The Best Steps for the Best Coat

Matthews Paint Substrate Preparation Guide

Select your substrate from the list below.

Clearcoat Preparation Recommendations

MPG MATTHEWS PAINT

Steps to Success

Matthews Paint Substrate Preparation Recommendations

Step #1 - Matthews is for Professional Use Only.

Step #2 - Always follow proper safety precautions when using Matthews products. Safe usage requires reading, understanding and following all labels, MSDS, and other product literature before use.

Step #3 - The spray area and substrate must be warm and have adequate airflow. Application of primers, topcoats, and clearcoats should never take place in temperatures under 60°F/16°C. Substrates should also be brought to or above this temperature guideline before applying any primer or topcoat.

Step #4 - Properly clean substrate.
Professionals don't even think about priming or painting over any substrate that hasn't been properly cleaned and prepared. Use proper cleaning products and procedures.

Step #5 - Knock down sharp edges whether routed or cut. Round any dramatic sharp edges on substrate. Primer and paint topcoat films are weakest on sharp 90 degree edges.

Step #6 - Use the right primer for every specific substrate.
Always use the appropriate primer and application techniques suggested from the Matthews substrate guide.

Step #7 - "When in doubt, test it out."
We recommend testing the process for any new product, primer, or first time application procedures before permanent production begins. Remember that the change of seasons affect the temperature and humidity during application, so periodic testing on application and adhesion confirms the product and production performance.

Step #8 - Choose the proper reducer for each application.
Review product data sheet for reducer temperature guidance.

Step #9 - Allow specified times between coats. For both primers, topcoats, and clears, extend flash times between each coat application.

Step #10 - Contact Matthews Paint with any questions. Matthews' customer service and technical assistance are both available for any color formula match, specification, or technical question that may arise.

Call toll free at **1-800-323-6593**
Or visit our web site at **www.matthewspaint.com**

Important Notes

Before any spray applications, consult your local city, local air quality districts, or government office to determine what regulations you must follow to be compliant with VOC regulations in your community. 45 330SP Speed Prep Cleaner may not be used in certain areas of the country!

Investigate or consult with the substrate manufacturer for information regarding proper cleaning and preparation for specialty coatings. If you cannot find your substrate in this guide, contact the substrate manufacturer.

We recommend to periodically test adhesion on a sample of the substrate you are utilizing to ensure application process in your environment. Perform this test after a full cure of product has been applied (72 hours or more). A Cross-Hatch Adhesion test is the most common system utilized for this process.

Before opening the products listed, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Use product technical data sheets for guidance.

Follow spray equipment manufacturer's instructions to prevent personal injury or fire.

Always adhere to directions for proper respirator fit, use, and maintenance.

Wear eye and skin protection at all times when working in the spray area.

Observe all application precautions.

See Material Safety Data Sheets and labels for additional safety information and handling instructions – available on our website at www.matthewspaint.com.

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.

Always refer back to a Matthews Paint Technical Data Sheet for further product application guidance. If you require technical assistance—please call toll free at 800-323-6593.

Aluminum

Note: All primers are listed by VOC content with the lowest VOC primers being first.

! Use proper respirator safety protection during sanding.

! When spraying 6001SP Polyester Primer Surfacer, it is important to refer to the technical sheets for spray tip details. We recommend the use of a 2.0 tip in the spray gun. When activated, mix thoroughly and apply immediately.

White Epoxy Primer:

MAP-LVU100: *RTS 0.42 VOC*

- Clean with 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 6405SP Low VOC Cleaner.
- Apply 1 full wet coat of White Epoxy Primer.
- Allow 5-10 minutes to flash.
- Sand after 24 hours air dry before recoat.
- Allow 30-60 minutes to flash.
- Topcoat per technical data sheet recommendations.

Polyester Primer Surfacer:

6001SP: *RTS 1.8 VOC*

- Clean with 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 6405SP Low VOC Cleaner.
- Mix Polyester Primer Surfacer according to instructions (see text box).
- Apply 1 wet coat of Polyester Primer Surfacer.
- Allow 20 minutes to flash.
- Apply 2nd wet coat of Polyester Primer Surfacer.
- Allow 20 minutes to flash.
- Allow longer flash times between 3rd coats.
- Allow 20-30 minutes to flash.
- Allow 1.5 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

E-Prime:

274 228SP or 274 229SP: *RTS 2.8 VOC*

- Clean with 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 6405SP Low VOC Cleaner.
- Apply 1 full wet coat of E-Prime.
- Allow 10-15 minutes to flash.
- Apply 2nd wet coat of E-Prime.
- Allow 30-60 minutes to flash.
- Topcoat per technical data sheet recommendations.

U-Prime:

274 685SP: *RTS 2.8 or 3.5 VOC*

- Clean substrate with 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 6405SP Low VOC Cleaner.
- Apply 1 wet coat of U-Prime.
- Allow 10-15 minutes to flash.
- Apply 2nd wet coat of U-Prime.
- Allow 10-15 minutes to flash.
- Allow 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

Aluminum

Note: All primers are listed by VOC content with the lowest VOC primers being first.

! Use proper respirator safety protection during sanding.

Non-Chromate Etch Primer:

74 350SP/74 351SP: *RTS 3.5 VOC*

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 full wet coat Non-Chromate Etch Primer **only**.
- Topcoat after 30 to 60 minutes.

Gray Epoxy Primer:

6007SP: *3.5 VOC*

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 full wet coat.
- Allow 30-60 minutes to flash.
- 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

White Epoxy Primer or Black Epoxy Primer:

274 908SP or 274 808SP:

Both are RTS 3.90-3.95 VOC

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 wet coat of Epoxy Primer.
- Allow 10-15 minutes to flash.
- Apply 2nd wet coat of Epoxy Primer.
- Allow 30-60 minutes to flash.
- Allow 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

HBEF Self-Etching Metal Treatment:

74 780SP: *RTS 6.04 VOC*

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 wet coat of HBEF Self-Etching Metal Treatment.
- Allow 3-5 minutes to flash.
- Apply 2nd wet coat of HBEF Self-Etching Metal Treatment.
- Allow 20-30 minutes to flash.
- Topcoat per technical data sheet recommendations.

Aluminum Continued On Next Page...

Aluminum

Note: All primers are listed by VOC content with the lowest VOC primers being first.

Use proper respirator safety protection during sanding.

74 734SP Metal Pretreatment not for use over Sanded, Shot or Media blasted aluminum due to the product's ZERO filling properties.

HBPT Self-Etching Metal Treatment:

74 770SP: *RTS 6.13 VOC*

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 wet coat of HBPT Self-Etching Metal Treatment.
- Allow 5 minutes to flash.
- Apply 2nd wet coat of HBPT Self-Etching Metal Treatment.
- Allow 20-30 minutes to flash.
- Topcoat per technical data sheet recommendations.

