



# HISTORIC / MBPX OMNI® Plus 3.5 VOC Acrylic Urethane Basecoat / M736 Converter

This TDS is intended for historic MBPX formulas that are maintained in historic MBPX color match files. Historic MBPX color match formulas (which contain M736) must use MH238 hardener in the ready to spray blend. See updated TDS if using intermix formulas with M799.

## Background

OMNI® MBPX is a fast drying, acrylic basecoat designed for today's automotive collision centers. For VOC compliance MBPX must be activated and then top coated with a compliant *Omni* clear coat.

## Components

Color	Reducer	Hardener
MBPX <i>Omni</i> Plus 3.5 VOC Acrylic Urethane Basecoat (M736 Converter)	MR294 Fast 55-65°F (13-18°C) MR295 Medium 65-75°F (18-24°C) MR296 Slow 75-85°F (24-29°C) MR297 Retarder 85-95°F (29-35°C)	MH238 Low VOC Hardener

## Compatible Products

Can be applied over:	Can be topcoated with:
Cured, cleaned and sanded OEM and refinish coatings. MP871 2.1 VOC Epoxy Primer - Gray MP831 2.1 VOC 1K Primer Surfacer - Gray MP80x 2.1 VOC Multi-Purpose Primers MP89x 2.1 VOC Urethane Sealers	MC730 2.1 VOC Production Clear MC760 2.1 VOC Universal Clear MC770 2.1 VOC High Gloss Urethane Clear MC262 2.1 VOC 4+1 Urethane Clear MC2910 2.1 VOC EUROPLUS® Multi-Panel Clearcoat

## Preparation

Surface Cleaning:	Sanding
SXA330 Wax and Grease Remover SWX350 (H <sub>2</sub> O-SO-CLEAN®) Waterborne Pre-Cleaner SX1009 2.9 VOC Bug and Tar Remover	400 Grit (machine or dry hand) or 500 Grit (wet) on old finishes and primer surfacers

## Mixing



Standard:	MBPX	:	MR Reducer	:	MH238
	10	:	10	:	1

**Note:** MBPX may be reduced with half the reducer to improve hiding. At the 10:5:1 ratio, the flash times between coats may be extended. For metallic and pearl colors, the 10:10:1 ratio should be used for the final coat to improve metallic control and orientation.



**Pot Life:** 8 hours at 70°F (21°C)

**Tinting:** MBPX color may be tinted up to 10% with *Omni* mixing bases and equal parts of M736 MBPX Converter



**Additives:** None

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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>	2 - 3 coats or until proper color is achieved
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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 at 70°F (21°C):</b>	Tape: 45 minutes
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<b>Clear:</b>	30 minutes minimum 24 hours maximum at 70°F (21°C) to clearcoat
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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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### VOC

#### Film build per coat

Applied	10 : 10 : 1	0.5 - 0.6 mils
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#### Square foot coverage at 1 mil

Applied	10 : 10 : 1	245 - 277 sq. ft. / gal. 100% transfer
Applied	10 : 5 : 1	322 - 364 sq. ft. / gal. 100% transfer

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<b>RTS Combinations:</b>	<b>MBPX (Package)</b>	<b>MBPX : MR29x : MH238</b>	<b>MBPX : MR29X : MH238</b>
Volume Ratio:	N/A	10 : 10 : 1	10 : 5 : 1
Applicable Use Category	Color Coating	Color Coating	Color Coating
VOC Actual (g/L)	84 - 347	42 - 175	63 - 231
VOC Actual (lbs/gal)	0.70 - 2.90	0.35 - 1.46	0.47 - 1.93
VOC Regulatory (less water less exempt) (g/L)	211 - 484	180 - 417	182 - 417
VOC Regulatory (less water less exempt) (lbs/gal)	1.76 - 4.05	1.50 - 3.48	1.52 - 3.48
Density (g/L)	895 - 1184	1094 - 1267	1070 - 1231
Density (lbs/gal)	7.47 - 9.88	9.13 - 10.57	8.93 - 10.27
Volatiles wt. %	51.3 - 87.1	73.3 - 90.3	64.8 - 87.2
Solids wt. %	13.9 - 48.7	9.7 - 26.7	12.8 - 35.2
Water wt. %	0.0	0.0	0.0
Exempt wt. %	33.3 - 78.7	61.7 - 86.3	53.3 - 82.0
Water vol. %	0.0	0.0	0.0
Exempt vol. %	43.0 - 76.7	56.2 - 84.1	58.9 - 79.6

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**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.

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