



Effective 20 February, 2008

# MONO93

## MONOPRIME 93

### Description

Vinyl based zinc chromate-free two package wash primer surfacer.  
Composition based on polyvinyl butyral resin.

### Products

MONO93	Monoprime 93
TH93	Thinner 93

### Properties

- Very good corrosion resistance.
- Very good overspray melting.
- Good filling properties. Used as etching primer surfacer.
- Excellent etching properties on all ferrous metal and light alloys.
- Can be coated with Imron<sup>®</sup> Fleet Line 2K surfacers or Imron<sup>®</sup> Fleet Line 2K topcoats.
- VOC compliant, conform with directive 2004/42/EC.

### Substrates

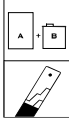






- Bare metals: steel, aluminium and galvanised steel.
  - OEM finishes\*.
  - Cured repair finishes.
- \* Not recommended for thermoplastic acrylic finishes or under polyester putties.



# MON093

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### PRODUCT PREPARATION

	<b>Mixing ratio</b>	MONO93 TH93	<b>Standard/Pressure feed</b>		<b>Airmix/Airless</b>	
			Volume 1 0.5	Weight 100 40	Volume 1 0-0.35	Weight 100 0-28
	<b>VOC</b>	400-770 g/l				
	<b>Pot life at 20°C</b>	5 days				
	<b>Spray viscosity at 20°C</b>	<b>DIN 4</b> <b>FORD 4</b>	16-23 s 19-26 s		60-125 s 60-125 s	
	<b>Spray equipment</b>	<b>Conventional guns</b>	<b>Fluid tip</b>	<b>Distance</b>	<b>Pressure</b>	
		Gravity feed Suction feed Pressure feed	1.2-1.5 mm 1.4-1.8 mm 1.0-1.2 mm	20-25 cm 20-25 cm 20-25 cm	3-4 bar 3-4 bar 3-4 bar	
		<b>Compliant guns (HVLV/HTE)</b>				
		Gravity feed Suction feed Pressure feed	1.2-1.4 mm 1.4-1.6 mm 1.0-1.2 mm	15 cm 15 cm 15 cm	According to supplier's specifications	
	<b>Number of coats</b>	1-2				
	<b>Flash time</b>	Between coats till flat. 15 min before recoating - till 8 hr maximum.				
	<b>DFT</b>	15-25 µm/coat				
	<b>Dry to sand</b>					
	at 20°C	1 hr				
	at 40°C	45 min				
	at 60°C	30 min				
This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.						



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### RECOMMENDED USE

#### Surface preparation

Bare metals (steel, galvanised steel, aluminium or surface treated aluminium)

1. Clean surface with a DuPont Refinish preparatory cleaner for bare metals. Wipe dry with clean Sontara® wipes.
2. Sand and eliminate all rust and corrosion.
3. Remove all traces of sanding dust, blowing with clean oil-free compressed air.
4. Degrease with a correct DuPont Refinish final cleaner/degreaser. Wipe dry with clean Sontara® wipes.

OEM and cured repair finishes

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with a correct DuPont Refinish preparatory cleaner. Wipe dry with clean Sontara® wipes.
3. Sand surface:
  - a. mechanical with P280 - P320;
  - b. wet with P600.
4. Remove all traces of sanding dust, blowing with clean oil-free compressed air.
5. Degrease with a correct DuPont Refinish final cleaner/degreaser. Wipe dry with clean Sontara® wipes.

#### Equipment cleaning

Use a correct DuPont Refinish solventborne gunwash.



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### RECOMMENDED USE (con'd)

#### Remarks

- Reduced material should not be returned to original can of unreduced material.
- Do not use polyester putty or epoxy primer surfacer over MONO93. Hardening and adhesion of polyester and epoxy products will be affected.
- Adhesion and flow problems will occur with activated material older than 5 days.
- For mixing rod information, see specific TDS.
- Material has to be at room temperature (18-25°C) before use.

#### Product data

Package viscosity: 125 s AFNOR 4 at 20°C  
Theoretical coverage: 9 m<sup>2</sup>/l at recommended DFT - ready-to-spray  
Directive 2004/42/EC: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 780 g/l of VOC. The VOC content of this product in ready to use form is maximum 770 g/l.

Products	Packages (l)	Shelf life at 20°C (year)
MONO93	4	2
TH93	1 - 5	2

#### Safety

Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.