Metal Pretreatment:

74 734SP: *RTS 6.34 VOC*

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 wet coat of Metal Pretreatment.
- Allow 15-30 minutes to flash.
- Topcoat per technical data sheet recommendations.

PT Filler:

74 760SP: *RTS 6.4 VOC*

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 wet coat of PT Filler.
- Allow 5 minutes to flash.
- Apply 2nd wet coat of PT Filler.
- Allow 20-30 minutes to flash.
- Topcoat per technical data sheet recommendations.

Anodized Aluminum

Note: All primers are listed by VOC content with the lowest VOC primers being first.

! Sanding must be performed to **remove all the Anodized surface from the aluminum.**

! Use proper respirator safety protection during sanding.

White Epoxy Primer:

MAP-LVU100: *RTS 0.42 VOC*

- Clean with 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 6405SP Low VOC Cleaner.
- Apply 1 full wet coat of White Epoxy Primer.
- Allow 5-10 minutes to flash.
- Apply 2nd full wet coat of White Epoxy Primer.
- Allow 30-60 minutes to flash.
- Sand after 24 hours air dry before recoat.
- Topcoat per technical data sheet recommendations.

Gray Epoxy Primer:

6007SP: *3.5 VOC*

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 full wet coat.
- Allow 30-60 minutes to flash.
- 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

White Epoxy Primer or Black Epoxy Primer

274 908SP and 274 808SP: *Both RTS 3.90-3.95 VOC*

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 wet coat of Epoxy Primer.
- Allow 10-15 minutes to flash.
- Apply 2nd wet coat of Epoxy Primer.
- Allow 30-60 minutes to flash.
- Allow 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

Aluminum Composite Sheets

(Alucobond®, Dibond, Alumilite, Alpolic, Alupanel and Ecopanel)

Note: All primers are listed by VOC content with the lowest VOC primers being first.

! Topcoat can be directly applied by preparing the substrate. Do not abrade or scuff down to expose the bare aluminum. If bare aluminum exposed, use epoxy primer application.

! Use proper respirator safety protection during sanding.

Topcoat Application
- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible or scuff substrate with Scotch-Brite pad until sheen has been removed.
- Clean again with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Topcoat per technical data sheet recommendations.
- Check adhesion.
- We recommend using any Epoxy Primer for stronger adhesion.

White Epoxy Primer:

MAP-LVU100: *RTS 0.42 VOC*
- Clean with 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 6405SP Low VOC Cleaner.
- Apply 1 full wet coat of White Epoxy Primer.
- Allow 5-10 minutes to flash.
- Sand after 24 hours air dry before recoat.
- Allow 30-60 minutes to flash.
- Topcoat per technical data sheet recommendations.

E-Prime:

274 228SP or 274 229SP: *RTS 2.8 VOC*
- Clean with 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 6405SP Low VOC Cleaner.
- Apply 1 full wet coat of E-Prime.
- Allow 10-15 minutes to flash.
- Apply 2nd wet coat of E-Prime.
- Allow 30-60 minutes to flash.
- Topcoat per technical data sheet recommendations.

Gray Epoxy Primer:

6007SP: *3.5 VOC*
- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 full wet coat.
- Allow 30-60 minutes to flash.
- 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

Aluminum Composite Sheets

(Alucobond®, Dibond, Alumilite, Alpolic, Alupanel and Ecopanel)

Note: All primers are listed by VOC content with the lowest VOC primers being first.

! Topcoat can be directly applied by preparing the substrate. Do not abrade or scuff down to expose the bare aluminum. If bare aluminum exposed, use epoxy primer application.

! Use proper respirator safety protection during sanding.

White Epoxy Primer or Black Epoxy Primer:

274 908SP or 274 808SP:

Both are RTS 3.90-3.95 VOC

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 wet coat of Epoxy Primer.
- Allow 10-15 minutes to flash.
- Apply 2nd wet coat of Epoxy Primer.
- Allow 30-60 minutes to flash.
- Allow 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

Steel

Pre-Sanded, Shot, or Media Blasted

Note: All primers are listed by VOC content with the lowest VOC primers being first.

! Use proper respirator safety protection during sanding.

! When spraying 6001SP Polyester Primer Surfacer, it is important to refer to the technical sheets for spray tip details. We recommend the use of a 2.0 tip in the spray gun. When activated, mix thoroughly and apply immediately.

White Epoxy Primer:

MAP-LVU100: *RTS 0.42 VOC*

- Clean with 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 6405SP Low VOC Cleaner.
- Apply 1 full wet coat of White Epoxy Primer.
- Allow 5-10 minutes to flash.
- Sand after 24 hours air dry before recoat.
- Allow 30-60 minutes to flash.
- Topcoat per technical data sheet recommendations.

Polyester Primer Surfacer:

6001SP: *RTS 1.8 VOC*

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Mix Polyester Primer Surfacer according to instructions (see text box).
- Apply 1 wet coat of Polyester Primer Surfacer.
- Allow 20 minutes to flash.
- Apply 2nd wet coat of Polyester Primer Surfacer.
- Allow 20 minutes to dry.
- Allow 1.5 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

U-Prime:

274 685SP: *RTS 2.8 VOC*

- Clean substrate with 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 6405SP Low VOC Cleaner.
- Apply 1 wet coat of U-Prime.
- Allow 10-15 minutes to flash.
- Apply 2nd wet coat of U-Prime.
- Allow 10-15 minutes to flash.
- Allow 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

Gray Epoxy Primer:

6007SP: *3.5 VOC*

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 full wet coat.
- Allow 30-60 minutes to flash.
- 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

Steel

Pre-Sanded, Shot, or Media Blasted

Note: All primers are listed by VOC content with the lowest VOC primers being first.

! Use proper respirator safety protection during sanding.

White Epoxy Primer or Black Epoxy Primer:

274 908SP or 274 808SP:

Both are RTS 3.90-3.95 VOC

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 wet coat of Epoxy Primer.
- Allow 10-15 minutes to flash.
- Apply 2nd wet coat of Epoxy Primer.
- Allow 30-60 minutes to flash.
- Allow 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

HBEF Self-Etching Metal Treatment:

74 780SP: *RTS 6.04 VOC*

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 wet coat of HBEF Self-Etching Metal Treatment.
- Allow 3-5 minutes to flash.
- Apply 2nd wet coat of HBEF Self-Etching Metal Treatment.
- Allow 20-30 minutes to flash.
- Topcoat per technical data sheet recommendations.

HBPT Self-Etching Metal Treatment:

74 770SP: *RTS 6.13 VOC*

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 wet coat of HBPT Self-Etching Metal Treatment.
- Allow 5 minutes to flash.
- Apply 2nd wet coat of HBPT Self-Etching Metal Treatment.
- Allow 20-30 minutes to flash.
- Topcoat per technical data sheet recommendations.

PT Filler Self-Etching Primer:

74 760SP: *RTS 6.4 VOC*

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 wet coat of PT Filler.
- Allow 5 minutes to flash.
- Apply 2nd wet coat of PT Filler.
- Allow 20-30 minutes to flash.
- Topcoat per technical data sheet recommendations.

