



MOTHANE™ HS-928
Polyurethane Coating
72-AX-10

Aliphatic Polyurethane

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PRODUCT DESCRIPTION

A two component, high solids, high gloss, low VOC, low HAPs, aliphatic acrylic polyurethane coating.

TYPICAL USES

For industrial and commercial use as a high performance protective coating for trailers, transportation equipment, industrial plants, mills, chemical processing plants, refineries, buildings and non-immersed marine structures. For coating and protection of storage tanks, piping, roof decks, water towers, structural steel, equipment, marine vessels, offshore structures, and other surfaces exposed to sunlight, UV light, humidity, chemicals and corrosive environments.

PRODUCT ADVANTAGES

MOTHANE™ HS-928 Polyurethane Coating provides excellent protection in moderate to severe industrial, commercial and marine environments. Excellent resistance to fresh and salt water, detergents and many chemicals. Very good resistance to fumes and spillage of most organic solvents, acids, and alkalies. Excellent abrasion and moisture resistance. Excellent gloss and color retention. DTM capable. Temperature resistant to 250°F.

COLORS

Black 72-AX-10. Special colors available subject to minimum order.

GLOSS

High Gloss

PHYSICAL CONSTANTS

Nonvolatile -	By weight - 67.2± 2.0%
	By volume - 61.1 ± 2.0%
VOC (Calculated)	2.80 lbs./gal.
	340 grams/liter
Flash Point -	(A) 80°F (B) 80°F(setaflash)
Mixing Ratio -	5:1 by volume
Weight per gallon -	(A) 8.4 ± 0.2 lbs.
	(B) 8.8 ± 0.2 lbs.

APPLICATION

Recommended Film Thickness per coat - 3.0 mils dry, 4.9 mils wet
 Theoretical Coverage @ 3.0 mils dry - 326 sq. ft./gal.
 Method - Conventional, HVLP or Airless spray
 Induction time - None
 Pot Life @ 70°F - 3 hours minimum
 Thinner - MOTHANE™ Thinner 43-EF-70 (Refer to thinning on back)
 Cure time @ 70°F -

Set to touch-	2 hours
Dry hard -	16 hours
To recoat -	16 hours to 5 days

Note - Coating is not fully cured for 7 days. (Refer to Dry Time on back.)

SHIPPING & STORAGE

Consists of -	1 Gallon Unit	5 Gallon Unit
Part (A) 72-AX-10	1 gallon (SF)	5 gallons (SF)
Part (B)73-AF-43	1 quart (SF)	1 gallon
Unit Shipping Weight -	10 lbs.	48 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).

APPLICATION INSTRUCTIONS

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

Limitations - Apply in good weather when product, air and surface temperature are above 50°F and surface temperature is at least 5°F above the dew point. Humidity must be below 90%. Conditions should be within these limits for the full curing time of the coating. Conditions of high humidity and/or low temperatures, especially with moisture condensing on the uncured paint film, will adversely affect the adhesion, curing and gloss of the coating. For optimum application properties, material should be between 70°F to 100°F prior to mixing and application. Maintain unmixed material in original, 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 methods. Dry abrasive blasting provides the greatest level of surface preparation. For best results, apply over recommended primer.

New or Unfinished Surfaces : Ferrous Metal: Follow preparation guidelines for recommended primer. Prime with MoPoxY™ TF 40-DK-2 or MoPoxY™ ST 41-BK-1.

Galvanized Metal: Remove oil and prime with MoPoxY™ Primer 513-10. **Aluminum:** Follow preparation guidelines for recommended primer. Prime with MoPoxY™ TF 40-DK-2.

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 - MOTHANE™ HS-928 is supplied in 2 containers. Always mix a complete unit in the proportions supplied. (1) Agitate Part A with power mixer (2) Combine entire contents of Part A and Part B and mix thoroughly with power mixer. Usable pot life depends on the temperature of the material. Refer to Pot Life section on front page.

Dry Time - Under proper painting conditions this coating is dry hard in 16 hours but not fully cured for 7 days. Dry time is highly dependant on film thickness, thinner selection, temperature, humidity and air movement.

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 MOTHANE™ Thinner 43-EF-70, MOTHANE™ Retarder 43-EF-80 or MAK Thinner 43-EF-136. Certain HAPs free solvents and VOC exempt solvents are also acceptable. Check with your Mobile Paint representative for recommendations. The use of non-specified thinners may render this product useless.

Application - This product is designed for application by conventional spray or HVLP. Airless spray is also acceptable. Brush and roller application is considered for touch up of small areas only. Apply 4.9 mils wet film thickness which will yield 3.0 mils dry film thickness.

Equipment - Airless Spray - Minimum of 30:1 ratio pump, .011"-.013" tip, 3/8" ID material hose. Conventional spray -DeVilbiss MBC gun with E tip and needle and 30 air cap or equivalent at 40-45 psi atomizing pressure and 8-10 psi pot pressure, 3/8" ID product hose, double regulated pressure tank with oil and moisture separator. HVLP - Binks SV100 gun or equivalent with a 1.4 needle setup and adjusted to 22-25 psi. Roller - High quality all purpose roller with 1/4" nap maximum. Brush - High quality bristle brush only. Brush and roller application is for touch up of small areas only.

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 MOTHANE™ Thinner 43-EF-70. Do not repressurize equipment until ready to resume work.

Cleanup - Clean all equipment immediately after use with MOTHANE™ Thinner 43-EF-70 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.