



High Performance Clear

6178SP/01

Matthews 6178SP/01 High Performance Clear is a premium quality, polyester-based, high gloss clear.

6178SP/01 produces an unsurpassed durable finish that is resistant to graffiti, chlorine and salt water exposure.

6178SP/01 is a high solids clear and is compliant in all 3.5 VOC regulated areas.

6178SP/01 is not intended for use as a coating for anti-fouling or use in marine applications.



Features:

Benefits:

Durable gloss finish	Adds depth and appearance
Air-dry or force-dry capable.....	Fits most shop conditions
High performance polyester technology.....	Resistance to chlorine, salt water, weathering, and chalking; Semi-Submersible
Excellent UV resistance	Excellent color and gloss retention; Extended life cycle; Reduced maintenance costs

Compatible Surfaces:

6178SP/01 High Performance Clear may be applied over properly prepared:

- | | |
|-------------------------------|---|
| MAP® | 74777SP/01 Tie Bond Adhesive** |
| Satin MAP® | 274777SP/01 Low VOC Tie Bond Adhesive** |
| Satin VOC MAP® | 274793SP/01 Low VOC Spray Bond Adhesive** |
| MAP-LVG Acrylic Polyurethane* | |
| MAP-LVS Acrylic Polyurethane* | |

*To ensure proper adhesion, apply HP Clear immediately following flash-off of final coat of LVG or LVS color.

**Warning: HP Clear cannot be applied directly over 74777SP/01 Tie Bond, 274777SP/01 Tie Bond or 274793SP/01 Spray Bond. If Tie Bond or Spray Bond is used, apply one coat of conventional or low VOC clears before applying HP Clear.

Associated Products:

- | | |
|-------------------------------------|---------------------------------------|
| Catalyst | Reducer |
| 6278SP/01 High Performance Catalyst | 6378SP-S/01 HP Clear Reactive Reducer |

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Directions for Use

Surface Preparation:

Substrate should be prepared according to Matthews Substrate Preparation Guide prior to topcoat application.

Mix Ratio:



Mix Ratio for Spraying (by volume)

6178SP/01	6278SP/01	6378SP-S/01
HP Clear	HP Catalyst	HP Reducer

1 part : 1 part : 1/2 part

All components should be mixed thoroughly before using
Strain material after mixing



Pot Life: 4 hours

Pot-life is the amount of time before spray viscosity doubles. These are estimates based on lab results at 50% relative humidity, 70°F/21°C—results will vary based on application conditions.
Note: mix no more product than can be used within time limits listed below:

Additives:



None

Spray Set Up:



Air Pressure:	Conventional:	40 - 50 psi at the gun*
	HVLP:	10 psi at the cap*

* Refer to spray gun manufacturer recommendations for inlet pressure.



Pressure Pot Fluid Delivery:	8 - 12 Fluid Ounces per Minute
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Gun Set Up:	Siphon Feed:	1.2 - 1.4 mm 0.047 - 0.055 fluid tip
	HVLP:	1.2 - 1.4 mm 0.047 - 0.055 fluid tip
	Pressure Pot:	1.0 - 1.2 mm 0.039 - 0.047 fluid tip

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Directions for Use

Application:



Apply:

Apply two to three medium wet coats, allowing proper flash time* between coats. Apply additional coats as necessary to achieve total dry film thickness.

*Flash times will vary dependent upon film thickness, temperature, spray gun set-up, application, etc.

Recommended		Per Coat	Total
Film Thickness:	Wet Film Thickness (WFT)	1.6 - 1.8 mils	3.2 - 5.4 mils
	Dry Film Thickness (DFT)	0.8 - 0.9 mils	1.5 - 2.7 mils

Caution: All 2-component crosslinking slows significantly at temperatures below 60°F or 16°C. Never spray or subject freshly painted coatings to these conditions or loss of gloss, decreased durability and improper curing can occur.

Estimated Drying Times:



Air-Dry @ 50% Relative Humidity, 70°F/21°C

Dust Free	1 hour
Set to Touch	2.5 hours
Dry to Handle	5 hours

Recoating: Paint films cured over 8 hours should be cleaned, lightly dry scuff sanded with 320 – 400g by hand/machine or wet sanded with 600g, then cleaned again before recoating.

Force Dry: Allow 30 minute purge before baking to prevent solvent popping. Bake for 40 minutes at 140°.

Equipment Cleaning:

Clean equipment promptly with lacquer thinner or equivalent cleaning solvent.

Note: Do not leave mixed material in equipment.

Technical Data:

VOC Information

VOC Actual RTS	3.08 lbs/gal
VOC Actual RTS	369 g/L
VOC Regulatory (less water less exempt) RTS	3.37 lbs/gal
VOC Regulatory (less water less exempt) RTS	404 g/L

For complete VOC information, visit MatthewsPaint.com > Quick Links > VOC Data

Performance Characteristics

Volume solids (RTS)	47.6%
Theoretical Coverage (1 mil @ 100% transfer efficiency)	763 sq.ft./RTS gal
Application Conditions - Temperature	60°F (16°C) Minimum 100°F (38°C) Maximum
Application Conditions - Relative Humidity	85% maximum 5° above dew point

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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 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
Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the general public. Products mentioned may be hazardous and should only be used according to directions, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to Matthews Paint. Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results, or fitness for any intended use, nor does Matthews Paint warrant freedom from patent infringement in the use of any formula or process set forth herein. If you require technical assistance, please call us toll-free 800/323-6593.



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