

**PRODUCT NAME**

Nisocoat 2 Gloss

**ORIGINALLY ISSUED**

21/04/2021

**PRODUCT CODE**

**VERSION**

1.0

**VERSION DATE**

21/04/2021



**PRODUCT DESCRIPTION**

A 2K Non-Isocyanate Acrylic product formulated to provide a tough, chemically resistant, high quality coating.



**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



**MAXIMUM VOC CONTENT (RFU)**

0.565Kg/L



**COLOUR RANGE**

- Available in Clear and a wide colour range including Fleet, RAL & BS and Automotive shades.



**GENERAL INFORMATION**

Specific Gravity 1.23  
Coverage 15 square metres per litre @ 30microns assuming 100% transfer efficiency  
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



**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.



**ADDITIONAL INFORMATION**

ST3000 LF 63 Chromate Free 2K Etch Primer is suitable for use with Nisocoat 2 on Aluminium/Alloy substrates, only in conjunction with a suitable intermediate primer (2K Acrylic or Polyurethane). ST3000 alone is not recommended



**HEALTH AND SAFETY**

- Refer to SDS and tin label prior to use.
- Suitable respiratory equipment should be worn when spraying.

**APPLICATION METHODS**



**MIXING RATIO**

COMPLIANT SPRAY GUN		PRESSURE POT		COMPLIANT SPRAY GUN		PRESSURE POT	
Clear Base	2	Clear Base	2	Coloured Base	2	Coloured Base	2
Hardener	1	Hardener	1	Hardener	1	Hardener	1
Thinner	<0.75	Thinner	<0.75	Thinner	<0.75	Thinner	<0.75



**HARDENER OPTIONS**

Hardener 9061

Hardener 9061



**THINNER OPTIONS**

Thinner 2691  
Thinner 2602  
Thinner 2711

Thinner 2691  
Thinner 2602  
Thinner 2711



**VISCOSITY**

25-30 seconds B4 cup 25-30 seconds B4 cup



**SPRAY GUN SETUP**

1.4mm -1.8mm 1.0mm -1.4mm



**NUMBER OF COATS (GUIDE ONLY)**

1-2 full coats 1-2 full coats



**FLASH OFF**

10-15 mins between coats 10-15 mins between coats

<b>DRYING TIME</b>				
Touch dry	15 mins @ 20°C	Touch dry	15 mins @ 20°C	
Hard dry	4 hours @ 20°C	Hard dry	4 hours @ 20°C	
Full dry	7 days @ 20°C	Full dry	7 days @ 20°C	
Full dry	30 mins @ 80°C	Full dry	30 mins @ 80°C	

**RECOATABILITY / OVERCOATING**  
 Can be overcoated wet on wet. After 7 days must be flatted.

<b>POT LIFE</b>				
8hrs @ 20°C		8hrs @ 20°C		

<b>WET FILM THICKNESS*</b>				
70-80 microns		70-80 microns		

<b>DRY FILM THICKNESS*</b>				
25-35 microns		25-35 microns		

\* - 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 its 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.