



**MoPoxY™ TF
Epoxy Primer Buff
40-DK-2**

Polyamide Epoxy

PRODUCT DESCRIPTION
TYPICAL USES
PRODUCT ADVANTAGES
COLORS
GLOSS
PHYSICAL CONSTANTS
APPLICATION
SHIPPING & STORAGE

A two component, rapid cure, thin film, high performance polyamide epoxy primer. Free of lead, chromates and crystalline silica.

For industrial and commercial use as a protective maintenance primer. 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 as a primer for ferrous metals or aluminum and under epoxy or polyurethane finishes.

MoPoxY™ TF Epoxy Primer 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. Fast dry primer for fast recoat.

Buff

Flat

Nonvolatile - By weight - 63.0 ± 2.0%
By volume - 44.0 ± 1.0%
VOC (Calculated) - 3.10 lbs./gal.
375 grams/liter
Flash Point - <73°F minimum (Setaflash) (mixed)
Mixing Ratio - 4:1 by volume (Component B is 35-EF-69)
Weight per gallon - 10.3 ± 0.2 lbs. (mixed)

Recommended Film Thickness per coat - 2.0 mils dry, 4.6 mils wet
Theoretical Coverage @ 2.0 mils dry - 350 sq. ft./gal.
Method - Conventional or airless spray
Thinner - MoPoxY Spraying Thinner 75-37 or MoPoxY Brushing Thinner 75-35 (refer to thinning on back)
Cure Time @ 75°F - Recoat - 30 minutes*
Dry hard - 6 hours
Immersion - 7 days
Refer to "Recoat" section on back
Pot life @ 75°F - 5 hours minimum
Induction time - 30 minutes @ 60-75° F
1 hour @ below 60° F

Consists of - 1 Gallon Unit
Part (A)40-DK-2A 1 gallon (SF)
Part (B)35-EF-69B 1 quart (SF)
SF = short filled
Unit Shipping Weight 12 lbs.

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

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 temperature are above 50°F and surface temperature is at least 5°F above the dew point. May be applied at air temperatures as low as 40°F with extended induction and cure time. For optimum application properties, material should be between 70°F to 100°F prior to mixing and application. Maintain unmixed material in closed containers in protected storage at 40°F - 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 methods.

New or Unfinished Surfaces - Ferrous Metal: For best performance, application to abrasive blasted surface is recommended. "Near White Blast Cleaning" (SSPC-SP10) is considered minimum for best performance. Proper blast media and blasting equipment shall be used to produce an average profile depth of 2.0 mils. 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. If blasting is not feasible, remove rust by "Hand or Power Tool Cleaning" (SSPC-SP2 or -SP3). **Aluminum:** Prepare as indicated above, except maintain a 1.0 – 1.5 mil profile or etch with RPI's LumaBrite, rinse thoroughly with potable water and allow to dry.

Previously Finished Surfaces Do not apply to existing coatings. Apply to properly prepared ferrous metals or aluminum.

Mixing: This is a two component coating supplied in two containers as a unit. Always mix complete units in the proportions supplied. (1) Mix contents of Component A thoroughly with a power agitator. (2) Mix contents of Component B thoroughly with a power agitator. (3) Combine the entire contents of Component A with Component B, mix thoroughly with a power agitator. Do not add thinner. Allow to stand ½ hour (at 60 - 75°F) and remix before applying. Induction time and usable pot life depends on material temperature at time of mixing.

Induction Time -
Below 60°F — 1 hour
60 - 75°F — ½ hour
Above 75°F — ¼ hour

Thinning: Material is supplied at 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. The addition of thinners will extend recoat and cure times. Thinners should never be added prior to the required induction time

Application: Spray application is preferred for proper film build and best performance. Brush application is acceptable for touch up only. Do not apply by roller. Apply at 4.6 mils wet film thickness to achieve 2.0 mils dry film thickness.

Recoat: Air, material and/or surface temperatures below 75°F or dry film thickness above 2 mils require longer dry time prior to recoating. Addition of thinner will extend recoat time. Evaluation of product under the final conditions of use should be undertaken to ensure adequate performance.

Equipment: Conventional spray - DeVilbiss MBC gun with E tip and 30 air cap or equal at 35-45 psi atomizing pressure and 8-10 psi pot pressure, 3/8" ID material hose, double regulated pressure pot with oil and moisture separator. Airless Spray - Minimum of 15:1 ratio pump, .011" - .015" 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 MoPoxY™ Spraying Thinner 75-37 or MoPoxY™ Brushing Thinner 75-35. Do not repressurize equipment until ready to resume work.

Cleanup: Clean all equipment immediately after use with MoPoxY™ Spraying Thinner 75-37 or MoPoxY™ Brushing Thinner 75-35. 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 on product labeling.

Notice: The technical data contained herein are true and accurate to the best of our knowledge. All products are offered and sold subject to Mobile Paint Manufacturing Company's Standard Conditions of Sale. Published technical data and instructions are subject to change without prior notice.

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LIMITED WARRANTY

The successful performance of this product is highly dependent on many factors beyond our control. Results are highly dependent upon the skill of the operator. This product is manufactured to meet the highest level of consistency and quality for the intended use. Mobile Paint warrants that its products meet the specifications which it sets for them. Should this product be proven to be off-specification within one year from date of shipment, Mobile Paint will, at its sole discretion, either replace the product or issue credit for the original purchase price of the product. The replacement or refund shall be the buyer's sole remedy and Mobile Paint and its affiliates **MAKE NO OTHER WARRANTY OR GUARANTEE, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY, DESIGN COMPATIBILITY AND FITNESS FOR A PARTICULAR PURPOSE. LABOR OR COST OF LABOR AND OTHER INCIDENTAL AND/OR CONSEQUENTIAL DAMAGES ARE SPECIFICALLY EXCLUDED.** The technical data contained herein are true and accurate to the best of our knowledge. Published technical data and instructions are subject to change without prior notice.