Steel Continued On Next Page...

Steel

Hot Dipped Galvanized, Galvaneal, Galvalume, Bonderized, Phosphate Coated, Passivators or Stabilizers

Note: All primers are listed by VOC content with the lowest VOC primers being first.

! Many galvanized metal manufacturers apply an oil treatment to protect galvanized steel while in storage. This must be removed through cleaning and abrading as necessary. Clean prior to painting.

! Use proper respirator safety protection during sanding.

White Epoxy Primer:

MAP-LVU100: *RTS 0.42 VOC*

- Clean with 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 6405SP Low VOC Cleaner.
- Apply 1 full wet coat of White Epoxy Primer.
- Allow 5-10 minutes to flash.
- Sand after 24 hours air dry before recoat.
- Allow 30-60 minutes to flash.
- Topcoat per technical data sheet recommendations.

Gray Epoxy Primer:

6007SP: *3.5 VOC*

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 full wet coat.
- Allow 30-60 minutes to flash.
- 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

White Epoxy Primer or Black Epoxy Primer:

274 908SP or 274 808SP:

Both are RTS 3.90-3.95 VOC

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 wet coat of Epoxy Primer.
- Allow 10-15 minutes to flash.
- Apply 2nd wet coat of Epoxy Primer.
- Allow 30-60 minutes to flash.
- Allow 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

Steel

Stainless

- We do not recommend coating stainless steel with Matthews.

Powder Coated

Note: All primers are listed by VOC content with the lowest VOC primers being first.

! Use proper respirator safety protection during sanding.

White Epoxy Primer:

MAP-LVU100: *RTS 0.42 VOC*

- Clean with 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 6405SP Low VOC Cleaner.
- Apply 1 full wet coat of White Epoxy Primer.
- Allow 5-10 minutes to flash.
- Sand after 24 hours air dry before recoat.
- Allow 30-60 minutes to flash.
- Topcoat per technical data sheet recommendations.

Gray Epoxy Primer:

6007SP: *3.5 VOC*

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 full wet coat.
- Allow 30-60 minutes to flash.
- 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

White Epoxy Primer or Black Epoxy Primer:

274 908SP or 274 808SP:

Both are RTS 3.90-3.95 VOC

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 wet coat of Epoxy Primer.
- Allow 10-15 minutes to flash.
- Apply 2nd wet coat of Epoxy Primer.
- Allow 30-60 minutes to flash.
- Allow 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

Steel or Aluminum Repairs

next to primed and/or painted surfaces

Note: All primers are listed by VOC content with the lowest VOC primers being first.

! Inspect existing coating for any delaminating or degradation to determine if existing coating should be removed. If so, repair or strip as necessary.

! Use proper respirator safety protection during sanding.

White Epoxy Primer:

MAP-LVU100: *RTS 0.42 VOC*

- Clean with 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 6405SP Low VOC Cleaner.
- Apply 1 full wet coat of White Epoxy Primer.
- Allow 5-10 minutes to flash.
- Sand after 24 hours air dry before recoat.
- Allow 30-60 minutes to flash.
- Topcoat per technical data sheet recommendations.

U-Prime:

274 685SP: *RTS 2.8 or 3.5 VOC*

- Clean substrate with 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 6405SP Low VOC Cleaner.
- Apply 1 wet coat of U-Prime.
- Allow 10-15 minutes to flash.
- Apply 2nd wet coat of U-Prime.
- Allow 10-15 minutes to flash.
- Allow 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

Gray Epoxy Primer:

6007SP: *3.5 VOC*

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 full wet coat.
- Allow 30-60 minutes to flash.
- 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

White Epoxy Primer or Black Epoxy Primer:

274 908SP or 274 808SP:

Both are RTS 3.90-3.95 VOC

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 wet coat of Epoxy Primer.
- Allow 10-15 minutes to flash.
- Apply 2nd wet coat of Epoxy Primer.
- Allow 30-60 minutes to flash.
- Allow 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

Painted Surfaces

Not Matthews Paint (Refurbishing Work)

Note: All primers are listed by VOC content with the lowest VOC primers being first.

! Always test painted surface for compatibility before use of Matthews primers and topcoats.

! Inspect existing coating for any delaminating or degradation to determine if existing coating should be removed. If so, repair or strip as needed.

! Use proper respirator safety protection during sanding.

White Epoxy Primer:

MAP-LVU100: *RTS 0.42 VOC*

- Clean with 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 6405SP Low VOC Cleaner.
- Apply 1 full wet coat of White Epoxy Primer.
- Allow 5-10 minutes to flash.
- Sand after 24 hours air dry before recoat.
- Allow 30-60 minutes to flash.
- Topcoat per technical data sheet recommendations.

Gray Epoxy Primer:

6007SP: *3.5 VOC*

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 full wet coat.
- Allow 30-60 minutes to flash.
- 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

White Epoxy Primer or Black Epoxy Primer:

274 908SP or 274 808SP:

Both are RTS 3.90-3.95 VOC

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 wet coat of Epoxy Primer.
- Allow 10-15 minutes to flash.
- Apply 2nd wet coat of Epoxy Primer.
- Allow 30-60 minutes to flash.
- Allow 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

Acrylic (Acrylite, Crylex, Plexiglas, Lucite, Implex)

> **!** Do not allow Tie Bond to dry between coats or before topcoating. Decrease flash time between coats based on temperature if needed.

> **!** Matthews strongly recommends the use of Tie Bond as an adhesive over acrylics to ensure proper adhesion.

Tie Bond Adhesive:

274 777SP: *RTS 0 VOC*

- Clean with 6428SP Plastic Prep (1st or 2nd surface) or 6405SP Low VOC Cleaner.
- Apply a mist coat of 6428SP Plastic Prep and allow to dry in order to reduce static surface charge.
- Apply 1 wet coat of Tie Bond Adhesive.
- Allow 5-10 minutes to flash.
- Apply 2nd wet coat of Tie Bond Adhesive.
- Allow 5-10 minutes to flash.
- Apply 1 wet coat of Matthews Topcoat.
- Allow 5-10 minutes to flash.
- Apply 2nd wet coat of Matthews Topcoat.

Tie Bond Adhesive:

74 777SP: *RTS 6.4 - 6.6 VOC*

- Clean with 6428SP Plastic Prep.
- Can use 6428SP Plastic Prep as an anti-static application (after surface has been cleaned) by applying a light mist coat over entire surface area and allowing product to evaporate.
- Apply 2 coats of Tie Bond Adhesive.
- Allow 5-10 minutes to flash.
- Topcoat per technical data sheet recommendations.

Body Filler

Filled Areas Only

Note: All primers are listed by VOC content with the lowest VOC primers being first.

! Use proper respirator safety protection during sanding.

