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## Spray Bond Adhesive

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# 274793SP/01

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Matthews 274793SP/01 Spray Bond is a single component spray applied adhesive designed to provide excellent adhesion when applying Matthews Clears to bare metal.

Spray Bond is water clear in color, which makes it an excellent choice to protect and highlight underlying metals.

274793SP/01 Spray Bond is near zero VOC and ready to spray as packaged.



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### Features:

Ready to spray.....	No mixing; No pot life
Near zero VOC.....	Environmentally friendly; Meets most stringent VOC regulations
Compatible over most metal substrates.....	Can be clearcoated with most Matthews clear finishes
Water clear.....	Won't discolor bare metal substrate

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### Benefits:

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### Compatible Surfaces:

**274793SP/01 Spray Bond Adhesive may be applied over properly prepared:**

- Polished or Brushed Aluminum
- Brass
- Bronze
- 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 metals that are prone to tarnish, such as brass and copper, Braco Clear should be used (refer to Technical Data Sheet MPC173 or MPC174).

### Warning:

Spray Bond can not be used directly under 6178SP/01 HP Clear. (Refer to Technical Data Sheet MPC182.)

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## Directions for Use

### Surface Preparation:

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

### Mix Ratio:



- Must be shaken or stirred prior to use
- Strain material after mixing

### 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



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.

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

### Estimated Drying Times:



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

Dry to Clearcoat 5 - 10 minutes

**Note:** After 1 hour, apply an additional coat of 274793SP/01 prior to clearcoating.

### 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 0.0 lbs/gal

VOC Actual RTS 0.0 g/L

VOC Regulatory (less water less exempt) RTS 0.01 lbs/gal

VOC Regulatory (less water less exempt) RTS 1 g/L

For complete VOC information, visit [MatthewsPaint.com](http://MatthewsPaint.com) > Quick Links > VOC Data

#### Performance Characteristics

Volume solids (RTS) 2.5%

Theoretical Coverage (1 mil @ 100% transfer efficiency) 40 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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## Spray Bond Adhesive

**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  
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