BLP MOBILE PAINTS

PRODUCT DATA

MoPoxY™ Epoxy Coating 513-series

Polyamide/Epoxy

PRODUCT DESCRIPTION

A two component high performance polyamide epoxy coating.

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.

PRODUCT ADVANTAGES

MoPoxY™ Epoxy Coating 513-series 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. Convenient 1:1 mixing ratio. Heat resistant to 200°F. Easy to apply. With MoPoxY™ Curing Agent 77-13B offers a high gloss finish. With MoPoxY™ Curing Agent 77-17B offers a semi-gloss finish.

COLORS

13 standard colors as shown on the color card. Special colors available subject to minimum order.

GLOSS

High Gloss with Curing Agent 77-13B; Semi-gloss with Curing Agent 77-17B

PHYSICAL CONSTANTS

Nonvolatile - By weight - 51.8 ± 1.0% *
By volume - 39.3 ± 1.0% *
VOC (Calculated) - 4.3 lbs./gal. Average *
514 grams/liter *
Flash Point - (A) 74°F; (B) 53°F (Setaflash)
Mixing ratio - 1:1 by volume
Weight per gallon - A) 11.4 ± 0.2 lbs.; B) 7.5 ± 0.2 lbs.
* Values are for white

APPLICATION

Recommended Film Thickness per Coat - 2.0 mils dry, 5.1 mils wet
Theoretical Coverage @ 2.0 mils dry - 314 sq. ft./gal.
Method - Brush, roller, conventional and airless spray
Thinner - MoPoxY™ Brushing Thinner 75-35; MoPoxY™ Spraying Thinner 75-37
Cure time @ 75°F - To touch - 2 hours
To handle - 8 hours
To recoat - 24 hours
Pot Life @ 75°F - 16 hours minimum
Induction Time - 30 minutes

SHIPPING & STORAGE

Consists of -	1 Gallon Unit	10 Gallon Unit
Base 513-series	1 Gallon (SF)	5 Gallon
Catalyst 77-13B or 77-17B	1/2 Gallon	5 Gallon
Unit Shipping Weight	11 lbs.	101 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 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° 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.

New or Unfinished Surfaces - **Wood:** Remove sap with mineral spirits. Sand smooth. Prime with MoPoxY™ thinned 20%. **Wallboard and hardboard:** Must be clean and dry. Prime with COVENTRY® Prymall 2 Acrylic Primer and Sealer, 19-7 or WEATHER-TITE™ 100% Acrylic Latex Universal Primer, 6-6. **Ferrous Metal:** For best performance, application to abrasive blasted surface is recommended. "Commercial Blast Cleaning" (SSPC-SP6) is recommended as minimum. Proper blast media and blasting equipment shall be used to produce an average profile depth of 1.5 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). Prime with MoPoxY™ Primer 513-10.

Galvanized Metal: Remove oil and prime with Vinyl Wash Primer 9-48. **Concrete Block:** Must be clean, dry and thoroughly cured. Fill pores with Block-Fil™ 60-7 or for high humidity exposures Bloc-Seal ™19-10. **Concrete:** Must be cured, dry and clean. Allow a minimum of 30 days cure time before coating. (1) "Brush Blast Cleaning" (SSPC-SP7) will remove efflorescence, laitance and other foreign matter and roughen the surface for proper adhesion. Remove all dust before coating. (2) "Acid Etching" - surface must be clean, cured and free from oil, grease, dirt, curing compounds, chalk or previously applied coating. Etch with a solution of 1 part Muriatic Acid to 2 parts water. Apply by brush or spray to wet all concrete surfaces to be coated thoroughly. After bubbling ceases (10-15 minutes) wash surface and scrub with a stiff brush. Rinse thoroughly with water to remove all traces of acid and residue. Allow to dry before coating. **Aluminum:** Clean thoroughly and etch with phosphoric acid based cleaning solution. Rinse well and allow to dry. Prime with MoPoxY™ Primer 513-10.

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 nosigns, coating work can proceed.

If lifting occurs, a barrier coat such as MO-BAR™ Universal Primer 28-DR-105 or 28-DH-37 should be applied prior to coating with MoPoxY™.

Mixing: This is a two component coating supplied in two containers as a unit. Always mix a complete unit in the proportions supplied. (1) Mix the contents of 513-series Base (Component A) thoroughly with a power agitator. (2) Combine the entire contents of Component A and Component B (Curing Agent 77-13B or 77-17B) and mix thoroughly with a power agitator. Allow a 30 minute induction time before using the coating. Agitate before use. Occasional stirring during use in suggested.

Thinning: This product is supplied at normal brushing viscosity. If thinning is necessary, thin up to 1/2 pint per gallon with MoPoxY™ Brushing Thinner 75-35 for brush or roller. Thin up to 1/2 pint per gallon with MoPoxY™ Spraying Thinner 75-37 for spray.

Application: Apply by brush, roller or conventional or airless spray. Roller application may require special care to prevent bubbling and more than one coat to obtain proper film thickness. Apply at 5.1 mils wet film thickness which will yield 2.0 mils dry film thickness.

Equipment: Brush - Use a good quality bristle brush. Roller - All purpose, good quality roller with 3/8" nap maximum. Conventional spray - For suction feed, use DeVilbiss MBC gun with E tip and needle and 30 air cap or equivalent at 40-45 psi atomizing pressure. For pressure feed, use DeVilbiss MBC gun with E tip and needle and 704 air cap or equivalent at 40-45 psi atomizing pressure and 5-8 psi fluid pressure, 3/8" ID material hose, double regulated pressure tank with oil and moisture separator. Airless Spray - Minimum of 28:1 ratio pump, .011" - .013" tip, 1/4" 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 no repressurize equipment until ready to resume work.

Cleanup: Clean all equipment immediately after use with MoPoxY™ Brushing Thinner 75-35 or MEK. 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.

513-Line(1/10)

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.