! When spraying 6001SP Polyester Primer Surfacer, it is important to refer to the technical sheets for spray tip details. We recommend the use of a 2.0 tip in the spray gun. When activated, mix thoroughly and apply immediately.

On repaired bare metal area:

- Sand or scuff painted areas around and including Body Filler.
- Clean again with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.

Cleaner should never come in contact with Body Filler.

Immediately prime with Polyester Primer Surfacer or U-Prime. Block sand with 220-320 grit.

White Epoxy Primer:

MAP-LVU100: *RTS 0.42 VOC*

- Clean with 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 6405SP Low VOC Cleaner.
- Apply 1 full wet coat of White Epoxy Primer.
- Allow 5-10 minutes to flash.
- Sand after 24 hours air dry before recoat.
- Allow 30-60 minutes to flash.
- Topcoat per technical data sheet recommendations.

Polyester Primer Surfacer:

6001SP: *RTS 1.8 VOC*

- Clean with 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 6405SP Low VOC Cleaner.
- Mix Polyester Primer according to instructions (see text box).
- Apply 1 wet coat of Polyester Primer Surfacer.
- Allow 20 minutes to flash.
- Apply 2nd wet coat of Polyester Primer Surfacer.
- Allow 20 minutes to flash.
- Apply 3rd coat to cover porosity, if necessary.
- Allow longer flash times between 3rd coats.
- Allow 20-30 minutes to flash.
- Allow 1.5 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

U-Prime:

274 685SP: *RTS 2.8 or 3.5 VOC*

- Clean substrate with 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 6405SP Low VOC Cleaner.
- Apply 1 wet coat of U-Prime.
- Allow 10-15 minutes to flash.
- Apply 2nd wet coat of U-Prime.
- Allow 10-15 minutes to flash.
- Allow 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

Body Filler Continued On Next Page...

Body Filler

Filled Areas Only

Note: All primers are listed by VOC content with the lowest VOC primers being first.

! Use proper respirator safety protection during sanding.

Gray Epoxy Primer:

6007SP: *3.5 VOC*

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 full wet coat.
- Allow 30-60 minutes to flash.
- 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

White Epoxy Primer or Black Epoxy Primer:

274 908SP or 274 808SP:

Both are RTS 3.90-3.95 VOC

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 wet coat of Epoxy Primer.
- Allow 10-15 minutes to flash.
- Apply 2nd wet coat of Epoxy Primer.
- Allow 30-60 minutes to flash.
- Allow 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

PVC

Expanded & Non Expanded
(Komatex, Sintra, Celtec, Intacel, EX-Cel, & Trovicel)

Note: All primers are listed by VOC content with the lowest VOC primers being first.

! 6405SP Cleaner can be used as a cleaner in VOC regulated areas but will **not** provide the same anti-static properties of the non-compliant 6428SP Plastic Prep.

Tie Bond Adhesive:

274 777SP: *RTS 0 VOC*

- Clean with 6428SP Plastic Prep.
- Can use 6428SP Plastic Prep as an anti-static application, once surface has been cleaned, by applying a light mist coat over entire surface area and allow product to evaporate.
- Prime with 1 medium wet coat of Tie Bond Adhesive.
- Allow 10-15 minutes to flash.
- Apply 2nd medium coat of Tie Bond Adhesive.
- Allow 10-15 minutes to flash.
- Topcoat per technical data sheet recommendations.

Side Fill Technique, if desired:

- Apply 1 wet coat of 274 777SP Tie Bond Adhesive.
- Apply 1-3 coats of 6001SP Polyester Primer Surfacer on rough side sections.
- Allow 1.5 hours to dry.
- Sand to desired smoothness.
- Clean sides and face with 6428SP Plastic Prep.
- Topcoat per technical data sheet recommendations.

Tie Bond Adhesive:

74 777SP: *RTS 6.4 - 6.6 VOC*

- Clean with 6428SP Plastic Prep.
- Can use 6428SP Plastic Prep as an anti-static application (after surface has been cleaned) by applying a light mist coat over entire surface area and allowing product to evaporate.
- Apply 2 coats of Tie Bond Adhesive.
- Allow 5-10 minutes to flash.
- Topcoat per technical data sheet recommendations.

Photopolymer (Nova)

Novacryl:
PT, ECR, LP, YA,
EX, Permaglow

> ! When applying paint to sub or 2nd surface clear Novacryl, you must clearcoat the first surface to protect the photopolymer. Follow cleaning procedures.

- Clean with 6428SP Plastic Prep or 6405SP Low VOC Cleaner.
- Can use 6428SP Plastic Prep as an anti-static agent by applying a mist coat and allowing to dry.

Topcoat Direct:

- Apply 1 medium wet topcoat.
- Allow 10-15 minutes to flash.
- Apply 2nd medium wet topcoat.

Photopolymer Jet

- Clean with 6428SP Plastic Prep or 6405SP Low VOC Cleaner.
- Can use 6428SP Plastic Prep as an anti-static agent by applying a mist coat and allowing to dry.

Tie Bond Adhesive:

274 777SP: *RTS 0 VOC*

- Prime with 1 medium wet coat of Tie Bond Adhesive.
- Allow 10-15 minutes to flash.
- Apply 2nd medium wet coat of Tie Bond Adhesive.
- Allow 10-15 minutes to flash.
- Apply 1-2 medium coats of 6010SP Flex Sealer, if required.
- Allow 30 minutes to flash between coats.
- Topcoat per technical data sheet recommendations.

Tie Bond Adhesive:

74 777SP: *RTS 6.4 - 6.6 VOC*

- Clean with 6428SP Plastic Prep.
- Can use 6428SP Plastic Prep as an anti-static application (after surface has been cleaned) by applying a light mist coat over entire surface area and allowing product to evaporate.
- Apply 2 coats of Tie Bond Adhesive.
- Allow 5-10 minutes to flash.
- Topcoat per technical data sheet recommendations.

Copolyesters, PETG and Mustang (Plaskolite)

- We do not recommend coating copolyesters and PETG substrates with Matthews.

Polycarbonate (Lexan)

Polycarbonate manufacturers recommend that all moisture be heat-purged out of substrate before coating application. Use of any MPC primer, adhesive, or topcoat will alter this substrate's impact strength.

Tie Bond Adhesive:

274 777SP: *RTS 0 VOC*

- Clean with 6428SP Plastic Prep or 6405SP.
- Can use 6428SP Plastic Prep as an anti-static application, once surface has been cleaned by applying a mist coat over entire surface area and allow product to evaporate.
- Apply 1 medium wet coat of Tie Bond Adhesive.
- Allow 10-15 minutes to flash.
- Apply 2nd medium coat of Tie Bond Adhesive.
- Allow 10-15 minutes to flash.
- Topcoat per technical data sheet recommendations.

-OR -

- Apply 1 light coat of MAP topcoat properly mixed with 287 103SP or Slow Converter (makes basecoat).
- Allow 10-15 minutes to flash.
- Apply 1 wet coat of unconverted MAP topcoat.
- Allow 10-15 minutes to flash.
- Apply 2nd wet coat of unconverted MAP topcoat.

