



Tie Bond Adhesive

274777SP/01

Matthews Tie Bond is a single component spray applied adhesion promoter designed to provide excellent adhesion over various acrylic and PVC substrates.

The application of Tie Bond directly to the plastic's surface eliminates the need for a scuffing process.

Tie Bond is water clear and is an excellent choice as an adhesion promoter when applying Matthews Acrylic Polyurethane finishes.

274777SP/01 Tie Bond is near zero VOC and ready to spray as packaged.



Features:

Benefits:

Compatible over most acrylic/PVC substrates	Improved adhesion for any Matthews topcoat
Ready to spray.....	No mixing; No pot life
Near zero VOC	Environmentally friendly; Meets most stringent VOC regulations

Compatible Surfaces:

274777SP/01 Tie Bond Adhesive may be applied over properly prepared:

- Acrylic
- Photopolymers
- Polycarbonate*
- Expanded Polyvinyl Chloride (PVC)
- Trim Cap (Jewelite)

Note: Generic families of plastic substrates may differ slightly in their manufacturing process and therefore exhibit different adhesion and application characteristics. Matthews recommends an adhesion test to specific (brand) substrates prior to implementing a coating program.

*The use of Tie Bond or any Matthews Polyurethane topcoats over polycarbonate will alter its impact strength.

Warning:

Tie 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 Topcoat 5 - 10 minutes

Note: After 1 hour, apply an additional coat of 274777SP/01 prior to topcoating.

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 > Quick Links > VOC Data

Performance Characteristics

Volume solids (RTS)	8.3%
Theoretical Coverage (1 mil @ 100% transfer efficiency)	133 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
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