



**MoPoxY™ HB**  
**High Build Epoxy Primer**  
**40-DR-5**  
 Polyamide/ Epoxy

**P.O. BOX 717 • THEODORE, ALABAMA 36590 -0717 • PHONE (251) 443-6110 • FAX (251) 408-0410**

<b>PRODUCT DESCRIPTION</b>	A two component, high performance polyamide epoxy anticorrosive primer which offers high build application characteristics for reduced application costs and improved performance. Low VOC.	
<b>TYPICAL USES</b>	For industrial and commercial use as a protective maintenance primer 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.	
<b>PRODUCT ADVANTAGES</b>	MoPoxY™ HB High Build 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. Low VOC. Heat resistant to 200°F	
<b>COLORS</b>	Red	
<b>GLOSS</b>	Eggshell	
<b>PHYSICAL CONSTANTS</b>	Nonvolatile -	By weight - 67.4 ± 1.0% Average* By volume - 49.0 ± 1.0% Average*
	VOC (Calculated) -	3.49 lbs./gal. Average* 418 grams/liter
	Flash Point -	(A) 70° F; (B) 92° F (Setaflash)
	Mixing Ratio-	4:1 by volume (with 35-EF-36B)
	Weight per gallon -	(A) 11.6 ± 0.2 lbs.; (B) 7.8 ± 0.2 lbs.
	*Varies with color.	
<b>APPLICATION</b>	Recommended Film Thickness per coat - 6.0 mils dry, 12.2 mils wet Theoretical Coverage @ 6.0 mils dry - 131 sq. ft./gal. Method - Brush, roller, conventional or airless spray Thinner - MoPoxY™ Brushing Thinner 75-35; MoPoxY™ Spraying Thinner 75-37 Cure time @ 75°F - To touch - 2 hour To handle - 8 hours To recoat - 24 hours  Pot Life@ 75°F - 8 hours minimum Induction Time - 30 minutes	
<b>SHIPPING &amp; STORAGE</b>	Consists of -	1 Gallon Unit                      5 Gallon Unit
	Part(A) 40-DR-5A	1 Gallon(SF)                      5 Gallon (SF)
	Part(B) 35-EF-36B	1 Quart (SF)                      1 Gallon (SF)
	(SF) = Short Filled	
	Unit Shipping Weight	12 lbs.                              59lbs.

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. 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 40-100°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 Blast 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.

**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:** MoPox<sup>TM</sup> HB is supplied in 2 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 35-EF-36B and mix thoroughly with power agitator. Allow to stand for 30 minutes and remix before application. Usable pot life depends on the temperature of material. Refer to Pot Life section on front page.

**Thinning:** Material is supplied at airless spray viscosity and should not require thinning. If thinning is necessary, thin with up to 1/2 pint MoPox<sup>TM</sup> Spraying Thinner 75-37 per gallon.

**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 12.2 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 disappear.

**Equipment:** Conventional spray - DeVilbiss MBC gun with E tip 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 Teflon 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 MoPox<sup>TM</sup> Spraying 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.

**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.