



**MoPoxY™ ST**  
**High Solids Epoxy Coating**  
**41-series**  
 modified polyamide epoxy

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

<b>PRODUCT DESCRIPTION</b>	A high performance modified polyamide epoxy coating designed for high build application and effective corrosion protection on ferrous metal surfaces where optimum surface preparation may not be feasible. A multipurpose, direct to metal, surface tolerant coating. Lead and chromate free and low VOC. Contains no reportable HAPs (Hazardous Air Pollutants).		
<b>TYPICAL USES</b>	For industrial, commercial and marine use for the protection of structural steel, pipework, tank exteriors, decks and offshore structures. Designed for protection of areas exposed to moderate to severe corrosive conditions.		
<b>PRODUCT ADVANTAGES</b>	Excellent resistance to fresh and salt water, detergents and most chemicals. Excellent abrasion resistance. Excellent adhesion to tight rust. Good adhesion to damp surfaces. A direct to metal coating that does not require grit blasting. Heat resistant to 200°F (dry).		
<b>COLORS</b>	Gray 41-BH-3, Buff 41-BK-1, White 41-BW-3 (Special colors available subject to minimum order.)		
<b>GLOSS</b>	Semigloss		
<b>PHYSICAL CONSTANTS</b>	Nonvolatile -	By weight - 75.0 ± 2.0% By volume - 63.0 ± 1.0%	
	VOC (Calculated) -	2.60 lbs./gal. 312 grams/liter	
	Flash Point -	95°F (Setaflash)	
	Mixing Ratio -	4:1 by volume	
	Weight per gallon -	11.3 ± 0.2 lbs. (mixed)	
<b>APPLICATION</b>	Recommended Film Thickness per coat - 5.0 - 8.0 mils dry, 7.9 - 12.7 mils wet Theoretical Coverage @ 5.0 mils dry - 222 sq. ft./gal. Method - Brush, roll or airless spray Thinner - MoPoxY™ Spraying Thinner 75-37 Cure time @ 75°F      Tack free 3 hours Recoat                 5 hours Dry hard                16 hours  Pot life @ 75°F - 8 hours minimum Induction time @ 75°F - 15 minutes		
<b>SHIPPING &amp; STORAGE</b>	Consists of -	1 Gallon Unit	5 Gallon Unit
	Part (A)	1 Gallon (SF)	5 Gallon (SF)
	Part (B)	1 Quart (SF)	1 Gallon
	Unit Shipping Weight (SF = short filled)	12 lbs.	59 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 temperatures are above 40°F and surface temperature is 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 for maximum performance of all high performance, direct to metal coating systems. Near white blasting provides surface preparation for maximum performance. However, where conditions and/or costs dictate that blasting is not possible, MoPoxY ST will provide excellent protection over less than ideally prepared substrates. For best performance, surfaces to be coated should be clean and dry.

**New or Unfinished Surfaces - Ferrous Metal:** For best performance, application to abrasive blasted surface is recommended. "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. If blasting is not feasible, remove rust by "Hand or Power Tool Cleaning" (SSPC-SP2 or -SP3). Galvanized metal: Remove oil and prime with Vinyl Wash Primer 9-42. Aluminum: Clean thoroughly and etch with phosphoric acid based cleaning solution. Rinse well and allow to dry. 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.

**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 ST 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) Agitate Part B with power agitator. (3) Combine entire contents of Part A and Part B and mix thoroughly with power agitator. (4) Allow to stand for 15 minutes and remix before application. Usable pot life depends on the temperature of the material. Refer to Pot Life section on front page.

**Thinning -** If thinning is necessary, thin with up to 1 pint MoPoxY 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 7.9 mils wet film thickness to achieve 5.0 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:** MoPoxY ST can be applied by both airless and conventional spray equipment. Power agitated pots are recommended. Airless spray - Minimum of 30:1 ratio pump, .019" - .021" 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 ketone solvents. Do not repressurize equipment until ready to resume work.

**Cleanup:** Clean all equipment immediately after use with MoPoxY™ 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.