

## ACRYLIC ENAMEL SYSTEM

### Technical Data Sheet

Technical Hotline 800.735.0303

### PRODUCT NUMBER

MSA SERIES

### DESCRIPTION

ACRYLIC ENAMEL SYSTEM

### HARDENER

MH-100

### DESCRIPTION

ACRYLIC ENAMEL HARDENER

### DESCRIPTION

A high quality, quick drying, high gloss acrylic enamel for use on properly prepared compatible substrates.

### COMPATIBLE SUBSTRATES

- MP-120 SERIES SEALERS
- MPV-2K PRIMER
- MP-35 SEALER
- MP3-HS PRIMER
- OEM FINISHES\*
- 2KPB PRIMER
- MP-2K PRIMER
- MP6-SS PRIMER
- MP-EPOXY PRIMER

*\*Tech Tip:* Proper sanding and cleaning is required to insure the best possible results are obtained.

### SURFACE PREPARATION



1. Finish sand repair areas with 400-600 grit or equivalent.
2. Clean repair areas with MX-8000 Pre Paint Cleaner or MXW-9001 where VOC regulations require its use. Wipe off any MXW-9001 residue with a clean damp cloth.
3. Use a tack cloth to remove any surface contaminants that may have settled on the repaired areas prior to paint application.
4. Apply MSA Acrylic Enamel color.

*\*Tech Tip:* For maximum product performance, seal repaired areas with MP-120 Series sealers, choose a sealer shade that will enhance the basecoat colors hiding capabilities or a color shade that closely resembles the basecoat color the vehicle will be.

### MIXING RATIO



READY TO SPRAY

OR

### MIXING RATIO



MSA : MH-100  
4 Parts : 1 Part

## POT LIFE (WHEN USING 4:1 MIX RATIO)



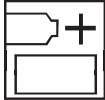
Hardener  
MH-100

Time  
4 Hours minimum

Temp  
77° F

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

## ADDITIVES



### **ACCELERATOR**

Accelerator may **NOT** be used.



### **FISH EYE ELIMINATOR**

Fish Eye Eliminator is not recommended for use in this product.

## APPLICATION



Adjust air pressure to 40-50 psi at gun for gravity or siphon feed guns or HVLP use 6-10 psi at air cap. Apply 2-3 medium coats (maximum 2 mils wet per coat) or until hiding is achieved. Allow a 15-20 minute flash time between coats and before force drying.



**GUN TYPE**  
**SIZE**  
**PSI**

**HVLP**  
1.3 - 1.7 mm  
6 - 10 at Aircap

**Conventional**  
1.3 - 1.7 mm  
40 - 50 at Gun

## DRY & FLASH TIME INFORMATION



### **DRY TIMES AT 77° F**

FLASH TIME 15-20 MINUTES  
TO DELIVER 16-24 HOURS



### **FORCE DRYING AT 140° F**

PURGE TIME 15 MINUTES  
BAKE TIME AT 140°F 40 MINUTES

## RECOATING



MSA may be recoated after 36 hours at 77°F. After 36 hours MSA must be lightly sanded/scuffed before additional color or clearcoat may be applied.

## EQUIPMENT CLEANUP



Clean equipment immediately after use with MX-110 Gun Wash or a high quality lacquer thinner.

## **TECHNICAL DATA**

Color:	Various
Mixing Ratio:	Ready To Spray (RTS) or 4:1
Viscosity #2 Zahn (RTS):	25 - 30 seconds #2 Zahn
Weight Solids (RTS):	43.5 - 47.5%
Film Build per coat:	Recommended 2 mils
V.O.C. (RTS):	4.43 lbs/gal (varies with color)
Disposal/Safety:	See MSDS for this product

**NOTE:** Matrix System products are not recommended for use in temperatures below 60°F. Use below these temperatures will effect dry times and performance.  
**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.**

***Put it to the test!***  
**[www.matrixsystem.com](http://www.matrixsystem.com)**