

PRODUCT NAME

Monothane 2K Topcoat

ORIGINALLY ISSUED

25/03/2011

VERSION

1.0

PRODUCT CODE

TOPMON

VERSION DATE

25/03/2011



PRODUCT DESCRIPTION

Monothane is a 2K Polyurethane Finish. Designed for use on Ferrous substrates without the need for a Primer. Provides excellent corrosion resistance. Good gloss level and excellent durability. It can be used on mild steel, shot blasted steel and also has excellent adhesion to a wide range of plastics without the need for a plastic primer. Monothane is suitable for airless application.



IMPORTANT INSTRUCTIONS BEFORE USE

- Read and follow SDS, TDS and label instructions
- Stir all paints thoroughly before use
- Always use the same batch number on the same job
- Check colour & sheen. HMG will not accept any discrepancies arising after use
- Filter the product immediately before use
- Reduce emissions and maintain quality by replacing tin lid after use
- If in any doubt speak HMG Technical Service Department on (0161) 205 7631



CURING INFORMATION

FORCE DRY: 20-30mins@70-80°C



MAXIMUM VOC CONTENT (RFU)

0.420Kg/L

REGULATIONS / COMPLIANCE

- 2004/42 IIB (D) 420



COLOUR RANGE

- Available in a wide colour range including RAL & BS shades



PACKAGING

Various pack sizes available.



GENERAL INFORMATION

Coverage 17-22 square metres per litre @ 25 microns DFT depending on colour and gloss.
Flashpoint 24°C
Storage Store between 5°C - 25°C. When not in use, cans must be kept sealed
Shelf Life 12 months from delivery date in original sealed containers



ADDITIONAL TECHNICAL INFORMATION

WEIGHT SOLIDS: 56-70% depending on colour.
GLOSS: 80% available.



CLEANING

Ensure surfaces to be coated are dry and must be cleaned using the appropriate HMG product to remove all traces of contaminants. HMG produce a full range of cleaners, silicone removers, degreasers and preparatory cleaners suitable for the cleaning process. Please refer to our website for Knowledge Base article Prep-Cleaning Techniques (KNB0009) and Preparatory Cleaners from the Product Guide.



SURFACE PREPARATION

Please refer to Knowledge Base for details on Surface Preparation.



SUGGESTED PRIMER / FILLER / SEALER SYSTEMS

- ST3000 2K Yellow Etch Primer



HEALTH AND SAFETY











- Refer to SDS and tin label prior to use.
- RFU product contains isocyanates. Suitable air fed respiratory equipment should be worn when spraying.

APPLICATION METHODS



MIXING RATIO

COMPLIANT SPRAY GUN		AIRLESS/AIR-ASSISTED		COMPLIANT SPRAY GUN		AIRLESS/AIR-ASSISTED	
Base	2	Base	2	Base	3	Base	3
Hardener	1	Hardener	1	Hardener	1	Hardener	1
Thinner	10-15%	Thinner	10-15%	Thinner	10%	Thinner	10%

	HARDENER OPTIONS							
	Hardener 9004 Standard		Hardener 9004 Standard		Hardener 9039		Hardener 9039	
	THINNER OPTIONS							
	Thinner 2601		Thinner 2601		Thinner 2601		Thinner 2601	
	Thinner 2602		Thinner 2602		Thinner 2602		Thinner 2602	
	Thinner 2603		Thinner 2603		Thinner 2603		Thinner 2603	
	Thinner 2604		Thinner 2604		Thinner 2604		Thinner 2604	
	VISCOSITY							
	20 - 25		seconds B4 cup		20 - 25		seconds B4 cup	
	20 - 25		seconds B4 cup		20 - 25		seconds B4 cup	
	SPRAY GUN SETUP							
	1.6 - 1.8		11 - 13 thou / 40 - 50°		1.6 - 1.8		11 - 13 thou / 40 - 50°	
	NUMBER OF COATS (GUIDE ONLY)							
	1-2 coats		1-2 coats (2nd coat optional)		1-2 coats		1-2 coats (2nd coat optional)	
	FLASH OFF							
	10 mins between coats 10 mins before baking		10 mins between coats 10 mins before baking		10 mins between coats 10 mins before baking		10 mins between coats 10 mins before baking	
	DRYING TIME							
	Touch dry		1hr		Touch dry		1hr	
	Full dry		Overnight		Full dry		Overnight	
	Force dry		20-30min@		Force dry		20-30min@	
	.		70-80°C		.		70-80°C	
	POT LIFE							
	1hr to double viscosity depending on temp.		1hr to double viscosity depending on temp		1hr to double viscosity depending on temp		1hr to double viscosity depending on temp.	
	WET FILM THICKNESS*							
	50-200 microns 1-2 coats		50-200 microns 1-2 coats		50-200 microns 1-2 coats		50-200 microns 1 coat	
	DRY FILM THICKNESS*							
	25-100microns 1-2 coats		25-100microns 1 coat		25-100microns 1-2 coats		25-100microns 1 coat	

* - HMG Technical Data Sheets indicate a Dry Film Thickness that will be achieved when applying a particular Wet Film Thickness. These values are a guide only and are not to be used as specifications. Film thickness will vary depending on actual use and specification. Great care should be taken to achieve the dft stated in the agreed specification and to avoid areas of excessively low or high thickness.

This information relates only to the specific material designated and may not be valid for such material used in combination with any other materials or in any process. Such information is to the best of HMG's knowledge and belief accurate and reliable as of the date indicated. However, no representation, warranty or guarantee is made as to it's accuracy, reliability or completeness. It is the user's responsibility to satisfy themselves as to the suitability and completeness of such information for their own particular use. For professional use only.