



## Spray Bond Adhesive

MPC198

# 274 793SP

Matthews 274 793SP Spray Bond is a single component spray applied adhesive designed to provide excellent adhesion over hard-to-adhere-to metals. It is a paint adhesive rather than a primer and will accept any of the Matthews topcoats. Spray Bond is water clear in color, which makes it an excellent choice as an adhesion promoter when applying MAP<sup>®</sup> Clear finishes to protect and highlight underlying metals.



### Features

- Universal
- Water Clear
- Single Component

### Compatible Surfaces

**274 793SP Spray Bond may be applied over:**

- Polished or Brushed Aluminum
- Brass, Bronze or other alloy metals
- Copper

**Note:** Spray Bond is not intended as a corrosion inhibiting coating and will not protect metals from rust or other forms of oxidation breakdown. When clearcoating polished metals, use Braco Clear (see MPC173 Technical Bulletin).

### Directions For Use

#### Surface Preparation:

- Wipe/clean substrate using 45 330SP Speed Prep Cleaner. Refer to MPC111 Technical Bulletin.
- Remove any residue with clean, lint-free cloth and wipe dry.
- All surfaces must be free of oil, grease or any other contaminants prior to coating.



#### Mix Ratios (by volume):

Ready to spray in can - needs no further reduction.

Spray Bond is a single component product that does not require the addition of an activator or catalyst. Strain material before using.



#### Additives:

None Recommended.

### Benefits

- Can be topcoated with most Matthews clear finishes
- Can be used as an adhesion promoter when applying clear coats to metals
- No potlife

**Warning:** Spray Bond should be applied to metal surfaces only and is not recommended over plastics, wood, primers or topcoats.

## Directions For Use (Continued)



### Spray Set Up:

#### Air Pressure

Conventional.....	40-50 lbs. psi at the gun
HVLP.....	10 psi at cap
Pot Pressure .....	15-18 psi

#### Gun Set Up

Siphon Feed .....	1.3 mm 0.050 fluid tip
HVLP.....	1.3 mm 0.050 fluid tip
Pot Pressure .....	1.2 mm 0.046 fluid tip



### Application:

- Apply 2-3 medium wet coats
- Flash 5-10 minutes between coats
- Follow with a second medium wet coat

**Warning:** Chamfer or knock-down all sharp edges.



### Drying Times:

#### Air Dry (50% relative humidity, 70°F / 21°C):

Tack Free .....	10-15 minutes
To Topcoat.....	15 minutes minimum, 30 minutes maximum

**Note:** Spray Bond is not a finish coat and should be topcoated within 30 minutes after application.

### Compatible Topcoats:

MAP® Colors & Clears, SVOC MAP® Colors & Clears, MAP® Ultra Low VOC Satin & Gloss

### Equipment Cleaning:

- Clean up equipment promptly with an all-purpose cleanup solvent.
- Do not leave mixed material in equipment.

### Technical Data:

#### VOC Information

274 7935SP Spray Bond.....	0
Ready to Spray .....	0

#### Performance Characteristics

Solids by Weight .....	2.9%
Volume Solids .....	2.6%
Theoretical Coverage (0.15-0.25 mil @ 100% transfer efficiency).....	41.7 sq.ft./RTS gal.
Application Conditions .....	60°F (16°C) Minimum 100°F (38°C) Maximum
Relative Humidity.....	85% Maximum 5° above dew point
Flash Point (Tag closed cup) .....	45°F (12°C)

### 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. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow 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:

US (412) 434-4515; CANADA (514) 645-1320; Mexico 01-800-00-21-400

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