



2.1 VOC Epoxy Primers

MPC208

274 528SP/Gray

274 530SP/White

274 531SP/Black 274 529SP

Matthews Epoxy Primers are corrosion resistant primers that provide excellent adhesion to many types of substrates and can also be used in areas where a maximum 2.1 VOC is required.



Features

- Universal
- 4:1 Easy Mix Ratio

Benefits

- Can be used over many substrates
- Can be used in areas where a maximum 2.1 VOC is required

Compatible Surfaces

May be applied over:

- Properly cleaned and sanded steel / stainless steel
- Properly cleaned and sanded blasted steel
- Properly cleaned and sanded carbon steel
- Properly cleaned and sanded galvanized steel
- Properly cleaned and sanded aluminum
- Properly cleaned and sanded fiberglass
- Previously painted surfaces with proper prep
- MAP Ultra Low VOC Satin or Gloss
- MAP®
- SATIN MAP®
- SVOC MAP®
- VOC MAP®
- Body Fillers
- Masonry
- Wood

Required Products

Catalyst

274 529SP 2.1 VOC Epoxy Hardener

Surface Preparation



- Wipe/clean substrate using 45 330SP Speed Prep Cleaner if permitted under VOC guidelines or 6405SP Low VOC Cleaner (refer to MPC111 Technical Bulletin).



- Sand the bare metal areas completely with 180 - 220 grit abrasive.
- Re-clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner. Final wipe with a clean tack cloth to remove any residue.



- Surfaces must be dry before application of primer. Then apply primer.

Mix Ratios (by volume)



Mix Ratios (by volume)

2.1 VOC

274 528SP
Epoxy Primer

274529SP
Epoxy Hardener

4 parts

1 part



- Hardener and epoxy primer should be mixed thoroughly before using.
- Strain material following mixing.



- The usable pot life is approximately 4 hours at 70°F (21°C).

Additives



None

Spray Set Up



Air Pressure:	Conventional:	35 psi at the gun
	HVLP:	10 psi at cap
	Pot Pressure:	15 - 18 psi
Gun Set Up:	Siphon Feed:	1.3 - 1.5 mm
	HVLP:	1.3 - 1.5 mm
	Pressure Pot:	1.2 mm 0.046 fluid tip

Application



Apply:	1 full wet coat
	Flash 10 - 15 min. between coats
	Follow with a second full wet coat
Recommended	
Wet Film Thickness:	2.3 - 6.8 mils/coat
Recommended	
Dry Film Thickness:	1.0 - 3.0 mils

Caution: All 2 component cross-linking stops or slows significantly at temperatures below 60°F or 16°C. Never spray or subject freshly painted coatings to these conditions or poor water and chemical resistance, decreased durability and improper curing will occur.

Drying Times



Dry Times at 70°F (21°C)

Dust Free	15 - 20 minutes
Dry to Touch	20 - 30 minutes
Dry to Handle	30 - 45 minutes
Dry to Topcoat	30 - 45 minutes

Note: After 4 days, sand with a 400 grit (wet or dry) before proceeding to the next undercoat or topcoat. Do not sand to below minimum dry film thickness over bare metal.

Equipment Cleaning

Clean equipment promptly with an all-purpose clean up solvent or any compliant general cleaner.
Do not leave mixed material in equipment.

Technical Data

2.1 VOC

274 528SP Epoxy Primer	0.98
274 529SP Epoxy Hardener	2.43
Ready to Spray (4:1)	1.27

Performance Characteristics

Volume Solids (Packaged)	40.7%
Volume Solids RTS	44.14%
Theoretical Coverage (1.0 mils @ 100% transfer efficiency)	707 sq.ft. @ 1 mil dry
Application Conditions 100°F (38°C) Max.	55°F (13°C) Min.
Relative Humidity 5° above dew point	85% Max.
Flash Point (<i>Tag closed cup</i>)	68°F (20°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

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.



Matthews Paint • Toll Free: 800.323.6593 • Fax: 800.947.0377
www.matthewspaint.com • 760 Pittsburgh Drive • Delaware, OH 43015

Product Information Effective 06/18
Part No. MPC208 06/18
©2018 Matthews Paint Company