Tie Bond Adhesive

74777SP/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 an excellent choice as an adhesion promoter when applying Matthews Acrylic Polyurethane finishes.

Features:

Benefits:

Compatible over most acrylic/PVC substrates ..... Improved adhesion for any Matthews topcoat
Reduce with any Matthews conventional, 2.8 or 3.5 VOC reducer ..... No pot life

Compatible Surfaces:

74777SP/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.)

Associated Products:

Reducer
6379SP/01 Cool temperature, 60 - 75°F (16 - 24°C)
45280SP/01 Warm temperature, 70 - 80°F (21 - 27°C)
45290SP/01 Very warm temperature, 75 - 85°F (24 - 29°C)
6396SP/01 Hot temperature, 80°F (27°C) & above

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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)

74777SP/01 Tie Bond	MAP Reducer*
2 parts	1/2 - 1-1/2 parts

*Choose MAP reducer

- 6379SP/01 Cool temperature, 60 - 75°F (16 - 24°C)
- 45280SP/01 Warm temperature, 70 - 80°F (21 - 27°C)
- 45290SP/01 Very warm temperature, 75 - 85°F (24 - 29°C)
- 6396SP/01 Hot temperature, 80°F (27°C) & above

NOTE: Larger jobs may require a hotter temperature reducer.

All components should be mixed thoroughly before using.

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, solvent selection, 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 74777SP/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	6.4 - 6.6 lbs/gal
VOC Actual RTS	767 - 791 g/L
VOC Regulatory (less water less exempt) RTS	6.4 - 6.6 lbs/gal
VOC Regulatory (less water less exempt) RTS	767 - 791 g/L

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

Performance Characteristics

Volume solids (RTS)	8.4 - 11.8%
Theoretical Coverage (1 mil @ 100% transfer efficiency)	135-190 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.
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