

**PRODUCT NAME**

QAD Enamel

**ORIGINALLY ISSUED**

22/09/2005

**VERSION**

1.0

**PRODUCT CODE**

TOPQAD

**VERSION DATE**

22/09/2005



**PRODUCT DESCRIPTION**

An industrial paint for use in situations where quick drying, high gloss, durable and tough coatings are needed.



**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)**

0.54Kg/L

**REGULATIONS / COMPLIANCE**

- Not Applicable



**COLOUR RANGE**

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



**GENERAL INFORMATION**

Coverage 10-12 square metres per litre @ 55 microns dft  
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.



**SUITABLE SUBSTRATE & THEIR SUITABLE PREPARATION**

**MILD STEEL**

Remove millscale and thoroughly degrease using suitable HMG Prep Clean  
Abrade with P80-P180 if necessary before applying appropriate HMG Primer

**SHOT BLASTED STEEL**

Remove all traces of blast grit/sand before applying appropriate HMG Primer

**ALUMINIUM**

Abrade with P180-P320  
Degrease with suitable HMG Prep Clean  
Coat with appropriate HMG Etch Primer, and if required Primer

**GALVANISED STEEL**

Abrade with P180-P320  
Degrease with suitable HMG Prep Clean  
Apply HMG Mordant Wash  
Coat with appropriate HMG Etch Primer, and if required Primer



**SUGGESTED PRIMER / FILLER / SEALER SYSTEMS**

- 2K Etch Primer ST3000
- HB05 Primer
- HB48 Primer



**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 and disposed of in a non-combustible container with a tight fitting Lid.

**APPLICATION METHODS**

AEROSOL

COMPLIANT SPRAY GUN












**MIXING RATIO**

RFU

Base  
Thinner

1  
up to 10%

	<b>THINNER OPTIONS</b>							
		Thinner 2621 Thinner 2622						
	<b>VISCOSITY</b>							
	RFU	30-35	seconds B4 cup					
	<b>SPRAY GUN SETUP</b>							
		1.6-1.8						
	<b>NUMBER OF COATS (GUIDE ONLY)</b>							
	1-2 coats	1-2 coats						
	<b>FLASH OFF</b>							
	10-15 mins between coats	10-15 mins between coats						
	<b>DRYING TIME</b>							
	Touch dry	30 mins @ 20°C	Touch dry	30 mins @ 20°C				
	Hard dry	12 hrs @ 20°C	Hard dry	12 hrs @ 20°C				
	Full dry	24 hrs @ 20°C	Full dry	24 hrs @ 20°C				
	<b>RECOATABILITY / OVERCOATING</b>							
	After 16 hours							
	<b>WET FILM THICKNESS*</b>							
	100 microns	100 microns						
	<b>DRY FILM THICKNESS*</b>							
	55 microns	55 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.