

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)
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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

MP246 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

Note: MP871 should not be applied over etch primer.

Preparation

Surface Cleaning:

SXA330 Wax and Grease Remover
 SWX350 (H₂O-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: $\frac{\text{MP871} : \text{MP875} : \text{MR29X}}{2 : 1 : 1}$



Sealer Ratio: $\frac{\text{MP871} : \text{MP875} : \text{MR29X}}{2 : 1 : 2}$



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 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.

