

PRODUCT DESCRIPTION

Mono Ferro PUR is a micaceous iron oxide (MIO)-pigmented, one-component, moisture-cure polyurethane used as a primer, intermediate coat or "overcoat" over aged alkyds, vinyls or epoxies. Can also be applied over SSPC-SP-2, SP-3, SP-6, SP-11 or SP-13 surface preparations. May also be used as a non-light-stable topcoat.

PRODUCT FEATURES

- Use as a spot or full primer.
- Can be applied in damp, cold, humid, or foggy conditions.
- Can be applied directly to steel, aluminum, galvanized metal or concrete.
- Can be applied at a minimum of -7°C (20°F) and humidity up to 99%, no dew point temperature differential restrictions.
- Excellent adhesion properties to tightly adhering rust.
- For use as field touch-up over inorganic zinc.
- Quick recoat times.
- Does not become brittle with age.
- Use as an interior topcoat.
- No pot agitation required
- pH range 3 to 11
- Intermediate coat over Xymax Mono Zinc ME III, Mono Zinc, Mono Zinc 390, Mono Lock PP, Xyguard or itself.

TYPICAL USES

- Structural Steel
- Chemical Processing Facilities
- Bridges
- Material Handling Equipment
- Polyflex membrane primer
- Tanks Exteriors
- Pipes
- Water and Wastewater Treatment Facilities
- Pulp and Paper Mills and Hydropower Facilities

TECHNICAL DATA

| | | | |
|--------------------------------------|-----------------------------------|---|--|
| Colors Available: | Grey | Drying times: (depend on humidity) | |
| Gloss: | Low gloss | Dust free: | 2 hours |
| Solids by volume: | 63% +/- 2% | To recoat: | 4 - 6 hours |
| Solids by Weight: | 79% +/- 2% | Hard: | 24 hours |
| Theoretical Coverage @ 1 mil: | 1026 ft ² / US gallon | Reduction solvent: | X-34/101629 (VOC free thinner) |
| D.F.T. at 25 microns: | 95m ² / 3.78 liters | Dilution: | 10% by volume if necessary |
| Recommended D.F.T. | 3-4 mils (75-100 microns) | Shelf life: | 12 months @ 25° C unopened |
| Viscosity: | 80-110 Ku | Pot life: | Newly opened cans: 16 hours Working pot for Spray application: 6 - 8 hours Brush or roll application: 4 - 6 hours |
| Specific gravity | 1.40 – 1.56 kg./lt. | Packaging: | 3.78 liters (1 US gallon) 18.93 liters (5 US gallons) |
| Flash Point: | Above 24°C (75.2°F) | | |
| V.O.C.: | 340 grams/liter 2.80 lbs./US gal. | | |

Keep in cool and dry area

APPLICATION GUIDE

SURFACE PREPARATION

First remove all grease, oil, salt contaminants, and dirt in accordance with SSPC-SP-1 "solvent cleaning". High-pressure-water-wash or steam clean to remove any remaining soluble salts. For full "overcoating" of aged alkyds or older coatings, use SSPC-SP-1. As a spot primer, use SSPC-SP-2 hand tool cleaning or SSPC-SP-3 or SSPC-SP-11 power tool cleaning.

As a full primer over steel, abrasive blast to a minimum of commercial blast in accordance with SSPC-SP-6 or Swedish Standard Sa2. The blast profile should be between 1½ and 2½ mils (37.5 and 62.5 microns).

For use over concrete, stone particles or other debris must be removed. Wax substrates or residue or very contaminated substrates must be cleaned with a sand-blasting machine, a grinding machine or a high pressure washing machine in accordance with SSPC-SP-13.

Before painting, always vacuum or remove any dust, dirt, or debris to ensure the surface is or remains clean.

Round off rough welds and sharp edges, and remove weld spatter.

Evaluate representative test patches to ensure adequate adhesion to old coatings.

MIXING AND THINNING

Mono Ferro Pur is supplied in either 1 gallon or 5 gallons containers. The entire contents of the containers must be mixed well before application. Thinning is not required; however, at lower temperatures, up to 10% of X-34 thinner for application in factory or shop can be added or use 101629 for other conditions. Mix gently.

Do not "box" or create vortex.

Reduction Solvent*: X-34/101629

Clean-Up Solvent: X-50

Air spray: 10% reduction if necessary

Airless spray: If required

Brush (Natural or synthetic short hair, stiff bristle) and roller: No reduction necessary

Paint temperature must always be above the dew point before mixing or application.

*Contact a Polyval representative when solvent reduction may be needed.

| DRYING TIMES | | | RECOATING TIME | | |
|----------------------------|--|---------------|----------------|----------|----------|
| Substrate temperature | Dust free | Hard | Minimum | Maximum | Normal |
| < -7°C (20°F) | Not recommended to paint below this temperature. | | | | |
| -7°C – 10°C (20°F - 50°F) | 6 - 18 hours | 72 - 96 hours | 18 hours | 2 months | 72 hours |
| 10°C – 38°C (50°F – 100°F) | 2 hours | 24 hours | 4 hours | 2 months | 24 hours |

| CONVENTIONAL SPRAY | | AIRLESS SPRAY | |
|--------------------|--|---------------|-------------------------------|
| Manual Spray gun: | DeVilbiss JGA-510, MBC-510 or equivalent | Pump Ratio: | 30:1 |
| Fluid Nozzle: | E Fluid Tip | Pressure: | 3000 psi |
| Air Cap: | 704 or 765 | Hose: | ¾ inch, 50 ft. length maximum |
| Atomizing Air: | 30 – 60 lbs. | Tip Size: | 0.017 – 0.021 |
| Fluid Pressure: | 15 – 20 lbs. | Filter Size: | 50 Mesh (300 um) |
| Hose: | ½ inch, 50 ft. length maximum | | |

SPECIAL INSTRUCTIONS & PRODUCT LIMITATIONS

- Avoid application over visible droplets or puddles of water or ice formations.
- Stated cure times are at 40% minimum relative humidity and temperatures of 10°C (50°F) to 38°C (100°F). Allow more time at humidities below 40% and temperatures below 10°C (50°F).
- When used as an exterior topcoat, gloss and color retention properties are limited.
- Equal in weathering to epoxies.
- Do not use for immersion services.
- For rapid recoat; refer to Pur-Acc accelerator data sheet. Recoat times for intercoat adhesion will be shortened. Consult Polyval before use.
- Maximum wet film thickness should not exceed 7 mils (175 microns).
- Avoid storing in temperature above 29°C (85°F) or direct sunlight.

See the material safety data sheet and product label for complete safety and precaution requirements.

DISCLAIMER:

"The following is made in lieu of all warranties, expressed or implied: Manufacturer's obligation shall be to replace such quantity of the product proven to be defective. The manufacturer shall not be liable for any injury, loss or damage, direct or incidental or consequential, arising out of the use of or the inability to use the product. Before using, the user shall determine the suitability of the product for the intended use and the user assumes all risk and liability whatsoever in connection therewith. All values shown are approximations. Values indicated are for guide purposes only, as actual values can change due to application conditions, application methods, environmental conditions etc. The information contained herein is subject to change without notice. Consult your representative for a current data sheet. The foregoing may not be altered except by an agreement signed by the officers of the manufacturer."

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