

HMG 2K Monothane is a twin pack direct to metal, anti-corrosive, gloss coating, with excellent adhesion and corrosion protection to all suitably prepared ferrous metals and many plastics. Ideal for application direct to metal as a single coat primer finish for use on skips, containers, agricultural and construction vehicles, machinery, street furniture and shop fronts.

Suitable for most clean and degreased metal surfaces.

- Touch dry after 1 hour, can be force dried at 70 – 80°C – 2 – 30 mins
- Available in 5L & 20L in full gloss finish.
- Available in wide range of colours including RAL & BS.
- Coverage: 17 – 22 m² per litre
- Thinner: 2601, 2602, 2603 & 2604

Full BS, RAL, agricultural and commercial vehicle colour ranges, and specials on request.

Manufactured under the auspices of an ISO 9001 management system.

Information

Theoretical Coverage (approx) at 20 microns DFT	17 - 22m ² per litre	Number of Coats (Guide Only)	Air/Airless - 1 - 2 Full Coats Compliant Spray - 1 - 2 Full Coats
Drying time at 20°C (May vary with film build and temperature)	Touch Dry - 1 Hours Hard Dry - Overnight Force Dry 2 - 30mins at 70 - 80°C	Application	Spray
Suggested Primer	N/A	Spray Gun Setup	Compliant 1.6 - 1.8 Airless 11 - 13 thou 40/59°
Hardener	9004 or 9039	Mixing Ratio	9004 - 2:1 9039 - 3:1
Thinner	2601, 2602, 2603 or 2604	Wet Film (WFT)	50 - 200 microns
Thinning	Compliant/Airless Spray up to 10-15% Viscosity 20 -25 Seconds B4 Cup Air or Air Assited up to 5%	Dry Film (DFT)	25 - 100 microns
Flash Point	24°C	Pot Life	1 Hour
Volume Solids		Recoat / Overcoat	
Maximum VOC (RFU)	420g/l	Finish	Gloss
Regulation / Compliance	2004/42 IIB (D) 420	Available Pack Sizes	5L & 20L

Important Information Before Use

Read and follow SDS, TDS, and label instructions. Stir paint thoroughly before use. Always use the same batch number on the same job. Check colour and 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 doubt, contact HMG Technical Service Department on 0161 205 7631.

Substrates

HMG 2K Monothane is for application direct to most suitably prepared metals and many plastics. Not suitable for coating over bitumen or chlorinated rubber coatings. Suitability over existing coating should be trialled in small area prior to full application.

Application Climate

Substrate temperature should be 5°C or above for application and during cure, and a minimum of 3° above the dew point. Adequate dry air ventilation should be supplied during drying.

Application Information

Thinning should only take place after material is thoroughly mixed. Application and use should always conform with the codes of practice described in BS 6150 and BS 5493.

Surface Preparation

Ensure surfaces are clean, dry and free from grease, oils, dust and other contamination prior to application. Thoroughly clean and degrease using suitable HMG Prep Clean 2802, 2803 or 2804.

Rust/corrosion to be removed to Sa or St standards, remove to clean metallic appearance with little or no rust/corrosion present. Areas where blast cleaning is not cost effective or practical, then the use of Ferrozinc is an alternative. Though Ferrozinc is not an equivalent alternative to shot blasting, it does offer a far superior performance than conventional coatings applied to slightly rusted surfaces. FERROZINC is used after simple wire brushing to remove surface rust, prior to application of primer.

General Specification

High pressure wash to remove all loose debris and other contamination.

Thoroughly clean and degrease using suitable HMG Prep Clean - Apply by cloth and quickly remove using clean lint free cloth. Repeat until surface is clean and free from all deposits (grease, oil, silicone). Replace cloths regularly to ensure that contamination is not re-applied to the surface.

Painting existing coatings (powder coated)

Check all existing coatings are well adhered with all loose and failed material removed back to firm with all edges well feathered.

Application

Apply HMG 2K Monothane evenly via Airless/Air-assisted, Pressure Pot, Compliant Spray. 1-2 full coats.

HMG 2K Monothane is a twin pack product and will require the mixing of the two parts prior to application, once mixed a chemical reaction will occur to allow the product to dry. When using twin pack products it is important that pot life is observed.

For full surface preparation please refer to our web site for Knowledge Base article Prep Cleaning Techniques (KNB0009) and Preparatory Cleaners from the Product Guide. If in doubt speak to HMG Technical Department on 0161 205 7631.

Health And Safety

Refer to SDS and tin label prior to use. Suitable respiratory equipment should be worn when spraying. Contaminated rags, spray booth filters or other substrates should be segregated from other chemical waste, soaked with water or disposed of in a non-combustible container with tight fitting lid.

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.