MPC125

Epoxy Primers

274 808SP Black
274 908SP 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 grey shades to compliment the topcoat.



Features:	Benefits:
• Universal	• Can be used over many substrates
• 3:1:1 Easy Mix Ratio	• Combine black & white together for any shade of grey
• VOC Compliant	• Can be used in areas where a maximum 3.5 VOC is required

Compatible Surfaces:

Epoxy Primers 274 808SP and 274 908SP may be applied over:

- Properly cleaned and sanded steel
- Properly cleaned and sanded blasted steel
- Properly cleaned and sanded carbon steel
- Properly cleaned and sanded galvanized steel
- Properly cleaned and sanded aluminum
- Properly cleaned and sanded fiberglass
- Previously painted surfaces with proper prep
- MAP Ultra Low VOC Satin or Gloss
- MAP®
- SATIN MAP®
- SVOC MAP®
- VOC MAP®
- Body Fillers
- Masonry
- Wood

Undercoats:

- 74734SP/74735SP Metal Pretreatment
- 74760SP/74766SP PT Filler
- 74770SP/74766SP HBPT
- 74780SP/74781SP HBEF
- 74350SP/74351SP Low VOC Non-Chromate Primer

Required Products:

Catalyst

274 909SP	Epoxy Primer Hardener

Reducers

6300SP	Cool VOC Reducer, 60 - 75°F (16 - 24°C)	6302SP	Hot VOC Reducer, 80°F (27°C) & above
6301SP	Warm VOC Reducer, 70 - 85°F (21- 29°C)	6372SP	Hot Exempt Reducer, 80°F (27°C) & above

274 808SP & 274 908SP

Directions for Use

Surface Preparation:



- Wipe/clean substrate using 45 330SP Speed Prep Cleaner if permitted under VOC guidelines or 6405SP Low VOC Cleaner (refer to MPC111 Technical Bulletin).
- Sand the bare metal areas completely with 180 - 220 grit abrasive.
- Sand old finishes with 320 - 400 grit dry by hand or machine or 600 grit wet.
- Re–clean with 45 330SP Speed Prep Cleaner or 6405SP Low VOC Cleaner. Final wipe with a clean tack cloth to remove any residue.
- Surfaces must be dry before application of primer. Then apply primer.

Mix Ratios:



Mix Ratios (by volume)

3.5 VOC

274 808SP & 274 908SP Epoxy Primer	274 909SP Epoxy Hardener	6372SP Exempt Reducer
*3 parts	1 part	1 part

Over 3.5 VOC



274 808SP & 274 908SP Epoxy Primer	274 909SP Epoxy Hardener	6300SP, 6301SP or 6302SP Low VOC Reducer
*3 parts	1 part	1 part

* Any combination of black and white may be mixed together to make grey. ***You must have a total of 3 parts of the combination.***

To achieve various shades of grey the table below may be used as a guideline. See above for 3 : 1 : 1 Mix Ratio.

	274 908SP (White) By Weight	274 808SP (Black) By Weight
White	100%	-
Light Grey	75%	25%
Medium Grey	50%	50%
Dark Grey	25%	75%
Black	-	100%





- Hardener, reducer and epoxy primer should be mixed thoroughly before using.
- Strain material following mixing.
- The usable pot life is approximately 4 hours at 70°F (21°C).

Reducers:

Exempt MAP Reducer *(3.5VOC)*

6372SP	Hot Exempt Reducer, 80°F (27°C) & above

Low VOC MAP Reducers *(Above 3.5 VOC)*

6300SP	Cool VOC Reducer, 60 - 75°F (16 - 24°C)
6301SP	Warm VOC Reducer, 70 - 85°F (21 - 29°C)
6302SP	Hot VOC Reducer, 80°F (27°C) & above

Additives:



None

Directions for Use

Spray Set Up:



Air Pressure:	Conventional:	55 - 65 psi at the gun
	HVLP:	10 psi at cap
	Pot Pressure:	15 - 18 psi
Gun Set Up:	Siphon Feed:	1.6 mm 0.063 fluid tip
	HVLP:	1.4 mm 0.055 fluid tip
	Pressure Pot:	1.2 mm 0.046 fluid tip

Application:



Apply: 1 full wet coat
Flash 10 - 15 min. between coats
Follow with a second full wet coat

Recommended Wet Film Thickness: 2.0 - 3.0 mils/coat

Recommended Dry Film Thickness: 1.5 - 2.0 mils

Caution: All 2 component cross-linking stops or slows significantly at temperatures below 60°F or 16°C. Never spray or subject freshly painted coatings to these conditions or poor water and chemical resistance, decreased durability and improper curing will occur.

Drying Times:



Dry Times at 70°F (21°C)

Dust Free	30 - 60 minutes
Dry to Handle	1.5 - 2 hours
Dry to Topcoat	30 - 60 minutes

Note: After 24 hours, a light sanding with 320 - 400 grit dry by hand or machine and tack wiping is recommended for good adhesion of the topcoat.

Equipment Cleaning:

Clean equipment promptly with an all-purpose clean up solvent or any compliant general cleaner.

Do not leave mixed material in equipment.

Technical Data:

3.5 VOC

274 808SP & 274 908SP Epoxy Primer	2.80 – 2.85
274 909SP Epoxy Hardener	4.59
6372SP Reducer	Exempt
Ready to Spray (3:1:1)	3.0 – 3.3

Above 3.5 VOC

274 808SP & 274 908SP Epoxy Primer	2.80 – 2.85
274 909SP Epoxy Hardener	4.59
6300SP, 6301SP or 6302SP Reducer	6.8
Ready to Spray (3:1:1)	3.90 – 3.95

Performance Characteristics

Volume Solids	58 – 60%
Volume Solids RTS	41 – 43%
Theoretical Coverage (2.0 mils @ 100% transfer efficiency)	335 – 340 sq.ft./RTS gal.
Application Conditions	55°F (13°C) Min. 100°F (38°C) Max.
Relative Humidity	85% Max. 5° above dew point
Flash Point *(Tag closed cup)*	68°F (20°C)

274 808SP/274 908SP

Epoxy Primers

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.
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