Tie Bond Adhesive:

74 777SP: *RTS 6.4 - 6.6 VOC*

- Clean with 6428SP Plastic Prep.
- Can use 6428SP Plastic Prep as an anti-static application (after surface has been cleaned) by applying a light mist coat over entire surface area and allowing product to evaporate.
- Apply 2 coats of Tie Bond Adhesive.
- Allow 5-10 minutes to flash.
- Topcoat per technical data sheet recommendations.

Vinyl (3M, Avery, MACtac, Oracal, FDC, & Ultramark)

Flex Additive is not required when applying Matthews Topcoat to completed pre-applied vinyl.

Use proper respirator safety protection during sanding.

- Clean with 6428SP Plastic Prep or 6405SP Low VOC Cleaner.
- Scuff surface with Scotch-Brite pad.
- Clean again with 6428SP Plastic Prep.
- Apply 1 wet coat of MAP topcoat mixed properly with 47 474SP Flex Additive.
- Allow 10-15 minute to flash.
- Apply 2nd wet coat of MAP topcoat mixed properly with 47 474SP Flex Additive.

Trim Cap (Jewelite, Silvatrim)

Flex Additive is not required when applying Matthews Topcoat to completed pre-applied vinyl.

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Abrade with Scotch-Brite pad.
- Clean again with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 wet coat of MAP topcoat mixed properly with 47 474SP Flex Additive.
- Allow 10-15 minute to flash.
- Apply 2nd wet coat of MAP topcoat mixed properly with 47 474SP Flex Additive.

EPS-Polystyrene (Gator Foam)

Pittsburgh Paint's 17-21 Seal Grip Acrylic Latex Primer (water based) works well in this application. Allow at least 60 minutes after application for topcoating.

- Clean substrate with clean compressed air.
- Apply latex exterior primer in order to fill and seal the entire foam surface areas. Allow to dry.
- Scuff surface with Scotch-Brite pad.
- Clean again with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Topcoat per technical data sheet recommendations.

Flexible Face (Cooley)

- Clean with 6428SP Plastic Prep or 6405SP Low VOC Cleaner.
- Verify that all surface areas are thoroughly cleaned.
- Repeat cleaning process if necessary.
- Apply 1 wet coat of MAP topcoat mixed properly with 47 474SP Flex Additive.
- Allow 10-15 minutes to flash.
- Apply 2nd wet coat of MAP topcoat mixed properly with 47 474SP Flex Additive.

Polypropylene or Polyethylene

Extremely difficult to paint even when flame or corona treatment process is used.

- Requires Flame or Corona treatment in order to alter the surface molecular structure, which allows a limited time period for the substrate to be paint receptive. All propylene and ethylene structures are different, so test for adhesion.
- Clean with 6428SP Plastic Prep.
- Topcoat per technical data sheet recommendations.

Glass & Porcelain

- We do not recommend coating glass or porcelain with Matthews.

Wood

Applying Color

Note: All primers are listed by VOC content with the lowest VOC primers being first.

! Test for the moisture content of the wood before any application. Moisture content must be less than 13%. Certain applications using exterior wood as a substrate will expand and/or contract too much for Matthews to be used. All surface areas of the wood must be coated.

! Use proper respirator safety protection during sanding.

- Abrade as necessary, finishing sanding with the finest grit possible.
- Remove dust with clean compressed air and tack rag.
- Spot prime over knots, cut areas, or ends with 274 908SP White Epoxy Primer or 274 808SP Black Epoxy Primer.
- Allow to dry 30-60 minutes.
- Topcoat per technical data sheet recommendations.

White Epoxy Primer:

MAP-LVU100: *RTS 0.42 VOC*

- Remove dust with clean compressed air and tack rag.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Remove dust with clean compressed air and tack rag.
- Apply 1 full wet coat of White Epoxy Primer.
- Allow 5-10 minutes to flash.
- Sand after 24 hours of air dry before recoat.
- Allow 30-60 minutes to flash.
- Topcoat per technical data sheet recommendations.

Polyester Primer Surfacer:

6001SP: *RTS 1.8 VOC*

- Remove dust with clean compressed air and tack rag.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Remove dust with clean compressed air and tack rag.
- Mix Polyester Primer Surfacer according to instructions (see text box).
- Apply 1 wet coat of Polyester Primer Surfacer.
- Allow 20 minutes to flash.
- Apply 2nd wet coat of Polyester Primer Surfacer.
- Allow 20 minutes to flash.
- Apply 3rd coat to cover porosity, if necessary.
- Allow longer flash times between 3rd coats.
- Allow 20-30 minutes to flash.
- Allow 1.5 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

Wood Continued On Next Page...

Note: All primers are listed by VOC content with the lowest VOC primers being first.

! Use proper respirator safety protection during sanding.

U-Prime:

274 685SP: *RTS 2.8 or 3.5 VOC*

- Remove dust with clean compressed air and tack rag.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Remove dust with clean compressed air and tack rag.
- Apply 1 wet coat of U-Prime.
- Allow 10-15 minutes to flash.
- Apply 2nd wet coat of U-Prime.
- Allow 10-15 minutes to flash.
- Allow 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

Gray Epoxy Primer:

6007SP: *3.5 VOC*

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 full wet coat.
- Allow 30-60 minutes to flash.
- 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

White Epoxy Primer or Black Epoxy Primer:

274 908SP or 274 808SP:

Both are RTS 3.90-3.95 VOC

- Remove dust with clean compressed air and tack rag.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Remove dust with clean compressed air and tack rag.
- Apply 1 wet coat of Epoxy Primer.
- Allow 10-15 minutes to flash.
- Apply 2nd wet coat of Epoxy Primer.
- Allow 30-60 minutes to flash.
- Allow 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

MDO, MDF, and Extira

Ensure that moisture content of the substrate is less than 13%.

When spraying 6001SP Polyester Primer Surfacer, it is important to refer to the technical sheets for spray tip details. We recommend the use of a 2.0 tip in the spray gun. When activated, mix thoroughly and apply immediately.

Use proper respirator safety protection during sanding.

White Epoxy Primer:

MAP-LVU100: *RTS 0.42 VOC*

- Clean with 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 6405SP Low VOC Cleaner.
- Apply 1 full wet coat of White Epoxy Primer.
- Allow 5-10 minutes to flash.
- Sand after 24 hours of air dry before recoat.
- Allow 30-60 minutes to flash.
- Topcoat per technical data sheet recommendations.

Polyester Primer Surfacer:

6001SP: *RTS 1.8 VOC*

- Remove dust with clean compressed air and tack rag.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Remove dust with clean compressed air and tack rag.
- Clean with 6405SP Low VOC Cleaner.
- Apply 1 wet coat of Polyester Primer Surfacer.
- Allow 20 minutes to flash.
- Apply 2nd wet coat of Polyester Primer Surfacer.
- Allow 20 minutes to flash.
- Apply 3rd coat to cover porosity, if necessary.
- Allow 1.5 hours dry time before sanding, cleaning, and topcoating.

