

**COATING DATA**

**DESCRIPTION:**

Indurethane Monarch HS is a high solids, polyester polyurethane finish formulated with the highest quality resin and is chemically engineered to provide outstanding performance in the most severe climates while retaining its original gloss and color for many years. As the newest addition to Induron's Premium Line, Indurethane Monarch HS is available in a wide range of colors and offers excellent chemical resistance. With this product, Induron has developed a champion that represents the next generation of urethane technology. Indurethane Monarch HS combines outstanding durability with exceptional quality and color retention in a high-gloss and high distinction of image (DOI) finish that is unrivaled in the market.

**Indurethane Monarch HS High Gloss Polyurethane**

- Excellent exterior durability. Retains gloss and color for years.
- Provides complete color flexibility with an automotive type finish. Choose from Induron color card standards or provide us with your color of choice.
- High performance chemical resistant coating.
- Complies with U. S. EPA Ozone Transport Commission (OTC) for Volatile Organic Compounds for VOC Emission Standards for industrial maintenance coatings.

**USE:**

Use as the finish coat on properly prepared interior or exterior surfaces. This coating is especially designed for use where long term gloss and color retention is required. This finish coating is formulated for use in a range of aggressive environments such as:

- Cement Trucks and Chemical Tankers.
- Bulk Tanks and Tankers
- Locomotives and Railroad Cars
- Oilfield and Land Drilling Equipment
- Marine Offshore and Heavy Duty Equipment

**LIMITATIONS:** Do not use for immersion service. Maximum continuous service temperature (dry) 200°F (93°C).

**SURFACE PREPARATION:**

Induron Indurethane Monarch HS may be applied over the appropriate Induron epoxy primer or intermediate coat or be applied directly to phosphated steel or steel prepared in accordance with an SSPC-SP 6/NACE 3 Commercial Blast. It may be applied over properly prepared and primed masonry and non-ferrous substrates. Consult your Induron representative for specific recommendations.

PRIMERS—Induron Indurethane Monarch HS may be directly applied over:

- FastPrime Universal Alkyd Primer
- FastPrime 2 Epoxy Polyamide Primer
- Fastprime 3 Zinc Micaeous Iron Oxide Primer
- Permaclean II Epoxy High Build Epoxy Primer
- Induramastic 85 & Induraguard Epoxy
- E-Bond 100 & MCU 62 Penetrating Sealer

**RECOATABILITY:** This product may be recoated with itself any time after 18 hours.

**COVERAGE:** Theoretical—1,023 ft<sup>2</sup> per gallon at 1.0 mil dry.

**DRY FILM THICKNESS:** 1.5 to 2.5 mils.

**WET FILM THICKNESS:** 2.4 to 4.0 mils.

\*Number of coats and thickness will vary with substrate and application method and technique.

## APPLICATION DATA

### BLEND RATIO:

One part Indurethane Monarch Activator to Three parts Indurethane Monarch Base by volume. Power agitate until components are thoroughly mixed.

**POT LIFE:** 4 hours@50F, 2 hours@70F, 1 hour@90F

**STORAGE TEMPERATURE:** Minimum 20°F, Maximum 110°F.

**SHELF LIFE:** 18 months at recommended storage temperature.

### APPLICATION:

**Airless Spray:** Use .015-.017 tip, 60 mesh filter, 30:1 pump ratio at 60-100 psi operating air pressure.

**Roll**—Use short nap, high quality synthetic cover with a solvent resistant core. Additional coats may be required to achieve desired film thickness. **Brush**—Use natural bristle brush. Additional coats may be required to achieve desired film thickness.

### THINNING:

Recommended spray viscosity of 18-20" #3 Zahn Cup. If thinning is required for viscosity reduction or cleanup, use K-1017.

**SURFACE TEMPERATURE:** Minimum 35°F, Maximum 120°F.

### CLIMATE:

Use this product only if the substrate temperature and ambient air temperature is a minimum of 35°F and is expected not to decrease for at least two hours after application. Also, the substrate temperature must be 5°F above the dew point for a period of at least two hours after application to avoid film defects caused by condensation occurring on wet paint.

### DRY TIME:

TO TOUCH: 4 hours @50F, 2 hours@70F, 1 hour @90F.

TO HANDLE: 12 hours@50F, 6hours@70F, 3 hours@90F.

TO RECOAT: Overnight.

**Note:** Lower temperature, higher film build, and/or poor ventilation will retard dry time.

**Note:** U-50 Accelerator may be used to increase the normal curing rate of reaction to provide a rapid low temperature cure at temperatures below 60° F. No more than 8 oz(1/2 package) should be used per 5 gallon kit.

### PHYSICAL DATA:

VOLUME SOLIDS: 64% ± 2%

SOLIDS BY WEIGHT: 73% ± 2%

WEIGHT PER GALLON: 11.2 ± 0.2 lbs per gallon

VOLATILE ORGANIC COMPOUNDS:

Mixed unthinned: < 2.2 lbs/gallon; < 265 grams/liter

Mixed thinned 10%: < 2.2 lbs/gallon; < 265 grams/liter

HAPS CONTENT:

Mixed unthinned: 1.20 HAPS per gal. solid paint

Mixed thinned 10%: 1.20 HAPS per gal. solid paint

**SAFETY DATA:** See individual product label for safety and health data. A Material Safety Data Sheet is available upon request.