

MONOGLASS™ MC 4250

**CLEAR / SUPER HIGH GLOSS
MOISTURE CURE URETHANE TOPCOAT**



PRODUCT FEATURES

- Aliphatic, single component, moisture cure polyurethane topcoat
- Outstanding gloss retention when exposed to damaging U.V. rays
- Super tough, hard and impact resistant topcoat
- Remarkable chemical and solvent resistant topcoat
- Excellent adhesion
- Anti-graffiti properties
- Tile like glaze coating
- Ultimate protection when used as a finishing coat over Glass Shield epoxies, moisture cure urethane primers or polyurethane topcoats
- Can be applied in damp and humid conditions
- Easy to apply with any traditional painting equipment



Suggested Use

- Steel
- Fiberglass
- Wood
- Interior or exterior concrete

Packaging, Handling & Storage

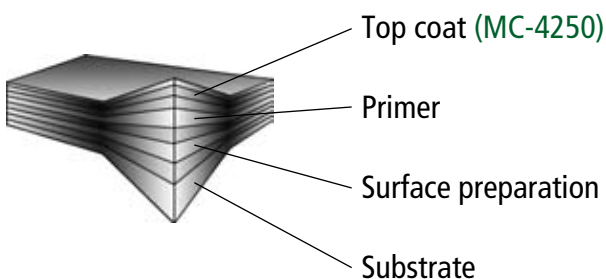
Shipping weight (approximate)	1 gallon: 8.32 lbs (3.774 kg)
Storage (general)	Store indoors
Storage temperature & humidity	40-100 °F (4-43 °C) 0-100% relative humidity
Shelf life	1 year at 75° F (24° C)

Technical Data

Coating type	Single component moisture cure urethane
Colour	Clear
Packaging	3.78 L (1 US gallon) 18.9 L (5 US gallon)
Mixing Ratio	Single component
Gloss	90% +
Flashpoint (ASTM D93)	26° C (80° F)
Thinner	GS UC 500S
Pot life	4 to 6 hours
Shelf life	1 year
Density (ASTM D 1475)	1.00 kg / L +/- 0.05
Weight	8.32 +/- 0.11 lbs / US gal.
Volatile organic compound (VOC)	4 lbs / US gal. (485g/L)

Temperature resistance	100° C (212° F) in continuous service
Solids (ASTM D1644)	
By weight	50 +/- 2%
By volume	45 +/- 2%
Theoretical spreading rate	17 sq.m / l at 25 microns dry
	705 sq.ft. / US gal at 1 mil
Recommended film thickness	50 - 100 microns dry (2.0 - 4.0 dry mils)
Application methods	Conventional air spray, airless and HVLP

Typical Sequence



In doubt? Contact technical services at 1-800-361-6652 for proper guidance in preparing substrate

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Surface Preparation

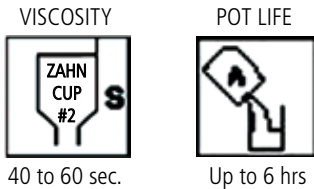
Surface must be clean, dry and free from contaminants. Remove dust, grease, wax, oil, rust, silicone residue, etc. Remove all old paints in order to obtain adequate adhesion.

Mixing and Thinning

MONOGLASS™ MC-4250 is a one component product supplied in 1 US gallon container or 5 US gallon containers.

Thinning is not recommended.

The pot life or the "working pot" is up to 6 hours. After the paint is stirred and poured, immediately seal the original can. Higher temperatures or humidity will shorten the pot life. Do not apply over water or frozen surfaces.



Application Conditions

Industry standards are for the substrate temperatures to be above 10° C of the dew point. Condensation due to substrate temperatures below the dew point can cause flash rusting on prepared steel and interfere with proper adhesion to the substrate.

Special application techniques may be required above or below normal application conditions.

Condition	Material	Surface	Ambient	Humidity
Normal	60 - 85° F (16 - 29° C)	65 - 85° F (18 - 29° C)	60 - 90° F (16 - 32° C)	0 - 65%
Minimum	50° F (10° C)	23° F (5° C)	23° F (5° C)	0%
Maximum	90° F (32° C)	100° F (35.5° C)	100° F (35.5° C)	85%

DISCLAIMER: All information is given in good faith. Since conditions of use are beyond the manufacturer's controls, all information contained herein is without warranty, implied or otherwise. All technical data and specifications are subject to change. Please consult with your Glass Shield representative for more detailed coating recommendations.
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Application

MONOGLASS™ MC-4250 can be applied by brush, roller or spray. De Vilbiss or equivalent equipment should be used. Airless spray: heavy duty 30:1 airless pump with tip size 0.017-0.021 in. at 3000 psi pressure with 3/8 fluid hose maximum 50ft length. Spray gun : similar to the De Vilbiss 510, fluid tip 0.55-0.73 in. at 30-60 psi pressure. For HVLP applications, please consult and follow equipment supplier's instructions. For applications, please refer and comply with equipment supplier's recommendations.

Curing times given at 23°C (73°F) and 40% relative humidity. Higher or lower temperatures will affect drying times.



Airless & Air Spray

Manufacturer	Graco
Pump	30 : 1
Fluid hose	3/8" x 100' max
Tip size	*
PSI	2400 PSI min.

* Refer to Kremlin chart for specific uses or consult Glass Shield technical services

Manufacturer	Devilbiss	SATA
Spray gun	HET	K3 RP
Fluid tip	1.4-1.6 ff	1.4-1.6
Air cap	#410 / 414	
Fluid line	3/8"	3/8"
Pressure pot	15 - 25 psi	40 psi
Atomizing air	50 - 60 psi	36 psi

Curing Schedule

Ventilate the substrate for 2 hours after application. Curing times are based on a 2.0-3.0 mil (50-75 micron) dry film thickness. Higher film thickness, insufficient ventilation or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure of the film. Consult a Glass Shield representative for further information. If the maximum recoat time has been exceeded, the surface must be sanded or prepared with a brush off blast SSPC-SP-7 prior to the application of additional coats. MONOGLASS™ MC 4250 applied below 40°F (4° C) may temporarily soften for several hours, after temperatures rise to 60°F (16° C). This is a normal condition and will not influence performance of the coating.

Dry to touch	4-6 hours
Dry to recoat	8-10 hours (sanding required after 10 hours)
Hard	10 hours
Full cure	7 days

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FOR EVERY INDUSTRIES



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