yield: | 15 ÷ 16 $m^2$/l for the thickness of 40 µm |
| Density of the mixture: | 1,00 kg/l |
| Coat thickness (WFT): | 60 µm wet coat |
| Finish thickness (DFT): | 40 µm dry coat |

**NOTICE :** The equivalents of the RAL template assigned to particular colors of the 1K Sea-Line yacht enamel are only a guide. The actual color shade may slightly differ from the RAL template due to variable application parameters (application method, nozzle diameter used, working pressure, layer thickness)

When performing painting works, it is recommended to use one production batch of a given product.

**Preparing the surface :** Before application of paint, surfaces should be primed :

- Universal Yachtprimer 1K Sea-Line®
- Epoxy Lightprimer 5:1 Sea-Line®
- Epoxy primer anticorossion 4:1 Sea-Line®
- Epoxy WOODPRIMER 10:4 Sea-Line®

Next:

- All contaminations remove by fresh water
- Primed surfaces grind :
  - Epoxy primers Sea-Line sand paper P320-P400
  - Universal Yachtprimer 1K Sea-Line does not require interlayer sanding
- Remove all sanding residues. Degrease with Cleaner Sea-Line
- Before application wait till surface dry

**Conditions for application** Air temperature should be higher than 5°C and paint temperature minimum 15°C
Air temperature should not be higher than 30C

**Method of application :** spray gun, brush, roller

**Thinner :** You may dilute the mixture by adding thinner to Sea-Line 1K systems at a rate of

- Brush/roll 0÷10%
- Spray gun 0÷10%

**Component mixing :**

- Mix product thoroughly in can.
- Depend on application system add 1K Thinner Sea-Line
- Mix ingredient thoroughly to obtain uniform color.

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| **Number of coats :** | 1÷2 layers |
| **Hardening of coating:** | **20°C** |
| Dry to the touch: | 3 hours |
| Resistant against rain: | 6 hours |
| Fully woterprof: | 10 hours |
| **Elapsed time before applying next coat :** | Min 16 hours |

The given times must be considered as guidelines for application of layer in thickness 40 µm DTF. The actual drying time may be shorter or longer and depends on film thickness, ventilation, humidity, underlying paint system etc.
Maximum recoating without sanding paint is applied only when the surface is free from chalking and other contamination. If the paint coating was exposed to direct sunlight, it must be clean and sanding. The removal of the top layer will provide a good grip

**Pneumatic spraying parameters :**

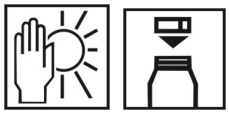
tip size : 1,2÷1,4 mm
pressure: 2,0÷2,5 bar

**Further Work :** After curing protect surface using S4 Protect Wax.

**Notice :** Boat should not be launched until last layer of top coat will not cured

**HSE conditions :** Please follow safety instructions from the technical data sheet for hazardous chemical and follow Polish workplace safety laws. The general rule is to avoid contact with skin and eyes. When using the product in a small, enclosed space you must provide forced ventilation. It is also recommended that you protect your respiratory system, eyes, and skin. Be particularly careful of fire as the product may explode

**Storage :**



Product components should be kept in tightly sealed containers, at a temperature between 5-35°C, away from sources of fire, heat, and sun rays.
Close the containers tightly immediately after every use.

**Expiration date:** 24 months from the date of production

All data in this document have been prepared for informational purposes. We can not take responsibility for the results of user actions over which we have no control. Responsibility of the user is to make the test sample and determine the suitability of the product for individual applications.Sea-Line do not take responsibility for any damages, or loss of profits associated with the improper use of the products.

All information is based on scrupulous laboratory research and many years of experience. Our position of market leadership does not free us from constant quality control of our products. However, we do not accept responsibility for the effects of improper use or storage of our products, or for the effects of using our products in any way contrary to the standards of good workmanship.

TROTON sp. z o.o. Ząbrowo.