



Epoxy Primers

274808SP/01 Black 274908SP/01 White

Matthews Epoxy Primers are corrosion resistant primers that provide excellent adhesion to many types of substrates and can also be used in 3.5 VOC compliant areas.

Combine the white epoxy with the black to create a wide range of gray shades to compliment the topcoat.



Features:

Low VOC technology	Environmentally friendly, meets 3.5 VOC regulations
Chromate-free.....	Meets EPA regulations for chromate restrictions
Available in Black and White.....	Combine together for any shade of gray
Topcoat with any Matthews Acrylic Polyurethane finishes.....	Versatile, multi-purpose
Compatible over various substrates.....	For multiple applications, fewer products to stock
Brush and roll capability	For use in areas where air spraying is prohibited
Epoxy technology	Excellent corrosion resistance, superior adhesion to substrate
Excellent filling properties.....	Capable of hiding minor metal substrate defects
Easy mix ratio	Less time mixing
24 hours topcoat window	No sanding required prior to topcoating within window
Anti-corrosion properties.....	Provides excellent corrosion protection

Benefits:

Compatible Surfaces:

274808SP/01 and 274908SP/01 Epoxy Primers may be applied over properly prepared:

Steel	Aluminum	Masonry
Blasted steel	Fiberglass	Wood
Carbon steel	Previously painted surfaces	
Galvanized steel	Body filler	

Associated Products:

Catalyst

274909SP/04 Epoxy Hardener

Exempt MAP Reducer (for 3.5 VOC)

- 6370SP/01 Cool temperature, 60 - 75°F (16 - 24°C)
- 6371SP/01 Warm temperature, 70 - 85°F (21 - 29°C)
- 6372SP/01 Hot temperature, 80°F (27°C) & above

Note: if 3.5 VOC is not required, any Matthews conventional or low VOC reducer can be used.

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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:



Mix Ratio for Spraying (by volume)

274808SP/01 / Black		
274908SP/01 / White	274909SP/04	Reducer**
3 parts*	1 part	1 part

*Any combination of black and white may be mixed together to make gray prior to catalyzing and reducing.

To achieve various shades of gray the table below may be used as a guideline.

	274908SP/01 (White)	274808SP/01 (Black)
White	100%	-
Light Grey	75%	25%
Medium Grey	50%	50%
Dark Grey	25%	75%
Black	-	100%

**Choose VOC MAP reducer

For 3.5 VOC:

- 6370SP/01 Cool temperature, 60 - 75°F (16 - 24°C)
- 6371SP/01 Warm temperature, 70 - 85°F (21 - 29°C)
- 6372SP/01 Hot temperature, 80°F (27°C) & above
- NOTE: Larger jobs may require a hotter temperature reducer.

If 3.5 VOC is not required, any Matthews conventional or low VOC reducer can be used.

- 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, reducer selection, and accelerator choice.

Note: mix no more product than can be used within pot life.

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: 1.3 - 1.5 mm 0.051 - 0.059 fluid tip
 HVLP: 1.3 - 1.5 mm 0.051 - 0.059 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 full 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, solvent selection, spray gun set-up, application, etc.

Recommended
Film Thickness:

	Per Coat Application	Total Application
Wet Film Thickness (WFT)	2.0 - 3.0 mils	4.0 - 6.0 mils
Dry Film Thickness (DFT)	0.8 - 1.2 mils	1.6 - 2.4 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 20 - 30 minutes

Dry to Touch 25 - 35 minutes

Dry to Handle 30 - 45 minutes

Dry to Topcoat 30 minutes - 24 hours (max)*

*After 24 hours, sand with a 220-400 grit dry, or equivalent sanding pad. Do not sand below minimum dry film thickness, otherwise reprime before topcoating.

Equipment Cleaning:

Clean equipment promptly with lacquer thinner or equivalent cleaning solvent.

Note: Do not leave mixed material in equipment.

Technical Data:

3.5 VOC Information

VOC Actual RTS	2.64 lbs/gal
VOC Actual RTS	316 g/L
VOC Regulatory (less water less exempt) RTS	3.3 lbs/gal
VOC Regulatory (less water less exempt) RTS	395 g/L

Above 3.5 VOC* Information

VOC Actual RTS	4.07 lbs/gal
VOC Actual RTS	487 g/L
VOC Regulatory (less water less exempt) RTS	4.07 lbs/gal
VOC Regulatory (less water less exempt) RTS	487 g/L

*>3.5 VOC calculations when using 45 290SP as an example

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

Performance Characteristics

Volume solids (RTS)	42.8%
Theoretical Coverage (1 mil @ 100% transfer efficiency)	685 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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