


# Marine Coatings Technical Data




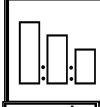


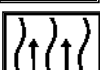
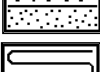


<b>Product Name</b>	Polykote MPS 4+1 Primer Filler
<b>Issue date</b>	7/19/2004
<b>Formula Number</b>	3700 Series
<b>Product code</b>	

<b>Packaging</b>
Available in 1 liter & 5 liter composite packs ( 4 liters base + 1 liter hardener)

<b>Product Description &amp; Function</b>
POLYKOTE MPS + 1 PRIMER is an ultra high quality primer for high performance applications. Polykote MPS 4+1 Primer Filler can be used as a first choice primer filler under Acrythane XSC. POLYKOTE MPS + 1 PRIMER contains high levels of Zinc phosphate and gives excellent corrosion and impact resistance. Compared to most primers, POLYKOTE MPS 4+1 Primer Filler is faster drying, easier to sand, and is higher in solids. Can be overcoated within minutes and requires no sanding between coats unless preferred by operator.
Available in white

<b>Substrates &amp; Preparation</b>		
		<b>Number of coats</b>
	<b>Aluminum -</b>	Sand blast or grind to 3-4 mils profile depending on grade of Aluminum. Spot repairs grind with 60 - 80 grit. Must be 100% clean and coated within 1 hr. of blasting/grinding. First apply one coat of HMG Etch Primer and apply MPS4+1 within 1hr
	<b>Steel -</b>	Sand with P60-P80g or sand blast to SSPC-SP5-85. Coat within 1 hr.
	<b>Previously painted -</b>	Sand with P180-P320g - ensure good adhesion to previous coats
	<b>Wood -</b>	Sand clean wood with P150-P180 grit and apply first coat reduced up to 50% with reducer. Reduce 2nd coat up to 25%. Best performance will be achieved by applying one coat of epoxy primer first. Follow instructions on TDS for either DG144 or Epi-prime epoxy primer
	<b>GRP/Gel Coat -</b>	Sand with P180-P320g being careful not to abrade through the Gel coat.
		1 - 3 coats

<b>Cleaning</b>	
	All surfaces should be pre cleaned prior to preparation and prior to application of primer. HMG SAH 270 degreaser is highly recommended as a wipe on wipe off cleaner. Cleaning between sanded coats, Contec ProSat wipes are recommended. <b>CLEAN BEFORE SANDING</b>

<b>Application</b>				
		<b>HVLP</b>	<b>Pressure Pot</b>	<b>Airless/Air Assisted</b>
	<b>Mixing Ratio</b>			
	Base	4 Parts	4 Parts	4 Parts
	Hardener	1 Part	1 Part	1 Part
	Reducer	1 - 1.5 parts	1 - 1.5 parts	0 - 0.5 parts
	<b>Spray Viscosity</b>	30 - 40 sec (Zahn 2 @ 72°F)	30 - 40 sec (Zahn 2 @ 72°F)	40 sec (Zahn 2 @ 72°F)
	<b>Gun Set Up</b>	See gun recommendations	Pot pressure 8 - 15 lbs	See gun recommendations
	<b>No of Coats</b>	See substrate		1 full coat
	<b>Flash Off</b>	10 - 30 mins		NA
	<b>Drying</b>	3 - 4 hours @ 72°F		
	<b>Pot Life</b>	3 hours @ 72°F		
	<b>Film Build</b>	4 mils WFT gives approximately 2 mils DFT		
	<b>Overcoating</b>	After 30 min without flattening as a wet on wet process with HMG Acrythane XSC Topcoat system. If greater than 36 hrs between coats, the surface should be sanded.		
	<b>Sanding</b>	Wet sand after 4 hrs. Dry sand possible after overnight dry. Sand with P320 grit paper. Contec ProSat wipe provide a clean and anti-static surface and are highly recommended after sanding		
	<b>VOC (Ready for Use)</b>	590 g / liter		

## Reducer Options

Acrythane XSC Reducer CB122 (RTD)	Fast	} Dependant on temperature or size of vessel to enable a Wet Edge to be retained. The choice of correct reducer will give optimum lay down of product and ease of application. Reducers can be blended
Acrythane XSC Polykote Reducer A788	Slow	
Acrythane XSC Reducer Brushing	V Slow	

## Hardener Option

Polykote Hardener 9004	All purpose hardener. No other available
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## Technical Information

<b>Solids</b>	Approximately 58% by weight
<b>Flashpoint</b>	Below 72°F
<b>Storage</b>	12 Months in Original sealed containers
<b>Equipment Cleaning</b>	Acrythane Reducer or Acetone
<b>Coverage</b>	407 sq/ft per US Gallon (theoretical)
<b>VOC (unmixed)</b>	590g/l

## Special Properties

Ultra high quality, high build premium primer that can be rapidly overcoated with topcoats without need for thru drying or further sanding. Even when epoxy primer is initially used, MPS 4+1 provides a great finish primer.

## Special notice - prevailing weather conditions

Polykote AMC Primer Surfacer should not be applied in temperatures below 50°F as curing times become extended beyond practical limits. Painting late in the day may result in condensation forming on the paint film that leads to loss of gloss and potential blistering problems in the cured coating. Space heaters can create moisture and worsen the situation. DO NOT apply paint if the temperature is going to drop below the dew point within 6 - 8 hrs after painting is complete.

## Health & Safety

Refer to "Material Safety Data Sheet" and can label prior to use.

FOR PROFESSIONAL USE ONLY. PAINT APPLICATORS ARE ASSUMED TO BE EXPERIENCED IN THE HANDLING AND APPLICATION OF THESE PRODUCT TYPES

Wear air fed mask when spraying this material

KEEP OUT OF THE REACH OF CHILDREN

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