BLP MOBILE PAINTS

PRODUCT DATA

MoPoxY™ HB
Hi-Build Epoxy Coating
40-AH-50, 40-AK-103, 40-AW-13

Polyamide Epoxy

PRODUCT DESCRIPTION

A two component high performance polyamide epoxy coating which offers high build application characteristics for reduced application costs and improved performance.

TYPICAL USES

For industrial and commercial use as a protective maintenance coating for industrial plants, pulp and paper mills, textiles mills, chemical processing plants, waste water plants, refineries, food processing plants, commercial buildings and marine structures. For coating and protecting storage tanks, piping, roofs and roof decks, water towers, structural steel, machinery, plant equipment, marine vessels, offshore structures and other surfaces exposed to humidity, chemicals and corrosive environments. Excellent over inorganic zinc-rich coatings and as an intermediate coat under polyurethane finishes.

PRODUCT ADVANTAGES

MoPoxY™ HB High Build Epoxy Coating offers excellent protection in exposures including moderate to severe industrial and marine environments. *Excellent resistance to fresh and salt water, detergents and most chemicals. *Very good resistance to fumes and spillage of most organic solvents, acids and alkalies. *Excellent abrasion and moisture resistance.*USDA approved for direct food contact surfaces.Heat resistant to 200°F.

COLORS

Gray 40-AH-50; Tan 40-AK-103; White 40-AW-13

GLOSS

Semi-gloss

PHYSICAL CONSTANTS

Nonvolatile - By weight - 65.1 ± 1.0%
By volume - 48.0 ± 1.0%
VOC (Calculated) - 3.58 lbs./gal.
429 grams/liter
Flash Point - (A) 77°F; (B) 92°F (Setaflash)
Mixing Ratio - 4:1 by volume
Weight per gallon - (A) 11.0 ± 0.2 lbs.; (B) 7.8 ± 0.2 lbs.

APPLICATION

Recommended Film Thickness - 6.0 mils dry, 12.5 mils wet
Theoretical Coverage @ 6.0 mils dry - 128 sq. ft./gal.
Method - Conventional or airless spray
Thinner - MoPoxY™ Brushing Thinner 75-35; MoPoxY™ Spraying Thinner 75-37
(Refer to thinning on back)

Cure time @ 75°F -	To touch	-	2 hours
	To handle	-	8 hours
	To recoat	-	24 hours

Pot Life @ 75°F - 8 hours minimum.
Induction Time - 30 minutes

SHIPPING & STORAGE

Consists of -	1 Gallon Unit	5 Gallon Unit
Part (A) 40-AW-13A	1 Gallon (SF)	5 Gallon (SF)
Part (B) 35-EF-36B	1 Quart (SF)	1 Gallon
Unit Shipping Weight	12 lbs.	59 lbs.

(SF) - Short Filled

Shelf Life - 12 months minimum from date of manufacture when maintained in protected storage @ 40-100°F (subject to reinspection thereafter).

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APPLICATION INSTRUCTIONS

Consult your Mobile Paint Representative for the protective coating system best suited for your requirements.

Limitations: Apply in good weather when air and surface temperatures are above 50°F and surface temperature must be at least 5°F above the dew point. For optimum application properties, material should be between 70° to 100°F prior to mixing and application. Maintain unmixed material in closed containers in protected storage at 40 - 100°F.

Surface Preparation: Good surface preparation is essential to a satisfactory coating system. Surfaces to be coated should be clean and dry. Remove all oil, grease, mildew or other contamination by solvent or detergent cleaning or other effective means.

Steel - Apply to abrasive blasted steel. “Commercial Blast Cleaning” (SSPC-SP6) is recommended as the minimum. For immersion service “Near White Blasting Cleaning” (SSPC-SP10) is considered minimum. Proper blast media and blasting equipment shall be used to produce an average profile depth of 2.5 mils minimum. Do not reuse abrasive media. Remove blasting dust and grit from surfaces before painting. Blasted surfaces should be coated within 8 hours after blasting or before rusting or other contamination of the surface occurs. For severe service except for potable water tank lining, prime with MoPoxY™ HB High Build Epoxy Primer 40-DR-5 or Mo-Zinc™ 3 Inorganic Zinc Primer 28-DH-50.

Concrete - Must be clean, dry, properly cured and free from all surface contaminants. “Brush-Off Blast” (SSPC-SP7) to provide an etched surface and to remove contaminants and laitance. Remove dust before coating. A prime coat of MoPoxY™ HB will penetrate concrete and is highly recommended to provide a good base coat prior to application of MoPoxY™ HB. When applying as a prime coat thin material up to 20% by volume (25 ounces per gallon).

Previously Finished Surfaces - Repair all damaged areas. Remove gloss from previous paint by sanding or “Brush Blasting” (SSPC-SP7). Remove rust, corrosion products, heavy chalk and loose or peeling paint by “Hand or Power Tool Cleaning” (SSPC-SP2 or -SP3). Spot prime any bare areas as in new work above. If doubt exists concerning compatibility of this coating with the previous system, apply coating to a representative area (25 square feet minimum) and allow to cure and age several weeks. Then inspect for adhesion failure, wrinkling, lifting, blistering or any other sign of incompatibility. If there are no signs, coating work can proceed.

Mixing: MoPoxY™ HB is supplied in two containers as a unit. Always mix a complete unit in the proportions supplied. (1) Agitate Part A with power agitator. (2)Combine entire contents of Part A and Part B and mix thoroughly with power agitator. Allow to stand for 30 minutes and remix before application. Usable pot life depends on the temperature of the material. Refer to Pot Life section on front page.

Thinning: Material is supplied at airless spray viscosity and should not require thinning. Clean Air Regulations may not allow thinning of this product for certain uses. Do not thin beyond applicable regulations. If thinning is allowed, use MoPoxY™ Spraying Thinner 75-37 or MoPoxY™ Brushing Thinner 75-35.

Application: Spray application is preferred for proper film build and best performance. Brush application is acceptable for touch up. Roller application may require special care to prevent bubbling and may require more than one coat to attain proper film thickness. Apply at 12.5 mils wet film thickness to achieve 6.0 mils dry film thickness.

Note: When applying over Inorganic Zinc Primer it may be desirable to apply a thinned ‘mist coat’ and allow tiny bubbles to form. Follow with a full wet coat after bubbles disapperar.

Equipment: Conventional spray - Devilbiss MBC gun with E tip and needle and 30 air cap or equivalent at 50 - 90 psi atomizing pressure and 10 - 35 psi pot pressure, 3/8" ID product hose, double regulated pressure pot with oil and moisture separator. Airless Spray - Minimum of 30:1 ratio pump, .017" - .027" tip, 3/8" ID material hose.

Note: During lunch, breaks or any period of work stoppage, material should be removed from hoses and equipment. Release pressure from equipment and flush hoses and equipment with 75-35, 75-37 or ketone solvents. Do not repressurize equipment until ready to resume work.

Cleanup: Clean all equipment immediately after use with MoPoxY™ Thinner 75-37 or MIBK. Completely flush all spray equipment with either of these solvents. Occasional flushing of spray equipment during the course of the working day helps prevent buildup and possible clogging.

Safety: Safe storage, handling and use dictate that adequate health and safety precautions be observed with this product and any recommended thinners. User is specifically directed to consult the current Material Safety Data Sheet for this product as well as precautions contained on product labeling.

40-AW-13(11/03)