



MOTHANE™ HD
Polyurethane Enamel
72-AX-3

Aliphatic Acrylic Polyurethane

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

PRODUCT DESCRIPTION

A two component, high performance, high gloss, aliphatic acrylic polyurethane coating.

TYPICAL USES

For industrial and commercial use as a high performance protective maintenance coating for industrial plants, pulp and paper mills, textile mills, chemical processing plants, waste water plants, refineries, food processing plants, pharmaceutical 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, transportation equipment and other surfaces exposed to humidity, chemicals and corrosive environments.

PRODUCT ADVANTAGES

MOTHANE™ HD Polyurethane Enamel offers excellent protection in exposures including moderate to severe industrial, commercial 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. Exceptional gloss and color retention on exterior exposure. Improved application properties. Temperature resistant to 250°F.

COLORS

Black 72-AX-3 (Special colors available subject to minimum order.)

GLOSS

High gloss

PHYSICAL CONSTANTS

Nonvolatile	-	By weight - 58.0 ± 1.0% mixed *
		By volume - 41.7 ± 1.0% mixed *
VOC (Calculated)-		4.11 lbs./gal. mixed *
		492 grams/liter mixed *
Flash Point	-	(A) 80°F (B) 70°F (Setaflash)
Weight per gallon-		9.8 ± 0.2 lbs. mixed *

* Average - varies according to color

APPLICATION

Recommended Film Thickness - 2.5 mils dry, 6.0 mils wet
 Theoretical Coverage @ 2.5 mils dry - 268 sq. ft./gal.
 Method - Conventional or airless spray
 Thinner - MOTHANE™ HD Thinner 43-EF-91
 Cure time @ 75°F -

To touch	-	30 minutes
To handle	-	4 hours
To recoat	-	12 hours

Pot Life @ 75°F - 4 hours minimum

SHIPPING & STORAGE

Consists of -	1 Gallon Unit	5 Gallon Unit
(A) 72-series	1 Gallon (SF)	5 Gallon (SF)
(B) 73-AF-7B	1 Quart (SF)	1 Gallon
(SF) = short filled		
Unit Shipping Weight	11 lbs.	53 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. 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 curing and gloss of the coating. 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 - Ferrous Metal: Follow preparation guidelines for recommended primer. Prime with MoPoxY™ Primer 513-10, MoPoxY™ HS Primer 613-10 or MoPoxY™ HB Primer 40-DR-5. Galvanized Metal: Follow preparation guidelines for recommended primer. Prime with Vinyl Wash Primer 9-42. Concrete: Follow preparation guidelines for recommended primer. Prime with MoPoxY™ HB 40-AW-13 Aluminum: Follow preparation guidelines for recommended primer. Prime with MoPoxY™ Primer 513-10, MoPoxY™ HS Primer 613-10, or MoPoxY™ HB Primer 40-DR-5.

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.

Tinting - Special Tint Bases are available for use with the Industrial Tinting System and should be used only after the addition of the proper amount of Industrial colorant. These Tint Bases may be short filled to allow for the addition of colorant. Actual coverage will depend on the amount of colorant added and should be taken into consideration when ordering. Some colors may require more than one coat for complete hiding.
DO NOT TINT WITH COLOR STUDIO COLORANT.

Mixing - MOTHANE™ HD is supplied in 2 containers. 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 73-AF-7B and mix thoroughly with power agitator. Usable pot life depends on the temperature of the 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 pint MOTHANE™ HD Thinner 43-EF-91 or MOTHANE™ Retarder 43-EF-80 per gallon.

Application - This product is designed for application by airless spray. Conventional spray is also acceptable. Brush application is considered for touch up of small areas. Apply 6.0 mils wet film thickness which will yield 2.5 mils dry film thickness.

Equipment - Airless spray: Minimum of 30:1 ratio pump, .011" - .013" tip, 3/8" ID Teflon material hose. Conventional spray: DeVilbiss MBC gun with E tip and 30 air cap or equal at 40 -45 psi atomizing pressure and 8 - 10 psi pot pressure, 3/8" ID product hose, double regulated pressure pot with oil and moisture separator. Brush: High quality bristle brush 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™ HD Thinner 43-EF-91. Do not repressurize equipment until ready to resume work.

Cleanup - Clean all equipment immediately after use with MOTHANE™ HD Thinner 43-EF-91 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.

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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.