

Professional two-component varnish system (spray application)

July 2023

Products: Epifanes PP Varnish Extra + Epifanes PU Speedcoat Clear Gloss



General surface preparation of neutral wood types, i.e. mahogany, meranti, Oregon pine

Make sure that the wood is dry and thoroughly degreased. Moisture content must be between 12 - 17%. Wipe down wood with Epifanes Thinner for PP varnish Extra, acetone or other aggressive degreaser and allow to evaporate. Use multiple (paper) towels and turn them regularly.

If needed, first sand the wood to a fresh surface using dry abrasive paper P60-80. Subsequently sand with finer grits from P100 towards P220 dry. Always sand along the wood grain. Remove all sanding dust and degrease once more. Allow to fully evaporate before applying varnish.

General surface preparation of tropical wood type, i.e. teak and iroco

Tropical wood contains natural acids that may cause adhesion problems. A thorough surface preparation may overcome this. Clean and degrease tropical wood with ample amounts of Epifanes Thinner for PP varnish Extra, acetone or other aggressive degreaser and allow to evaporate. Use multiple (paper) towels and turn them regularly. Do not use water! This may activate the wood acids.

If needed, first sand the wood to a fresh surface using dry abrasive paper P60-80. Subsequently sand with finer grits from P100 toward P180 dry. Always sand along the wood grain. Remove all sanding dust and degrease once more. Allow to fully evaporate before applying varnish.

This varnish system is sprayable by HLVP and RP spray guns. For finest spray results application by RP is advised.

Spray settings at 20°C. and max. 70% RAH:

	Epifanes PP Varnish Extra	Epifanes PU Speedcoat
Thinner	Thinner for PP Varnish Extra	Thinner for PU Speedcoat
Thinning ratio	5-20%	15-25%
Pressure on nozzle	2.0 – 2.2 bar	2.2 bar
Nozzle	1.1 – 1.6 mm	1.1 – 1.3 mm
Viscosity DIN-cup 4	17 ± 2 seconds	18 – 20 seconds



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Coat #	Product	Thinning %	Filmthickness		Brush/spray	Recoatibility in hours			Sandable
			wet	dry		12°C.	20°C.	28°C.	
1.*	PP Vernis Extra	50%	70-90µm	15-20µm	brush	4	3	2	24 hours
2.*	PP Vernis Extra	25%	70-90µm	20-30µm	brush	4	3	2	24 hours
3.*	PP Vernis Extra	10%	70-90µm	25-35µm	brush	4	3	2	24 hours
After 3 coats, allow 48 hours to cure. After 48 hours, sand with P280									
4.	PP Vernis Extra	5-20%	70-90µm	35-45µm	Spray	3	2	2	24 hours
5.	PP Vernis Extra	5-20%	70-90µm	35-45µm	Spray	3	2	2	24 hours
6.**	PP Vernis Extra	5-20%	70-90µm	35-45µm	Spray	3	2	2	24 hours
After 6 coats, allow 7 days to cure. After 7 days, sand with P320									
7.	PU Speedcoat	15-25%	70-90µm	35-45µm	Spray	2	1	1	24 hours
8.	PU Speedcoat	15-25%	70-90µm	35-45µm	Spray	2	1	1	24 hours
9.	PU Speedcoat	15-25%	70-90µm	35-45µm	Spray	2	1	1	24 hours
10.***	PU Speedcoat	15-25%	70-90µm	35-45µm	Spray	2	1	1	24 hours

Remarks on system build up:

* Apply building coats # 1 - 3 by longhaired soft brush. Brush application will avoid solvent entrapment and solvent popping by trapped air in the wood pockets To minimize sinking of the varnish system, allow each 3rd. coat 48 hours to cure. After 48 hours, sand with P320.

** Depending on type of wood, saw cut and (open) wood structure more building coats of PP Varnish Extra may be necessary. Allow to total of building coats at least 7 days to cure and sink. After 7 days, sand with P320. More coats are always better. The optimal system contains 15 coats of Epifanes PP Varnish Extra.

*** Allow the whole system 48 hours to cure. In case of polishing, always apply a fourth coat of PU Speedcoat. For longer gloss retention, more coats PU Speedcoat may be applied.

Note: For a good condition of the varnish system, do not replace building coats of PP Varnish Extra by coats of PU Speedcoat.

Polishable after 7 days curing time (20°C.).

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