U-Prime:

274 685SP: *RTS 2.8 or 3.5 VOC*

- Clean substrate with 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 6405SP Low VOC Cleaner.
- Apply 1 wet coat of U-Prime.
- Allow 10-15 minutes to flash.
- Apply 2nd wet coat of U-Prime.
- Allow 10-15 minutes to flash.
- Allow 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

Gray Epoxy Primer:

6007SP: *3.5 VOC*

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 full wet coat.
- Allow 30-60 minutes to flash.
- 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

MDO, MDF, and Extira Continued On Next Page...

MDO, MDF, and Extira

Note: All primers are listed by VOC content with the lowest VOC primers being first.

! Use proper respirator safety protection during sanding.

White Epoxy Primer or Black Epoxy Primer:

274 908SP or 274 808SP: *Both are RTS 3.90-3.95 VOC*

- Remove dust with clean compressed air and tack rag.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Remove dust with clean compressed air and tack rag.
- Clean with 6428SP Speed Prep or 6405SP Low VOC Cleaner.
- Apply 1 wet coat of Epoxy Primer.
- Allow 5-15 minutes to flash.
- Apply 2nd wet coat of Epoxy Primer.
- Allow 30-60 minutes to flash.
- Allow 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.
- All surfaces must be sealed.
- Check adhesion.

Scooter Board

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Scuff surface with Scotch-Brite pad.
- Clean again with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Prime with one medium wet coat 274 777SP Tie Bond Adhesive.
- Allow 5-10 minutes to flash.
- Topcoat per technical data sheet recommendations.

HDU or Polyurethane Foam Board

Poly Board, Sign Foam, Precision Board, Jasper Board, Corafoam®/Dunaboard

Note: All primers are listed by VOC content with the lowest VOC primers being first.

! When spraying 6001SP Polyester Primer Surfacer, it is important to refer to the technical sheets for spray tip details. We recommend the use of a 2.0 tip in the spray gun. When activated, mix thoroughly and apply immediately.

! Use proper respirator safety protection during sanding.

Polyester Primer Surfacer:

6001SP: *RTS 1.8 VOC*

- Clean substrate with clean compressed air.
- Mix Polyester Primer Surfacer according to instructions.
- Apply 1 wet coat of Polyester Primer Surfacer.
- Allow 20 minutes to flash.
- Apply 2nd wet coat of Polyester Primer Surfacer.
- Allow 20 minutes to flash.
- Apply 3rd coat to cover porosity, if necessary.
- Allow longer flash times between 3rd and 4th coats.
- Allow 1.5 hours or more dry time before sanding, cleaning, and topcoating.

U-Prime:

274 685SP: *RTS 2.8 VOC*

- Clean substrate with clean compressed air.
- Apply 1 wet coat of U-Prime.
- Allow 10-15 minutes to flash.
- Apply 2nd wet coat of U-Prime.
- Allow 10-15 minutes to flash.
- Apply 3rd coat, if necessary.
- Allow 24 hours dry time before sanding, cleaning, and topcoating.

Fiberglass–Gel Coated

! All contaminants must be removed.

- Inspect Gel Coat to ensure proper coverage of all pre-painted surfaces.
- Clean with 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean with 6405SP Low VOC Cleaner.
- Topcoat per technical data sheet recommendations.

Fiberglass Continued On Next Page...

Fiberglass – Non Gel Coated

Note: All primers are listed by VOC content with the lowest VOC primers being first.

! All contaminants must be removed.

! When spraying 6001SP Polyester Primer Surfacer, it is important to refer to the technical sheets for spray tip details. We recommend the use of a 2.0 tip in the spray gun. When activated, mix thoroughly and apply immediately.

! Use proper respirator safety protection during sanding.

Polyester Primer Surfacer:

6001SP: *RTS 1.8 VOC*

- Clean substrate with clean compressed air.
- Apply 1 wet coat of Polyester Primer Surfacer.
- Allow 20 minutes to flash.
- Apply 2nd wet coat of Polyester Primer Surfacer.
- Allow 20 minutes to flash.
- Apply 3rd coat to cover porosity, if necessary.
- Allow longer flash times between 3rd and 4th coats.
- Allow 1.5 hours dry time before sanding, cleaning, and topcoating.

U-Prime:

274 685SP: *RTS 2.8 or 3.5 VOC*

- Clean substrate with clean compressed air.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 6405SP Low VOC Cleaner.
- Apply 1 wet coat of U-Prime.
- Allow 10-15 minutes to flash.
- Apply 2nd wet coat of U-Prime.
- Allow 10-15 minutes to flash.
- Allow 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

Gray Epoxy Primer:

6007SP: *3.5 VOC*

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 full wet coat.
- Allow 30-60 minutes to flash.
- 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

White Epoxy Primer or Black Epoxy Primer:

274 908SP or 274 808SP: *Both are RTS 3.90-3.95 VOC*

- Clean substrate with clean compressed air.
- Apply 1 wet coat of Epoxy Primer.
- Allow 10-15 minutes to flash.
- Apply 2nd wet coat of Epoxy Primer.
- Allow 30-60 minutes to flash.
- Apply the necessary number of coats to fill the imperfections.
- Extend flash times between each application of epoxy when adding more than two coats to fill fiberglass.
- Allow 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

Limestone

Note: All primers are listed by VOC content with the lowest VOC primers being first.

Use proper respirator safety protection during sanding.

White Epoxy Primer:

MAP-LVU100: *RTS 0.42 VOC*

- Clean with 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 6405SP Low VOC Cleaner.
- Apply 1 full wet coat of White Epoxy Primer.
- Allow 5-10 minutes to flash.
- Can recoat after 2 hours by spray or after 8 hours by roll.
- Sand after 24 hours of air dry before recoat.
- Topcoat per technical data sheet recommendations.

E-Prime:

274 228SP or 274 229SP: *RTS 2.8 VOC*

- Clean with 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 6405SP Low VOC Cleaner.
- Apply 1 full wet coat of E-Prime.
- Allow 10-15 minutes to flash.
- Apply 2nd wet coat of E-Prime.
- Topcoat per technical data sheet recommendations.

Gray Epoxy Primer:

6007SP: *3.5 VOC*

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 full wet coat.
- Allow 30-60 minutes to flash.
- 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

White Epoxy Primer or Black Epoxy Primer:

274 908SP or 274 808SP: *Both are RTS 3.90-3.95 VOC*

- Clean substrate with compressed air.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 6405SP Low VOC Cleaner.
- Apply 1 wet coat of Epoxy Primer.
- Allow 10-15 minutes to flash.
- Apply 2nd wet coat of Epoxy Primer.
- Allow 30-60 minutes to flash.
- Allow 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

Granite Polished or Smooth

Note: All primers are listed by VOC content with the lowest VOC primers being first.

