

QAD Enamel is an industrial, durable, quick drying, high gloss, tough, alkyd for use on spray applied steel. Railings and exterior furniture and fencing plus other suitable prepared metals.

Available in aerosols for easy touch up.

- Suitable for use over HMG HB48 Primer.
- Coverage: 10 – 12m² per litre at 55 microns dft
- Touch dry: 30 mins at 20°C
- Thinner: HMG 2621 2622

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	11-12m ² per Litre	Number of Coats (Guide Only)	Aerosol - 1-2 Compliant - 1-2
Drying time at 20°C (May vary with film build and temperature)	Touch Dry – 30 mins Hard Dry - 12 Hours Full Dry – 24 Hours	Application	Spray
Suggested Primer	ST300 Etch Primer, HB48 or HB05	Spray Gun Setup	Compliant – 1.6-1.8 Viscosity 30-35 seconds B4 cup
Thinner	2621 or 2622	Wet Film (WFT)	100 microns
Thinning	Compliant – 10%	Dry Film (DFT)	55 microns
Flash Point	24°C	Pot Life	N/A
Volume Solids		Recoat / Overcoat	10 mins to 18 hours max
Maximum VOC (RFU)	540 g/l	Finish	Matt, Satin, Semi-Gloss and Gloss
Regulation / Compliance	Not applicable	Available Pack Sizes	1L, 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 QAD Enamel is suitable a multi sheen finish coat for suitably prepared and primed metals, clean and free of grease, oils and other contaminants. Not suitable for coating over bitumen or chlorinated rubber coatings. Suitability with existing coatings to be checked with test application prior to use.

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

Bare substrates

Mild steel – Remove millscale and thoroughly degrease using suitable HMG Prep Clean. Abrade with P80 – P180 if necessary, prior to application of primer.

Shot Blasted Steel – Remove all traces of blast grit/sand prior to application of primer.

Aluminium – Abrade with P180 – P320, degrease with suitable HMG Prep Clean prior to application of primer.

Galvanised Steel – Degrease with suitable HMG Prep Clean, apply HMG Mordant Wash, apply HMG Etch Primer and if required HMG Primer.

Previously Painted

High pressure wash to remove all loose debris and poorly adhered previous coatings to remove all salts and other contaminants.

Degrease using suitable HMG Degreaser 2800 to remove grease and oils not removed with pressure washing alone. Existing coatings to be well adhered with all edges tight and well feathered. Rust/corrosion to be removed back to clean metallic appearance.

Abrade to provide good adhesion.

Wipe over with degreaser to remove loose debris from abrasion.

Substrate to be clean, free of grease, oils, dust and completely dry prior to application.

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.