



Tie Bond Adhesive

MPC197

274 777SP

Matthews Tie Bond is a single component spray applied adhesion promoter designed to provide excellent adhesion over various plastic substrates. The application of Tie Bond directly to the plastic's surface eliminates the need for a scuffing process which often results in visible scratch marks on a finished sign. Tie Bond is water clear in color, which makes it an excellent choice as an adhesion promoter when applying Matthews Acrylic Polyurethane finishes.



Features

- Universal
- Single Component
- Versatile

Benefits

- Can be topcoated with any MPC color system
- No potlife
- Can be used with MPC's full array of solvents

Compatible Surfaces

274 777SP Tie Bond Adhesive may be applied over:

- Acrylic
- Acrylonitrile Butadiene Styrene (ABS)
- Photopolymers
- Expanded Polyvinyl Chloride (PVC)
- Polycarbonate*
- Styrene

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.

Warning: Tie Bond cannot be used directly under 6178SP HP Clear. (For information on using Tie Bond with this clear, refer to Technical Bulletin MPC182 HP Clear.)

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

Directions For Use

Surface Preparation:

- Wipe/clean substrate using 6428SP Plastic Prep (refer to MPC171 Technical Bulletin), or 6405SP Low VOC Cleaner (refer to MPC172 Technical Bulletin) in regulated areas.
- Remove any residue with clean, lint-free cloth and wipe dry.
- All surfaces must be free of oil, grease or any other contaminants prior to coating.



Mixing Recommendations:

Reduce 274 777SP 10% by volume with only Methyl Ethyl Ketone (MEK) or MPC 45 280SP Warm Temp Reducer. MEK was best in our testing, but 45 280SP is a close alternative.

- Examples:
- A. Mix 10 parts 274 777SP with 1 part MEK or 45 280SP
 - B. Mix 10 liq oz 274 777SP with 1 liq oz MEK or 45 280SP

Directions For Use (Continued)



Additives:

None Recommended.



Spray Set Up:

Air Pressure

Conventional.....40-50 lbs. psi at the gun
HVLP.....10 psi at cap
Pot Pressure 15-18 psi

Gun Set Up

Siphon Feed1.3 mm 0.050 fluid tip
HVLP.....1.3 mm 0.050 fluid tip
Pot Pressure1.2 mm 0.046 fluid tip



Application:

- Apply 2-3 medium wet coats
- Flash 15 minutes
- Apply topcoat

Caution: Use caution when coating light drier spray techniques over sensitive plastics (i.e. polycarbonate) to minimize crazing and warping.



Drying Times:

Air Dry (50% relative humidity, 70°F / 21°C):

Tack Free 10-15 minutes
To Topcoat..... 15 minutes

Compatible Topcoats:

MAP® or SVOC MAP® Colors and MAP Ultra Low VOC Satin and Gloss

Equipment Cleaning:

- Clean up equipment promptly with an all-purpose cleanup solvent.
- Do not leave mixed material in equipment.

Technical Data:

VOC Information

274 777SP Tie Bond.....0

Performance Characteristics

Solids by Weight15.4%
Volume Solids14.8%
Theoretical Coverage (1 mil @ 100% transfer efficiency).....236 sq.ft./RTS gal.
Application Conditions60°F (16°C) Minimum
100°F (38°C) Maximum
Relative Humidity.....85% Maximum
5° above dew point
Flash Point (Tag closed cup)53°F (12°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

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.