! Use proper respirator safety protection during sanding.

White Epoxy Primer:

MAP-LVU100: *RTS 0.42 VOC*

- Clean with 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 6405SP Low VOC Cleaner.
- Apply 1 full wet coat of White Epoxy Primer.
- Allow 5-10 minutes to flash.
- Sand after 24 hours of air dry before recoat.
- Allow 30-60 minutes to flash.
- Topcoat per technical data sheet recommendations.

E-Prime:

274 228SP or 274 229SP: *RTS 2.8 VOC*

- Clean with 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 6405SP Low VOC Cleaner.
- Apply 1 full wet coat of E-Prime.
- Allow 10-15 minutes to flash.
- Apply 2nd wet coat of E-Prime.
- Allow 30-60 minutes to flash.
- Topcoat per technical data sheet recommendations.

Gray Epoxy Primer:

6007SP: *3.5 VOC*

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 full wet coat.
- Allow 30-60 minutes to flash.
- 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

White Epoxy Primer or Black Epoxy Primer:

274 908SP or 274 808SP: *Both are RTS 3.90-3.95 VOC*

- Clean with 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 6405SP Low VOC Cleaner.
- Apply 1 wet coat of Epoxy Primer.
- Allow 10-15 minutes to flash.
- Apply 2nd wet coat of Epoxy Primer.
- Allow 30-60 minutes to flash.
- Allow 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

Granite Sandblasted

- Clean substrate with compressed air.
- Brush away any loose debris.
- Clean again with compressed air.
- Topcoat per technical data sheet recommendations.

Cement Previously Coated Masonry, Concrete or Concrete Block

Note: All primers are listed by VOC content with the lowest VOC primers being first.

! Use proper respirator safety protection during sanding.

Gray Epoxy Primer:

6007SP: *3.5 VOC*

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 full wet coat.
- Allow 30-60 minutes to flash.
- 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

White Epoxy Primer or Black Epoxy Primer:

274 908SP or 274 808SP: *RTS 3.90-3.95 VOC*

- Inspect coating to ensure a sound and secure finish.
- Sandblast away any loose coating from surface or clean with 5% Muriatic acid and water solution. (Use recommended safety instructions from Muriatic acid manufacturer!)
- Remove debris with compressed air.
- Rinse well with water and allow to dry.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean with water and allow to dry completely.
- Apply 1 wet coat of Epoxy Primer.
- Allow 10-15 minutes to flash.
- Apply 2nd wet coat of Epoxy Primer.
- Allow 30-60 minutes to flash.
- Allow 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

Cement Continued On Next Page...

Cement

Masonry, Concrete, Concrete Block, Dryvit, Stucco, and Texcote

Note: All primers are listed by VOC content with the lowest VOC primers being first.

Failure to ensure that moisture and PH levels are within recommended limits will result in apparent or eventual **coating failure.**

Pay careful attention to these instructions, as they are very important to follow properly.

Test moisture level of substrate. Requires less than 13%.

Use proper respirator safety protection during sanding.

- Pressure-clean entire surface with 2000 PSI at 3-5 GPM (Gallons Per Minute).
- PH test level of substrate. Proper PH level must be less than 10 and higher than 5, neutral is 7 and preferred. (PH test pencils can be purchased at http://www.cole-palmer.com)

White Epoxy Primer:

MAP-LVU100: *RTS 0.42 VOC*

- Sandblast away any loose coating from surface or clean with 5% Muriatic acid and water solution (Use recommended safety instructions from Muriatic acid manufacturer!)
- Clean with 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 6405SP Low VOC Cleaner.
- Apply 1 full wet coat of White Epoxy Primer.
- Allow 5-10 minutes to flash.
- Sand after 24 hours of air dry before recoat.
- Allow 30-60 minutes to flash.
- Topcoat per technical data sheet recommendations.

E-Prime:

274 228SP or 274 229SP: *RTS 2.8 VOC*

- Sandblast away any loose coating from surface or clean with 5% Muriatic acid and water solution (Use recommended safety instructions from Muriatic acid manufacturer!)
- Clean with 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 6405SP Low VOC Cleaner.
- Apply 1 full wet coat of E-Prime.
- Allow 10-15 minutes to flash.
- Apply 2nd wet coat of E-Prime.
- Allow 30-60 minutes to flash.
- Topcoat per technical data sheet recommendations.

Gray Epoxy Primer:

6007SP: *3.5 VOC*

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 full wet coat.
- Allow 30-60 minutes to flash.
- 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

White Epoxy Primer or Black Epoxy Primer:

274 908SP or 274 808SP: *Both are RTS 3.90-3.95 VOC*

- Sandblast away any loose coating from surface or clean with 5% Muriatic acid and water solution (Use recommended safety instructions from Muriatic acid manufacturer!)
- Rinse well with water.
- Allow to dry completely.
- Apply 1 wet coat of Epoxy Primer.
- Allow 10-15 minutes to flash.
- Apply 2nd wet coat of Epoxy Primer.
- Allow 30-60 minutes to flash.
- Allow 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

Drywall

Note: All primers are listed by VOC content with the lowest VOC primers being first.

! Use proper respirator safety protection during sanding.

White Epoxy Primer:

MAP-LVU100: *RTS 0.42 VOC*

- Wipe surface with tack cloth.
- Apply 1 full wet coat of White Epoxy Primer.
- Allow 5-10 minutes to flash.
- Can recoat after 2 hours by spray or after 8 hours by roll.
- Sand after 24 hours of air dry before recoat.
- Topcoat per technical data sheet recommendations.

E-Prime:

274 228SP or 274 229SP: *RTS 2.8 VOC*

- Wipe surface with tack cloth.
- Apply 1 full wet coat of E-Prime.
- Allow 10-15 minutes to flash.
- Apply 2nd wet coat of E-Prime.
- Topcoat per technical data sheet recommendations.

U-Prime:

274 685SP: *RTS 2.8 or 3.5 VOC*

- Wipe surface with tack cloth.
- Apply 1 wet coat of U-Prime.
- Allow 10-15 minutes to flash.
- Apply 2nd wet coat of U-Prime.
- Allow 10-15 minutes to flash.
- Allow 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

Gray Epoxy Primer:

6007SP: *3.5 VOC*

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 full wet coat.
- Allow 30-60 minutes to flash.
- 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

White Epoxy Primer or Black Epoxy Primer:

274 908SP or 274 808SP: *Both are RTS 3.90-3.95 VOC*

- Wipe surface with tack cloth.
- Apply 1 medium coat of Epoxy Primer.
- Allow 30 minutes to flash.
- Apply 2nd wet coat of Epoxy Primer.
- Allow to dry overnight.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Allow 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

Clearcoat Preparation Recommendations

Substrate guidelines are recommendations only.

Matthews Topcoat (Color)

Applying clearcoat just after applying any Matthews color.

