PRODUCT INFORMATION

MAE Acrylic Enamel with Hardener

Background
MAE is a fast drying, two component acrylic enamel designed for economy minded collision centers. MAE may also be sprayed with the addition of MX201 Gloss Enhancer to improve gloss normally associated with clearcoating in one easy step.

MAE Acrylic Enamel w/MH Hardeners
Color
MAE Acrylic Enamel
Reducer
MR185 Fast, MR186 Medium, MR187 Slow, MR188 Very Slow, MR486 Fast, MR487 Medium, MR488 Slow
Hardener
MH101 Hardener
MH202 High Gloss Hardener

Compatible Substrates
Cured, cleaned and sanded OEM and refinish coatings
MP Series Epoxy Primers
MP176 Etch Primer*
MP178 Plastic Primer
MP180 2K Sealer
MP181 1K Primer Surfacer
MP182 2K Urethane Surfacer
MP213 GP Sealer
MP230 1K Enamel Sealer
MX241 / 245 Polyester Primers
MP282 2K Urethane Surfacer

*For optimum properties, MP176 should be overcoated with a primer surfacer or sealer before topcoating.

Preparation
Surface cleaning
MX190 Cleaner, MX191 Low VOC Cleaner, MX192 Plastic Cleaner
Sanding
400 grit (machine or dry hand) or 500 grit (wet) on old finishes and primer surfacers

Mixing
Standard

MAE		MR Reducers		MH101/MH202
8	:	1	:	1

Gloss Enhancer

MAE		MX201		MH101/MH202	MR Reducers
8	:	1	:	1	1-2

Pot life 8 hours at 70ºF (21ºC)

Additives

MX189 Retarder*	Add 10% to RTS quart
MX193 Flex Add	Add 10% to RTS quart
MX194 Fisheye Eliminator	Add up to ½ oz to RTS quart
MX195 Accelerator	Add 1 oz. to RTS quart
MX200 Accelerator	Add 1 oz. to RTS quart

*Addition of retarder may result in a non-compliant ready to spray VOC. Verify local regulations prior to use.

Mixing (cont.)
Tinting
MAE may be tinted up to 10% with OMNI™ AU mixing bases.

Application
Coats

3 coats or until hiding
Air pressure


HVLP	8 - 10 psi at the air cap
Conventional	40 - 50 psi at the gun

Gun setup
1.3 - 1.6 mm or equivalent

Dry Times
Between coats

5 - 10 minutes at 70ºF (21ºC)
Air dry

Dust: 30 Minutes
Tack: 1 - 2 hours
Tape: 4 hours
Dry: 16 hours at 70ºF (21ºC) to polish and put into service.
Force Dry
30 minutes at 140ºF (60ºC), wait 8 hours to polish and put into service.
IR
10 - 15 minutes

Clean Up
Clean spray guns, gun cups, storage pots thoroughly with MR Reducer, General Purpose Solvent or another appropriate clean up solvent after each use.
Follow EPA guidelines for proper storage and disposal of solvent-borne waste paint.

Properties
VOC

Package	4.50 lbs/ gal.
Applied (MH101)	5.00 lbs/ gal. max
Applied (MH202)	5.00 lbs/ gal. max.

Film build per coat

Applied (MH101)	1.0 - 1.4 mils
Applied (MH202)	1.0 - 1.4 mils

Square foot coverage at 1 mil

Applied (MH101)	560 sq. ft. / gal., no loss
Applied (MH202)	570 sq. ft. / gal., no loss

Limitations
Omni™ AU and Omni™ LV should not be combined with components of other product lines.

Important
The contents of this package may have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Spray equipment must be handled with due care and in accordance with manufacturer's recommendations. Follow label directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.
See Material Safety Data Sheet and Labels for additional safety information and handling instructions.
EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (304) 843-1300; IN CANADA (514) 645-1320.