

# MP3-HS

## ULTRA HIGH BUILD 2K PRIMER

### Technical Data Sheet

Technical Hotline 800.735.0303

### DESCRIPTION

MP3-HS Ultra High Build Primer is a 2 component high build primer surfacer. MP3-HS is easy to use, with good sanding properties, and will provide the desired film build in fewer coats to improve productivity and cost savings.

### QUICK REFERENCE

What: High build urethane primer.

Mix: 4:1 with MA3-HS activator.

Application: 2-3 coats with primer gun.

Time: Dry to sand in about 1.5 - 2 hours per layer.

Recoat: Topcoat with any Matrix System brand topcoat.

### REQUIRED COMPONENTS

<u>Product</u>	<u>Description</u>
MP3-HS	Ultra High Build 2K Primer
<u>Activator</u>	
MA3-HS	Ultra High Build 2K Primer Activator
<u>Reducer</u>	
Not Required	

### COMPATIBLE SUBSTRATES

Steel  
Aluminum  
Fiberglass  
Bodyfiller  
OEM E-Coat  
OEM Finishes



### PREPARATION

For best results pre clean objects to be painted before sanding. To "pre clean" an object to be painted wash thoroughly with soap and water, then, follow with MX-9000 Pre-Prep Wax & Grease Remover using clean paper towels.



## **PREPARATION CONT'D**

### ***Steel***

1. Clean repair area with Matrix MX-9000 Pre-Prep Wax & Grease Remover or MXW-9001 Low VOC Cleaner/Degreaser, where VOC regulations require use.
2. Sand with P80 grit dry.
3. Clean repair area with Matrix MX-8000 Final Prep Pre-Paint Cleaner or MXW-9001 Low VOC Cleaner/Degreaser, where VOC regulations require use.
4. Apply MP-600, MP-550 or MP-Series Epoxy Primers prior to application of MP3-HS.

### ***Aluminum***

1. Clean repair area with MXW-9001 Low VOC Cleaner/Degreaser.
2. Thoroughly sand surface with "red" scuff pad (3M 7447 or equal)
3. Clean repair area with MXW-9001 Low VOC Cleaner/Degreaser.
4. Apply MP-600, MP-550 or MP-Series Epoxy Primers prior to application of MP3-HS.

### ***Fiberglass (Gel coated or SMC surface)***

1. Clean repair area with MXW-9001 Low VOC Cleaner/Degreaser.
2. Sand surface with P220-P320 grit dry.
3. Clean repair area with MXW-9001 Low VOC Cleaner/Degreaser.

### ***Body Filler***

1. Body filler should be final sanded with P150-P220 grit dry prior to applying MP3-HS.
2. Body filler should be kept within the repair area. Do not feather body filler directly into the surrounding paint.
3. The surrounding finish should be feathered in with P220-P320 grit dry.

**\*Tech Tip:** If cleaning of the body filler is needed after sanding, use only MXW-9001 Low VOC Cleaner/Degreaser. Do not saturate the body filler. Allow extra dry time to assure polyester filler is completely dry.

### ***Existing OEM finishes***

1. Clean repair area with Matrix MX-9000 Pre-Prep Wax & Grease Remover or MXW-9001 Low VOC Cleaner/Degreaser where VOC regulations require use.
2. Sand the existing OEM finish with P220-P320 grit dry.
3. The MP3-HS application should be kept within the sanded area of the existing finishes.

### ***OEM E-Coat***

1. MP3-HS can be applied directly to properly cleaned & sanded OEM E-Coat.
2. Clean panel with Matrix MX-9000 Pre-Prep Wax & Grease Remover or MXW-9001 Low VOC Cleaner/Degreaser where VOC regulations require use.
3. To correct surface imperfections feather edge any damaged E-Coat area with P220-P320 grit dry. The remainder of the panel may be prepared using a red scuff pad (3M 7447 or equal)
4. Clean panel with Matrix MX-8000 Final Prep Pre-Paint Cleaner or MXW-9001 Low VOC Cleaner/Degreaser where VOC regulations require use.