> **!** Use proper respirator safety protection during sanding.

- Allow topcoat 15 minutes to flash.
- Apply 1 wet coat of Matthews Clear.
- Allow 5-10 minutes to flash.
- Apply 2nd wet coat of Matthews Clear.

After 24 hours

- Clean with 6405SP Low VOC Cleaner.
- Abrade as necessary, finishing sanding with the finest grit possible.
- Clean again with 6405SP Low VOC Cleaner.
- Apply 1 wet coat of Matthews Clear.
- Allow 5-10 minutes to flash.
- Apply 2nd wet coat of Matthews Clear.

Aluminum

> **!** Do not allow Spray Bond to dry before clearcoating.

> **!** Chamfer or knock down all sharp edges.

Spray Bond Adhesive:

274 793SP: *RTS 0 VOC*

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 wet coat of Spray Bond Adhesive.
- Allow 5-10 minutes to flash.
- Apply 2nd wet coat of Spray Bond Adhesive.
- Allow 5-10 minutes to flash.
- Apply 1 wet coat of Matthews Clear.
- Allow 5-10 minutes to flash.
- Apply 2nd wet coat of Matthews Clear.

Acrylic

Tie Bond Adhesive:

274 777SP: *RTS 0 VOC*

- Clean with 6428SP Plastic Prep. (1st or 2nd surface)
- Apply a mist coat of 6428SP Plastic Prep and allow to dry in order to reduce static surface charge.
- Apply 1 wet coat of Tie Bond Adhesive.
- Allow 5-10 minutes to flash.
- Apply 2nd wet coat of Tie Bond Adhesive.
- Allow 5-10 minutes to flash.
- Apply 1 wet coat of Matthews Clear.
- Allow 5-10 minutes to flash.
- Apply 2nd wet coat of Matthews Clear.

Acrylic Continued On Next Page...

Acrylic

Tie Bond Adhesive:

74 777SP: *RTS 6.4 - 6.6 VOC*

- Clean with 6428SP Plastic Prep.
- Can use 6428SP Plastic Prep as an anti-static application (after surface has been cleaned) by applying a light mist coat over entire surface area and allowing product to evaporate.
- Apply 2 coats of Tie Bond Adhesive.
- Allow 5-10 minutes to flash.
- Topcoat per technical data sheet recommendations.

Polycarbonate

! Some Polycarbonate substrates can be too solvent-sensitive for use of the preferred Tie Bond Adhesive. The application of a "converted" coat as a primer may provide the adhesion required and not adversely affect the substrate. Polycarbonate manufacturers recommend that all moisture be heat-purged out of substrate before any coating application. Use of any MPC primer or topcoat may alter the substrate's impact strength.

Tie Bond Adhesive:

274 777SP: *RTS 0 VOC*

- Clean with 6428SP Plastic Prep. (1st or 2nd surface)
- Apply a mist coat of 6428SP Plastic Prep to reduce static surface charge.
- Apply 1 medium wet coat of Tie Bond Adhesive.
- Allow 10-15 minutes to flash.
- Apply 2nd medium coat of Tie Bond Adhesive.
- Allow 10-15 minutes to flash.
- Apply 1 wet coat of Matthews Clear.
- Allow 5-10 minutes to flash.
- Apply 2nd wet coat of Matthews Clear.

Optional Converted Basecoat Application:

- Clean with 6428SP Plastic Prep. (1st or 2nd surface)
- Apply a mist coat of 6428SP Plastic Prep to reduce static surface charge.
- Apply 1 medium coat of Matthews Clear mixed with 287 103SP Basecoat Converter.
- Allow 10-15 minutes to flash.
- Apply 1 wet coat of Matthews Clear.

Tie Bond Adhesive:

74 777SP: *RTS 6.4 - 6.6 VOC*

- Clean with 6428SP Plastic Prep.
- Can use 6428SP Plastic Prep as an anti-static application (after surface has been cleaned) by applying a light mist coat over entire surface area and allowing product to evaporate.
- Apply 2 coats of Tie Bond Adhesive.
- Allow 5-10 minutes to flash.
- Topcoat per technical data sheet recommendations.

Vinyl (3M, Avery, MACtac, Ultramark)

Flex Additive is not required when applying Matthews Topcoat to completed pre-applied vinyl.

- Clean with 6428SP Plastic Prep or 6405SP Low VOC Cleaner.
- Apply 1 wet coat of Matthews Clear mixed with 47 474SP Flex Additive.
- Allow 5-10 minutes to flash.
- Apply 2nd wet coat of Matthews Clear.

Trim Cap (Jewelite, Silvertrim)

Flex Additive is not required when applying Matthews Topcoat to completed pre-applied vinyl.

- Clean with 6428SP Plastic Prep.
- Scuff surface with Scotch-Brite pad.
- Clean again with 6428SP Plastic Prep.
- Apply 1 wet coat of Matthews Clear mixed with 47 474SP Flex Additive for conventional Matthews.
- Allow 5-10 minutes to flash.
- Apply 2nd wet coat of Matthews Clear.

Brass, Copper, or Cast Bronze

Substrate must be completely cleaned to ensure all contaminants have been removed.

Attempt to knock down any sharp edges if possible.

Spray Bond Adhesive:

274 793SP: *RTS 0 VOC*

- Clean substrate to remove oils, contaminants, oxidation, and watermarks.
- Clean surface with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 wet coat of Spray Bond Adhesive.
- Allow 5-10 minutes to flash.
- Apply 2nd wet coat of Spray Bond Adhesive.
- Allow 5-10 minutes to flash.
- Apply 1 wet coat of Matthews Clear or Braco Clear.
- Allow 5-10 minutes to flash.
- Apply 2nd wet coat of Matthews Clear.

Luminore

Hotter temperatures may cause the Spray Bond to set up faster than the process recommends. Topcoat may need to be applied using shorter flash times of the adhesive.

Use proper respirator safety protection during sanding.

Spray Bond Adhesive:

274 793SP: *RTS 0 VOC*

- Clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner.
- Apply 1 wet coat of Spray Bond Adhesive.
- Do not allow Spray Bond Adhesive to dry before clearcoating.
- Allow 5-10 minutes to flash.
- Apply 2nd wet coat of Spray Bond Adhesive.
- Allow 5-10 minutes to flash.
- Apply 1 wet coat of Matthews Clear.
- Allow 5-10 minutes to flash.
- Apply 2nd wet coat of Matthews Clear.

Wood

Test for the moisture content of the wood before any application. Moisture content must be less than 13%. Certain applications using exterior wood as a substrate will expand and/or contract too much for Matthews to be used. All surface areas of the wood must be coated.

- Abrade as necessary, finishing sanding with the finest grit possible.
- Remove dust with clean compressed air and tack cloth.
- Apply 1 wet coat of Matthews Clear.
- Allow 5-10 minutes to flash.
- Apply 2nd wet coat of Matthews Clear.

Notes

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