



## PRODUCT INFORMATION



# MP871 2.1 VOC Epoxy Primer - Gray

## Background

OMNI® MP871 is a gray 2.1 VOC two component epoxy primer which may be used as a primer or as a sealer.

## Components

### Primer

MP871 2.1 VOC Epoxy Primer  
- Gray

### Hardener

MP875 2.1 VOC Epoxy Hardener

### Reducer

MR294 Fast 55-65°F (13-18°C)  
MR295 Medium 65-75°F (18-24°C)  
MR296 Slow 75-85°F (24-28°C)

## Compatible Products

### Can be applied over:

Sanded and cleaned bare or treated steel, galvanized or aluminum.  
Sanded and cleaned body filler, SMC and gel-coated fiberglass.  
Properly cleaned and sanded E-coat  
Cleaned, cured and sanded OEM and refinish coatings.  
SU470LV 1K Compliant Adhesion Promoter  
MP80x 2.1 VOC Multi-Purpose Primers  
MP831 2.1 VOC 1K Primer Surfacer - Gray

### May be topcoated with

MP243 Polyester Primer  
MP831 2.1 VOC 1K Primer Surfacer - Gray  
MP80x 2.1 Multi-Purpose Primer  
MP89x 2.1 VOC Urethane Sealers  
MBPX *Omni* Plus 3.5 VOC Acrylic Urethane Basecoat  
MBX 3.5 VOC Acrylic Basecoat  
MTX 2.8 VOC Single Stage  
MLX 2.8 VOC Acrylic Enamel

Note: MP871 should not be applied over etch primer.

## Preparation

### Surface Cleaning:

SXA330 Wax and Grease Remover  
SWX350 (H<sub>2</sub>O-SO-CLEAN®) Waterborne Pre-Cleaner  
SX1009 2.9 VOC Bug and Tar Remover

### Sanding

As a primer: 180 - 220 grit machine on bare steel  
As a sealer: 320 - 400 grit machine on primer and old finishes

## Mixing



### Primer Ratio:

<b>MP871</b>	:	<b>MP875</b>	:	<b>MR29X</b>
<b>2</b>	:	<b>1</b>	:	<b>1</b>



### Sealer Ratio:

<b>MP871</b>	:	<b>MP875</b>	:	<b>MR29X</b>
<b>2</b>	:	<b>1</b>	:	<b>2</b>



### Pot Life:

3 - 4 hours at 70°F (21°C)



### Additives:

None

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## 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.

## Application



**Coats:** 2 : 1 : 1 1 - 2 coats used as a primer  
2 : 1 : 2 2 - 3 coats used as a sealer

Note: When additional reducer is added and MP871 is sprayed as a sealer, be sure that the minimum recommended film build is maintained. (see chart)

## Dry Times

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



**Air Dry at 70°F (21°C):** 2 : 1 : 1 **Primer**  
60 minutes  
2 : 1 : 2 **Sealer**  
30 - 40 minutes



**Force Dry** 2 : 1 : 1 **Primer**  
30 minutes at 140°F (60°C) metal temperature and cool down to topcoat



**IR** 2 : 1 : 1 **Primer**  
10 - 15 minutes and cool down to topcoat



**Topcoat:** **Air Dry**  
2 : 1 : 1  
60 minutes  
2 : 1 : 2  
30 - 40 minutes  
**Force Dry**  
After cool down

**Note:** MP871 Series Epoxy Primers must be scuffed and reapplied if allowed to sit more than 3 days (72 hours)

## Clean Up

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Clean spray guns, gun cups, storage pots, etc., thoroughly with MR Reducer, MS151 Low VOC General 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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<b>Dry Film Build Per Coat</b>	Applied 2 : 1 : 1	1.0 mils
	Applied 2 : 1 : 2	0.7 mils
<b>Square foot coverage at 1 mil</b>	Applied 2 : 1 : 1	650 sq. ft. / gal. 100% transfer
	Applied 2 : 1 : 2	520 sq. ft. / gal. 100% transfer

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<b>PRIMER-SEALER</b>	<b>Primer</b>	<b>Sealer</b>
RTS Combinations:	MP871 : MP875 : MR29X	MP871 : MP875 : MR29X
Volume Ratio:	2 : 1 : 1	2 : 1 : 2
Applicable Use Category	Primer	Primer-Sealer
VOC Actual (g/L)	144	115
VOC Actual (lbs/gal)	1.21	0.96
VOC Regulatory (less water less exempt) (g/L)	248	248
VOC Regulatory (less water less exempt) (lbs/gal)	2.07	2.07
Density (g/L)	1313 - 1349	1291 - 1346
Density (lbs/gal)	10.96 - 11.25	10.77 - 11.23
Volatiles wt. %	49.1 - 50.4	58.6 - 60.3
Water wt. %	0.1	0.1
Exempt wt. %	38.1 - 39.7	49.6 - 51.7
Water vol. %	0.2	0.1 - 0.2
Exempt vol. %	42.0 - 42.1	53.6 - 53.7

#### 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.

