

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 (H₂O-SO-CLEAN®) Waterborne Pre-Cleaner

Sanding

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

Mixing



Ratios: $\frac{\text{MAE} : \text{MR Reducers}}{4 : 1}$



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.

Application



Coats: 3 coats or until proper color is achieved

Air Pressure and Gun Setup



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



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

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

VOC

Package 4.50 lb./ gal. (539 g/L)

Applied (4:1) 5.00 lb./ gal. (599 g/L)

RTS Solids by weight 36.4-51.9%

Film build per coat

Applied (4:1) 0.8 - 1.2 mils

Square foot coverage at 1 mil

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

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 for the most up-to-date information.

