



## MP80x Series

### 2.1 VOC Multi Purpose Primer (National Rule)

#### Background

OMNI® MP80x Series is a fast drying, two component multi-purpose Low VOC primer which may be used as a primer surfacer or as a wet-on-wet sealer when integrated with clear coat. It is available in white, gray and black and is available for use in all North American Markets.

#### Components

**Primer**

MP801 2.1 VOC Multi-Purpose Primer - White  
MP802 2.1 VOC Multi-Purpose Primer - Gray  
MP803 2.1 VOC Multi-Purpose Primer - Black

**Hardener**

MH810 Multi-Purpose Primer Hardener

**Reducer**

MR185 Fast Reducer  
MR186 Medium Reducer  
MR187 Slow Reducer  
MR188 Very Slow Reducer  
(refer to OBTB-001NR *Omni* National Rule Reducer Guide)  
MR294 Compliant Reducer Fast  
MR295 Compliant Reducer Medium  
MR296 Compliant Reducer Slow

**Clearcoats**

Any *Omni* MC Clearcoat

#### Compatible Products

**Can be applied over:**

Cleaned, sanded and etch primed steel, galvanized and 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.  
MP178 Plastic Primer  
MP243 Polyester Primer  
MP220 Chrome Free Etch Primer  
MP17x Epoxy Primers

**Can be topcoated with:**

MP17x Epoxy Primer Series  
MP23x 2K Urethane Sealer Series  
MBP Acrylic Urethane Basecoat  
MBC Acrylic Basecoat  
MTK Acrylic Urethane Single Stage  
MAE Acrylic Enamel Single Stage

#### Preparation

**Surface Cleaning:**

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

**Sanding**

For use as a primer: 180-220 Grit machine on bare steel  
For use as a sealer: 320-400 Grit machine on primer or old finishes.

#### Mixing

**Primer Surfacer:**

<b>MP80x</b>	:	<b>MH810</b>	:	<b>MR18x/MR29x</b>
4	:	1	:	2

**Wet on Wet Sealer:**

<b>MP80x</b>	:	<b>MC Clear</b>	:	<b>MH810</b>	:	<b>MR18x/MR29x</b>
3	:	1	:	1	:	1

**Pot Life:**

1/2 Hour at 70°F (21°C) at 4:1:2  
1 Hour at 70°F (21°C) at 3:1:1:1

**Additives:**

MX193	Flex Add 10% to RTS mix
SL87	Extender add 5% to RTS mix

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## Air Pressure and Gun Setup

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<b>HVLP:</b>	8 - 10 psi at the air cap
<b>Compliant:</b>	29 - 40 psi at the gun
<b>Gun Setup:</b>	1.3 - 1.6 mm or equivalent

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

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## Application

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<b>Coats:</b>	4:1:2	2 - 4 coats for Primer-Surfacer
	3:1:1:1	1 - 2 coats for Wet-on-Wet Sealer

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## Dry Times

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<b>Between Coats:</b>	5 - 10 minutes at 70°F (21°C)
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<b>Air Dry:</b>	<b>4:1:2 Primer Surfacer</b> 1-2 hours at 70°F (21°C) to sand and topcoat
	<b>3:1:1:1 Wet on Wet Sealer</b> 15 minutes to topcoat



<b>Force Dry:</b>	<b>4:1:2 Primer Surfacer</b> 20 - 30 minutes at 140°F (61°C) metal temperature
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<b>IR (Medium):</b>	<b>4:1:2 Primer Surfacer</b> 10 - 15 minutes
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<b>Topcoat:</b>	<b>Air Dry</b> <b>4:1:2 Primer Surfacer</b> 1-2 hours to sand and topcoat
	<b>3:1:1:1 Wet on Wet Sealer</b> 15 minutes to topcoat
	<b>Force Dry</b> <b>4:1:2 Primer Surfacer</b> After cool down

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## 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.

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## Properties

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### Film Build Per Coat

Applied 3:1:1:1	1.2 - 1.5 mils.
Applied 4:1:2	1.5 - 2 mils.

### Square foot coverage at 1 mil

Applied 3:1:1:1	605 - 669 sq. ft. / gal. at 100% transfer
Applied 4:1:2	553 - 595 sq. ft. / gal. at 100% transfer

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PRIMER - PRIMER SEALER	Standard System	Flexible System	Standard System	Flexible System
RTS Combinations	MP80x : MH810 : MR18x/MR29x	MP80x : MH810 : MR18x/MR29x + 10% MX193	MP80X : MC161/ MC2800 : MH810 : MR18x/ MR29x	MP80x : MC270/ MC260 : MH810 : MR18x/MR29x : + 10% MX193
Volume Ratio:	4 : 1 : 2	4 : 1 : 2 +10%	3 : 1 : 1 : 1	3 : 1 : 1 : 1 +10%
Applicable Use Category	Primer	Primer	Primer - Sealer	Primer - Sealer
VOC Regulatory (less water less exempt) (g/L)	406 - 458	417 - 463	379 - 418	392 - 428
VOC Regulatory (less water less exempt) (lbs/gal)	3.39 - 3.82	3.48 - 3.86	3.16 - 3.49	3.27 - 3.57
Solids wt. %	50.0 - 54.5	49.8 - 54.1	51.3 - 56.5	51.0 - 55.8
Solids vol. %	34.5 - 37.0	34.9 - 37.1	37.7 - 41.9	37.8 - 41.7
Sq. Ft. Coverage at 1 mil at 100% transfer efficiency	553 - 594	560 - 595	605 - 672	606 - 669

#### 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 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.

