



## 2.1 Low VOC Gray Epoxy Primer

MPC208

274 528SP  
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

#### Undercoats:

- 74734SP/74735SP Metal Pretreatment
- 74760SP/74766SP PT Filler
- 74770SP/74766SP HBPT
- 74780SP/74781SP HBEF
- 74350SP/74351SP Low VOC Non-Chromate Primer

### Required Products

#### Catalyst

274 529SP 2.1 Low VOC Gray 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	30 minutes
Dry to Handle	30 - 45 minutes
Dry to Topcoat	45 - 60 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)	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

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