

MLX 2.8 VOC Acrylic Enamel

Background

OMNI™ MLX is a fast drying, two component 2.8 VOC Acrylic Enamel designed for use in VOC restricted areas.

Components

Color	Hardener	Reducer
MLX 2.8 VOC Acrylic Enamel	MH238 Low VOC Hardener	MR295 Medium 65-75°F (18-24°C) MR296 Slow 75-85°F (24-29°C) MR297 Retarder 85-95°F (29-35°C)

Compatible Products

Can be applied over:

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

Can be topcoated with:

MC730 2.1 VOC Production Clear
MC2980 2.1 VOC EUROPLUS™ Clearcoat

Preparation

Surface Cleaning:

SXA330 Wax and Grease Remover
SWX350 (H₂O-SO-CLEAN™)
SX1009 2.9 VOC Bug and Tar Remover

Sanding

320 grit machine or 500 grit (wet) on old finishes and primer surfaces

Mixing



Ratio:

MLX	:	MH238	:	MR29x Reducer
4	:	1	:	1



Pot Life:

2 hours at 70°F (21°C)

Tinting:

parts

MLX color may be tinted up to 10% with *Omni* mixing bases and equal M743 MLX converter.



Additives:

SLV814 Universal Flexiblizer, 10% to RTS quart

Do Not use SLV73 Fisheye Eliminator in MLX 2.8 VOC Acrylic Enamel

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 - 3 coats or until proper color is achieved.
Cross coat as needed.

For optimum performance final recommended film build is 2.0 - 2.5 mils.

Dry Times



Between Coats: 5 minutes at 70°F (21°C)



Air Dry: Dust: 30 - 45 minutes
Tack: 1.5 - 2 hours
Tape: 6 - 8 hours



Force Dry: 30 minutes at 140°F (60°C)



IR: 10 - 15 minutes



Polish: **Air Dry**
16 hours at 70°F (21°C) to polish and put into service
Force Dry
8 hours to polish and put into service



Recoat: **Air Dry**
8 hours at 70°F (21°C)
Force Dry
8 hours
Must lightly scuff before recoating

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 4 : 1 : 1 1.0 - 1.5 mils
Square foot coverage at 1 mil	Applied 4 : 1 : 1 920 sq. ft. / gal. 100% transfer

RTS Combinations:

RTS Combinations:	MLX Color	MLX : MH238 : MR29x	MLX : MH238 : MR29x : SLV814 (Flexible)
Volume Ratio:	As is	4 : 1 : 1	4 : 1 : 1 +10%
Applicable Use Category	Single-Stage Coating	Single-Stage Coating	Single-Stage Coating
VOC Actual (g/L)	282 - 343	197 - 237	183 - 220
VOC Actual (lbs/gal)	2.35 - 2.86	1.65 - 1.99	1.52 - 1.83
VOC Regulatory (less water less exempt) (g/L)	340 - 399	281 - 331	273 - 320
VOC Regulatory (less water less exempt) (lbs/gal)	2.84 - 3.33	2.35 - 2.76	2.28 - 2.67
Density (g/L)	1034 - 1275	1083 - 1268	1095 - 1264
Density (lbs/gal)	8.63 - 10.64	9.04 - 10.58	9.14 - 10.55
Volatiles wt. %	41.2 - 51.7	47.4 - 56.0	49.7 - 57.7
Solids wt. %	48.3 - 58.8	44.0 - 52.6	42.3 - 50.3
Water wt. %	0.0	0.0	0.0
Exempt wt. %	17.4 - 21.9	30.4 - 36.5	34.0 - 39.8
Water vol. %	0.0	0.0	0.0
Exempt vol. %	14.1 - 17.2	28.3 - 30.4	31.5 - 33.5

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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