**\*Tech Tip:** The use of clean, new, towels is encouraged in the cleaning process to minimize the likelihood of contamination to the substrate materials.



## **MIXING RATIO**

4 parts MP3-HS to 1 part MA3-HS.

## **ADDITIVES**

***Adding additional materials to a ready to spray product will increase the V.O.C as applied. Check mixture and local regulations to assure compliance.***



**Accelerator** MX-081 or MX-084 accelerator may be helpful to assure proper curing in colder weather when air dry is the only option. Although it can speed dry times, please use with caution. Excessive film build, shrinkage, loss of gloss, and incomplete curing, may result as a side effect when abused. See Additives TDS.



**Retarder** Not Recommended



**Fisheye** Not Recommended



**Flattening** Not Recommended



**Flex Additive** MX-841 can be used to increase the flexibility of any Matrix System 2K urethane primer or clear. This can be helpful during installation and life of flexible parts.



## **POT LIFE**

1.5-2 hours @ 70° F/21° C.

**\*Tech Tip:** Pot life will shorten as temperatures increase. Matrix System products are not recommended for use in temperatures below 65° F.



## **GUN SETUP**

<b>Gun Type</b>	<b>Size</b>	<b>Air Pressure</b>
Air Gunza	1.8 mm	18-22 psi at the gun inlet
Devilbiss PRI	1.8 mm	16-20 psi at the gun inlet



## **APPLICATION**

Apply 2-3 medium coats. Allow complete flash times between coats to achieve best through dry and sanding properties.



## **DRY/FLASH TIMES**

A properly flashed surface will appear dull and dry to touch. Times are approximate.

### **DRY TIMES AT 70° F/21° C**

FLASH TIME (AFTER 1ST COAT)	15-30 minutes
FLASH TIME (AFTER 2ND COAT)	30-45 minutes
TO SAND	1.5-2 hours per layer
TO TOPCOAT	after sanding

**\*Tech Tip:** Higher film build applications will often require extended flash times.

### **FORCE DRYING AT 140° F/60° C**

PURGE TIME	30 minutes
BAKE TIME	30 minutes + 1 hour cool down

## **SPECIAL CONSIDERATIONS**

Extreme temperatures and high film build applications will extend dry times.



## **RECOATING**

MP3-HS may be recoated with any Matrix System brand topcoat after sanding.



## **EQUIPMENT CLEANING**

Clean equipment immediately after use according to local regulations.

## **TECHNICAL**

Color:	Grey
Primer:	MP3-HS
Activator:	MA3-HS
Weight Solids (RTS):	63.6%
Volume Solids (RTS):	43%
Film Build:	1.3 - 1.5 mils per full coat
Coverage:	689 sq. ft. per gallon @ 1 dry mil

V.O.C. as Delivered:	Regulatory VOC lbs/gal	Regulatory VOC g/l	Material VOC lbs/gal	Material VOC g/l
MP3-HS	3.6	431	3.5	420
MA3-HS	5.9	713	5.9	713
V.O.C. (RTS):				
MP3-HS/MA3-HS	4.1	488	4.0	478

Disposal/Safety: see MSDS for this product

### **FOR INDUSTRY USE ONLY**

#### **Read MSDS Before Use**

The contents of the package must be blended with other components before the product can be used. Any mixture of components will have hazards of all components. Before opening the packages, read all warning labels. Follow all precautions.

The material is designed for application only by professionally trained personnel using proper equipment under controlled conditions, and is not intended for sale to the general public.

#### **SEE MSDS AND PRODUCT LABELS FOR ADDITIONAL SAFETY INFORMATION.**

**NOTE:** Matrix Systems products are not recommended for use in temperatures below 65°F. Use below these temperatures will effect dry times and performance.