



# PRODUCT INFORMATION



## MLE 3.5 Polyurethane Enamel

### Background

MLE is a fast drying, Low VOC Polyurethane Enamel designed for use in the manufacturing and industrial applications.

### MLE 3.5 Polyurethane Enamel

#### Color

MLE 3.5 Polyurethane Enamel

#### Hardener

MMA534 High Solid Urethane Hardener

### Compatible Substrates

Cured, cleaned and sanded original finishes

MP170 Epoxy Primer

MP176 Etch Primer\*

MP180 2K Sealer

MP181 1K Primer Surfacer

MP182 2K Urethane Surfacer

MP183 Compliant Sealer

MP184 Compliant Surfacer

MX198 Polyester Primer

MP210 1K High Solids Primer

MP211 2K High Solids Primer

MP213 GP Sealer

\*For optimum properties MP176 should be primed before topcoating.

### Preparation

#### Surface cleaning

MX190 Cleaner, MX191 Compliant Cleaner

#### Sanding

180 -220 grit (machine or dry hand) on bare metal and case hardened coatings.

### Mixing

#### Ratios



$\frac{\text{MLE}}{3} : \frac{\text{MMA534 Hardener}}{1}$

#### Thinning

MLE may be thinned up to 10% with MR Reducers.

#### Additives

MX200 Accelerator may be added up to 6 oz. per RTS gal.

### Application

#### Coats



1 - 2 coats

#### Air pressure



HVLP 10 psi at the air cap  
Conventional 60 psi at the gun

#### Gun setup

1.3 - 1.6 mm or equivalent

### Dry Times

#### Air Dry at 70°F (21°C)



**Between Coats** 10 - 15 minutes



**To Touch:** 1 hour

**To Handle:** 4 hours

**Dry:** 24 hours

**Recoat:** 16 hours to 4 days

**Force Dry:** Allow 10 minutes purge

**Bake at 180°F:** 10 minutes

**Bake at 140°F:** 20 minutes

**Bake at 120°F:** 30 minutes

### Clean Up

Clean spray guns, gun cups, storage pots, etc., thoroughly with MR Reducer, MS100 General Purpose Solvent or other appropriate clean up solvent after each use.

Follow EPA guidelines for proper storage and disposal of solvent-borne waste paint.

### Properties

#### VOC

Package VOC Actual 2.77-3.50 lb./gal.  
332-419 g/l

Package VOC Regulatory 2.77-3.50 lb./gal.  
(Less water less exempt) 332-419 g/l

3:1 RTS VOC Regulatory 2.62-3.17 lb./gal.  
(Less water less exempt) 314-380 g/l

#### Dry film build per coat

Applied (3:1) 1½ - 2 mils

#### Square foot coverage at 1 mil

Applied (3:1) 840 - 946 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 (412)434-4515; IN CANADA (514) 645-1320.

