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**

<table>
<thead>
<tr>
<th>Color</th>
<th>MLE 3.5 Polyurethane Enamel</th>
</tr>
</thead>
<tbody>
<tr>
<td>Hardener</td>
<td>MMA534 High Solid Urethane Hardener</td>
</tr>
</tbody>
</table>

**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**

<table>
<thead>
<tr>
<th>Surface cleaning</th>
<th>MX190 Cleaner, MX191 Compliant Cleaner</th>
</tr>
</thead>
<tbody>
<tr>
<td>Sanding</td>
<td>180 - 220 grit (machine or dry hand) on bare metal and case hardened coatings.</td>
</tr>
</tbody>
</table>

**Mixing**

<table>
<thead>
<tr>
<th>Ratios</th>
<th>MLE MMA534 Hardener</th>
</tr>
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<tbody>
<tr>
<td></td>
<td>3 : 1</td>
</tr>
</tbody>
</table>

**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**

<table>
<thead>
<tr>
<th>Coats</th>
<th>1 - 2 coats</th>
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</thead>
</table>

**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**

<table>
<thead>
<tr>
<th>Air Dry at 70ºF (21ºC)</th>
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</thead>
<tbody>
<tr>
<td>Between Coats</td>
<td>10 - 15 minutes</td>
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</tbody>
</table>

**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**

<table>
<thead>
<tr>
<th>VOC</th>
<th>Package VOC Actual</th>
<th>2.77-3.50 lb./gal.</th>
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</thead>
<tbody>
<tr>
<td></td>
<td>Package VOC Regulatory</td>
<td>2.77-3.50 lb./gal.</td>
</tr>
<tr>
<td></td>
<td>3:1 RTS VOC Regulatory</td>
<td>2.62-3.17 lb/gal.</td>
</tr>
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</table>

**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.