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




### Additives:

None Recommended.

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## Directions For Use (Continued)



### 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 Feed .....1.3 mm 0.050 fluid tip
HVLP.....1.3 mm 0.050 fluid tip
Pot Pressure .....1.2 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 Weight .....15.4%
Volume Solids .....14.8%
Theoretical Coverage (1 mil @ 100% transfer efficiency).....236 sq.ft./RTS gal.
Application Conditions .....60°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
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