



MP80x Series

2.1 VOC Multi Purpose Primer

Background

OMNI® MP80x Series is a fast drying, two component multi-purpose 2.1 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 gray and black.

Components

Primer

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

Hardener

MH810 Multi-Purpose Primer
Hardener

Reducer

MR294 Compliant Reducer Fast
MR295 Compliant Reducer Medium
MR296 Compliant Reducer Slow
(refer to OBTB-001 *Omni* Low VOC
Reducer Guide)

Clearcoats

MC730 2.1 VOC Production Clear
MC2910 2.1 VOC EUROPLUS® Multi-Panel 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.
SX1071 ECOBASE™ 5.5 Etch Prime
SU470LV 1K Compliant Adhesion Promoter
MP246 Polyester Primer
MP871 2.1 VOC Epoxy Primer - Gray

Can be topcoated with:

MP871 2.1 VOC Epoxy Primer - Gray
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

Preparation

Surface Cleaning:

SXA330 ACRYLI-CLEAN® Wax and Grease Remover
SXA103 MULTI-PREP™
SWX350 (H₂O-SO-CLEAN®)
SX1009 2.9 VOC Bug and Tar Remover

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:

MP80x	:	MH810	:	MR29x
4	:	1	:	2



**Wet on Wet
Sealer:**

MP80x	:	MC730/MC2910	:	MH810	:	MR29x
3	:	1	:	1	:	1



Pot Life:

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



Additives:

SLV814 Universal Flexiblizer 10% to RTS quart

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:

4:1:2	2 - 4 coats for Primer-Surfacer
3:1:1:1	1 - 2 coats for Wet-on-Wet Sealer

Dry Times



Between Coats:

5 - 10 minutes at 70°F (21°C)



Air Dry:

4:1:2 Primer Surfacer
1-2 hours at 70°F (21°C) to sand and topcoat
3:1:1:1 Wet on Wet Sealer
15 minutes to topcoat



Force Dry:

4:1:2 Primer Surfacer
20 - 30 minutes at 140°F (61°C) metal temperature



IR (Medium):

4:1:2 Primer Surfacer
10 - 15 minutes



Topcoat:

Air Dry
4:1:2 Primer Surfacer
1-2 hours to sand and topcoat
3:1:1:1 Wet on Wet Sealer
15 minutes to topcoat
Force Dry
4:1:2 Primer Surfacer
After cool down

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

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 3:1:1:1 602 sq. ft. / gal. at 100% transfer

Applied 4:1:2 592 sq. ft. / gal. at 100% transfer

PRIMER - PRIMER SEALER	Standard System	Flexible System	Standard System	Flexible System
RTS Combinations	MP80x : MH810 : MR29x	MP80x : MH810 : MR29x + 10% SLV814	MP80X : MC730 : MH810 : MR29x	MP80x : MC730 : MH810 : MR29x : + 10% SLV814
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 Actual (g/L)	120	113	118 - 142	112 - 133
VOC Actual (lbs/gal)	1.00	0.94	1.00 - 1.19	0.93 - 1.11
VOC Regulatory (less water less exempt) (g/L)	232 - 246	225 - 237	239 - 250	221 - 237
VOC Regulatory (less water less exempt) (lbs/gal)	1.94 - 2.05	1.88 - 1.98	1.91 - 2.09	1.85 - 2.03
Density (g/L)	1414 - 1511	1406 - 1485	1369 - 1452	1357 - 1433
Density (lbs/gal)	11.88 - 12.61	11.73 - 12.39	11.42 - 12.12	11.32 - 11.96
Volatiles wt. %	51.4 - 53.9	53.1 - 55.5	47.0 - 52.8	49.2 - 54.5
Solids wt. %	46.1 - 48.0	44.5 - 46.9	47.2 - 53.0	45.5 - 50.8
Water wt. %	0.0 - 0.1	0.0 - 0.1	0.0	0.0
Exempt wt. %	43.5 - 45.4	45.5 - 47.7	37.1 - 43.6	39.8 - 45.7
Water vol. %	0.0 - 0.1	0.0 - 0.1	0.0	0.0
Exempt vol. %	49.0 - 51.1	50.3 - 52.3	43.0 - 48.4	44.9 - 49.8

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 for the most up-to-date information.



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