

74 793SP

Spray Bond Adhesive

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.



MATTHEWS PAINT

The World's Finest Coating For Architectural Signage

LakeView Corporate Park • 8201 - 100th Street

Pleasant Prairie, WI 53158-2201

Toll Free: 800/323-6593 • Wisconsin: 262/947-0700

Toll Free FAX: 800/947-0377 • FAX: 262/947-0444

Spray Bond Adhesive

74 793SP

Matthews 74 793SP Spray Bond is a single component spray applied adhesive designed to provide excellent adhesion over hard to adhere to metals. It is a paint adhesive rather than a primer and will accept any of the Matthews' topcoats.

Spray Bond's ability to provide adhesion to the traditionally hard to adhere to metals such as galvanized or anodized surfaces allows the signage industry to readily change the color of those substrates.

Spray Bond is clear in color which makes it an excellent choice as an adhesion promoter when applying MAP® Clear finishes to protect and highlight underlying metals.



Features:

- Universal
- Clear

Benefits:

- Can be topcoated with any Matthews color and most clear finishes.
- Can be used as an adhesion promoter when applying clear coats to metals.

Compatible Surfaces:

74 793SP Spray Bond may be applied over:

- Polished or Brushed Aluminum
- Brass, Bronze or other alloy metals
- Copper

Warning:

Spray Bond can not be used directly under 6125SP TactileClear™ or 6778SP HP Clear. (For information on using Spray Bond with these clears, refer to Technical Bulletin MPC168 TactileClear or MPC182 HP Clear.)

Note: Spray Bond should be applied to metal surfaces only and is not recommended over plastics, wood, primers or topcoats.

Spray Bond is not intended as a corrosion inhibiting coating and will not protect metals from rust or other forms of oxidation breakdown. When clear coating polished metals, use Braco Clear. See MPC173 Technical Bulletin.

Required Products:

Reducers

6379SP Cool temperature, 60 - 75°F (16 - 24°C)

45 280SP Warm temperature, 70 - 80°F (21 - 27°C)

45 290SP Very warm temperature, 75 - 85°F (24 - 30°C)

6396SP Hot temperature, 80°F (27°C) & above

74 793SP

Directions for Use

Surface Preparation:

- Wipe/clean substrate using 45 330SP Speed Prep Cleaner. *Refer to MPC111 Technical Bulletin.*
- 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.**

Mix Ratios:

Mix Ratios (by volume):



74 793SP Spray Bond	MAP Reducer
2 parts	1/2 - 1 1/2 parts

Spray Bond is a single component product that does not require the addition of an activator or catalyst.



- Thin with any of the MAP® reducers best suited for shop conditions
- If spray appears to “cobweb” or apply stringy, more reducer should be added to provide a smooth coating.
- Strain material following mixing.

Reducers:

MAP Reducers (Conventional)

6379SP	Cool temperature, 60 - 75°F (16 - 24°C)
45 280SP	Warm temperature, 70 - 80°F (21 - 27°C)
45 290SP	Very warm temperature, 75 - 85°F (24°C - 30°C)
6396SP	Hot temperature, 80°F (27°C) & above

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 Feed:	1.3 mm 0.050 fluid tip
	HVLP:	1.3 mm 0.050 fluid tip
	Pressure Pot:	1.2 mm 0.046 fluid tip

Application:



Apply:	One full wet coat Flash 5 - 10 minutes between coats Follow with a second full wet coat
Recommended Wet Film Thickness:	2 coats @ 4.0 – 5.0 mils/per coat
Recommended Dry Film Thickness:	0.15 - 0.25 mils minimum

Spray Bond is not a finish coat and should be topcoated within 30 minutes after application. It remains permanently tacky and will pick up dust and dirt unless promptly topcoated.

Directions for Use

Drying Times:



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

Tack Free	10 - 15 minutes
To Topcoat	15 minutes minimum 30 minutes maximum

Compatible Topcoats:

MAP® Colors & Clears
VOC MAP® Colors & Clears

Equipment Cleaning:

Clean up equipment promptly with 45 340SP Cleanz-It or an all-purpose clean up solvent.
Do not leave mixed material in equipment.

Technical Data:

VOC Information

74 793SP Spray Bond	7.2
MAP Reducer (Conventional)	7.0 - 7.15
Ready to Spray (2 : 1/2 - 1 1/2)	7.12 - 7.16*

* Local regulations may exempt use of spray applied adhesives from VOC considerations.

Performance Characteristics

Volume Solids	1.5%
Volume Solids RTS	0.9 - 1.2%
Theoretical Coverage (1 mil @ 100% transfer efficiency)	14 - 20 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)