

## MAE Acrylic Enamel

### Background

OMNI® MAE is a fast drying acrylic enamel designed for today's economy minded collision centers.

### Components

#### Color

MAE Acrylic Enamel

#### Reducer

MR185/MR486 Fast 55-65°F (13-18°C)  
MR186/MR487 Medium 65-75°F (18-24°C)  
MR187/MR488 Slow 75-85°F (24-29°C)  
MR188 Very Slow 85-95°F (29-35°C)

### Compatible Products

#### Can be applied over:

Cured, cleaned and sanded OEM and refinish coatings  
MP17x Epoxy Primers  
MP178 Plastic Primer  
MP281 1K Light Gray Primer Surfacer  
MP182 2K Urethane Surfacer  
MP282 High Build 2K Primer Surfacer  
MP213 GP Sealer  
MP23x 2K Urethane Sealers

**If desired, a clearcoat can be applied to provide additional long term durability.**

#### Can be topcoated with:

MC161 High Solids Urethane Clear  
MC250 Urethane Clearcoat  
MC260 Quick Clear  
MC270 4.2 VOC Production Clear  
MC2800 EUROPLUS® Speed Clear

### Preparation

#### Surface Cleaning:

MX190 Cleaner  
MX192 Plastic Cleaner  
SXA330 Wax and Grease Remover  
SWX350 (H<sub>2</sub>O-SO-CLEAN®) Waterborne Pre-Cleaner

#### Sanding

400 grit (machine or dry hand) or 500 grit (wet) on old finishes and primer surfacers

### Mixing



#### Ratios:

MAE	:	MR Reducers
4	:	1



#### Pot Life:

Indefinite



#### Additives:

MX194 Fisheye Eliminator      Add up to 0.5 oz. to RTS quart

#### Tinting:

MAE may be tinted up to 10% with *Omni* AU mixing bases and equal parts M103 enamel mixing clear.

#### Note:

If clearcoating, MAE Activated must be used. See data sheet OB16.

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## Application

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**Coats:** 3 coats or until proper color is achieved

## Air Pressure and Gun Setup

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**HVLP:** 8 - 10 psi at the air cap  
**Compliant:** 29 - 40 psi at the gun

**Gun Setup:** 1.3 - 1.6 mm or equivalent

Note: For best overall results, refer to spraygun manufacturer's recommendations for inlet air pressures.

## Dry Times

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**Between Coats:** 5 - 10 minutes at 70°F (21°C)



**Air Dry:** Dust: 10 minutes  
Tack: 30 - 40 minutes  
Tape: 4 hours



**Force Dry:** 30 minutes at 140°F (60°C)



**IR:** 10 - 15 minutes



**Polish:** **Air Dry:** 16 hours at 70°F (21°C) to polish and put into service.  
**Force Dry:** wait 8 hours to polish and put into service.

## Clean Up

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Clean spray guns, gun cups, storage pots, etc., thoroughly with MR Reducer, MS251 Multi Purpose Solvent or another appropriate clean up solvent after each use.

Follow EPA guidelines for proper storage and disposal of solvent-borne waste paint.

## Properties

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### VOC

Package	4.50 lb./ gal. (539 g/L)
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Applied (4:1)	5.00 lb./ gal. (599 g/L)
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RTS Solids by weight	36.4-51.9%
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### Film build per coat

Applied (4:1)	0.8 - 1.2 mils
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### Square foot coverage at 1 mil

Applied (4:1)	497 sq. ft. per US gallon at 100% transfer
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**Limitations**

*Omni* products should not be combined with components of other product lines.

**Precautionary Information:**

The contents of this package may have to be blended with other components before the product can be used. Before opening the packages be sure you understand the warning messages on the labels of all components since the mixture will have the hazards of all of its parts. Spray equipment must be handled with due care and in accordance with manufacturer's recommendations. Follow label directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

**Medical Response:**

**EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (412) 434-4515; IN CANADA (514)-645-1320**

**See Safety Data Sheet and Labels for additional safety information and handling instructions.**

Data Safety Sheets for the PPG products mentioned in this publication are available through your PPG *Omni* brand distributor. To the best of our knowledge, the technical information in this bulletin is accurate; however, since PPG Industries is constantly improving its coating and paint formulas, the current technical data may vary somewhat from what was available when this bulletin was printed. Contact your *Omni* brand distributor or visit [www.ppgrefinish.com](http://www.ppgrefinish.com) for the most up-to-date information.

