

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 Hardener Reducer

MP871 2.1 VOC Epoxy Primer MP875 2.1 VOC Epoxy Hardener MR294 Fast 55-65°F (13-18°C)
- Gray MR295 Medium 65-75°F (18-24°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

Note: MP871 should not be applied over etch primer.

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

MR296 Slow 75-85°F (24-28°C)

MBX 3.5 VOC Acrylic Basecoat MTX 2.8 VOC Single Stage

MLX 2.8 VOC Acrylic Enamel

Preparation

Surface Cleaning:

SXA330 Wax and Grease Remover SWX350 (H₂O-SO-CLEAN™)

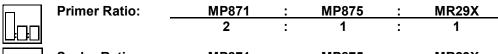
SX1009 2.9 VOC Bug and Tar Remover

Sanding

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

finishes

Mixing



Sealer Ratio: <u>MP871 : MP875 : MR29X</u>
2 : 1 : 2

Pot Life: 3 - 4 hours at 70°F (21°C)

Additives: None

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.

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



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

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

Dry Film Build Per Coat Applied 2:1:1 1.0 mils

Applied 2:1:2 0.7 mils

Square foot coverage at 1 mil Applied 2:1:1 650 sq. ft. / gal. 100% transfer

Applied 2:1:2 520 sq. ft. / gal. 100% transfer

PRIMER-SEALER	Primer	Sealer
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 use. 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 Material Safety Data Sheet and Labels for additional safety information and handling instructions.

Material 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.

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