



INDUSTRIAL COATINGS

TECHNICAL DATA SHEET

MFI-590/590B/590W INDUSTRIAL EPOXY SEALERS

PRODUCT DESCRIPTION MFI Systems™ Industrial Epoxy Sealers are a two-component, 100% epoxy, industrial-grade sealer with good film build and exceptional anti-corrosion properties for DTM applications. It has excellent adhesion to properly sanded and cleaned bare metals, including aluminum. MFI-590/590B/590W levels to an almost texture-free surface with excellent gloss holdout. It can be sanded, when needed, and the three colors can be intermixed to achieve various shades of gray. MFI-590/590B/590W is V.O.C. compliant in North America and available in gallons. Use with **MFI-592 Epoxy Sealer Activator**.

COMPATIBLE SUBSTRATES

Cold Rolled Steel*	Stainless Steel*	Galvanized/Galvaneal*
Aluminum*	Factory E-coats	Properly Prepared Fiberglass/SMC

*Properly sanded and cleaned

SURFACE PREPARATIONS

The surface must be clean and free of all surface contamination. A degreaser/acid cleaner should be used to remove oils and other contaminants. See your MFI Systems™ Representative for recommendations.

MIXING

4 Parts: MFI-590/590B/590W Industrial Epoxy Sealer

1 Part: MFI-592 Industrial Epoxy Sealer Activator

Optional Reduction Up to 1 Part MFI-400 Series Zero VOC Reducer to help with flow.

NOTE: Mix by volume and stir thoroughly. Make sure product is at room temperature (72°F/22°C) before mixing.

APPLICATION

Apply 1-2 wet coats of Industrial Epoxy Sealer. Allow 10-15 minutes flash time between coats. Industrial Epoxy Sealer can be topcoated in 30-60 minutes @ 70°F (21°C). Do not apply at temperatures below 50°F

- Apply with a 1.4 mm – 1.6 mm fluid nozzle and tip. Air pressure should be 8 -10 psi HVLP or 40 – 45 psi Conventional
- Drying time listed may vary, depending upon film build, temperature, humidity and degree of air movement
- Excess film thickness will retard dry times and affect the recoat window
- Avoid moisture contamination with the Activator – moisture can gel the material and affect the performance properties

CURE TIMES

Air-dry (assumes 77°F & 50% Relative Humidity)

To Topcoat: 30 – 60 min.

To Recoat: 24 hrs. (After 24 hours, sand with 320 grit)

See Safety Data Sheet and labels for additional safety information and handling instructions.

- 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 and SDSs of all component, since the mixture will have the hazards of all its parts.
- Improper handling and use, for example, poor spray technique, inadequate engineering controls, and or lack of Personal Protective Equipment (PPE), may result in hazardous conditions or injury.
- Follow spray equipment manufacturer's instructions to prevent personal injury or fire.
- Provide adequate ventilation for health and fire hazard control.
- Follow company, product SDS and respirator manufacturer's recommendations for selection and proper use of respiratory protection. Be sure employees are adequately trained on the safe use of respirators per company and regulatory requirements.
- Wear appropriate PPE such as eye and skin protection. In the event of injury, see first aid procedures on SDS.
- Always observe all applicable precautions and follow good safety and hygiene practice.
- For additional health and safety information refer to the SDS which can be found at www.mfisystems.com



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**MFI-590/590B/590W
INDUSTRIAL EPOXY SEALERS**

TECHNICAL DATA:

Property	Method	Result*
Color		Gray, Black, White
Conical Mandrel (1/8")	ASTM D522	Pass
Adhesion	ASTM D3359	Excellent
Salt Spray Resistance – 1000 Hrs.	ASTM B117	Excellent (topcoated)
Chemical Resistance		Good
Substrates		CRS, HRS, Aluminum, Stainless Steel, Galvanized, Plastics**, Fiberglass**
Recommended Topcoat(s)		MFI-5000 Series, MFI-5100 Series, MFI-5200 Series, MFI-5300 Series, MFI-5500 Series

*These results were obtained over iron phosphated CRS panels.

**Because of the variability of plastic/fiberglass substrates, coating performance should be confirmed on the actual plastic or fiberglass substrate being used.

PHYSICAL PROPERTIES:

Property	Blended Value* (4:1 with MFI-592)
Weight per gallon	10.3 ± 0.3 lbs./gal.
Weight Solids (%)	45.0 ± 2.0
VOC (less exempts)	2.09 lb./gal.
VOC (actual)	1.15 lb./gal.
Coverage (@1mil, no loss)	539 – 599 sq. ft./gal.
Shelf Life	12 months

APPLICATION:

Mixing Instructions: Mix by volume. Stir thoroughly.

4 Parts: MFI-590/590B/590W 2.1 VOC Industrial Epoxy Sealer
1 Part: MFI-592 Epoxy Sealer Activator
Optional Up to 1 Part: MFI-400 Series Zero VOC Reducer

Wet Film Thickness: 2.0 – 2.4 mils per coat

Dry Film Thickness: 1.0 – 1.2 mils per coat

Reducers: Fast – MFI-465 Reducer, Medium – MFI-475 Reducer, Slow – MFI-485 Reducer
(Use of the following reducers will increase V.O.C.s above 3.5 lb./gal.: MFI-365, MFI-375, MFI-385)

Pot Life: Up to 8 hours @ 72°F (22.2°C), 50% RH

The technical data presented is information believed by MFI Systems™ to be currently accurate; however, no guarantee of accuracy, comprehensiveness or performance is given or implied. Continuous improvements in coating technology may cause future technical data to vary from what is in this document. Product is intended for application by trained personnel in a factory or shop application. Do not attempt to use product without the current Safety Data Sheet. The performance of a product can fluctuate due to surface preparation technique, method of application, operating conditions, the material it is applied to or with, and use. It is strongly recommended that products be tested with respect to these factors prior to full scale use.