



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 gray shades to compliment the topcoat.



**Features:**

**Benefits:**

Low VOC technology .....	Environmentally friendly, meets 3.5 VOC regulations
Chromate-free.....	Meets EPA regulations for chromate restrictions
Available in Black and White.....	Combine together for any shade of gray
Topcoat with any Matthews Acrylic Polyurethane finishes.....	Versatile, multi-purpose
Compatible over various substrates.....	For multiple applications, fewer products to stock
Brush and roll capability .....	For use in areas where air spraying is prohibited
Epoxy technology .....	Excellent corrosion resistance, superior adhesion to substrate
Excellent filling properties.....	Capable of hiding minor metal substrate defects
Easy mix ratio .....	Less time mixing
24 hours topcoat window .....	No sanding required prior to topcoating within window
Anti-corrosion properties.....	Provides excellent corrosion protection

**Compatible Surfaces:**

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

Steel	Aluminum	Masonry
Blasted steel	Fiberglass	Wood
Carbon steel	Previously painted surfaces	
Galvanized steel	Body filler	

**Associated Products:**

<b>Catalyst</b>	<b>Exempt MAP Reducer</b> (for 3.5 VOC)
274 909SP Epoxy Hardener	6370SP Cool temperature, 60 - 75°F (16 - 24°C)
	6371SP Warm temperature, 70 - 85°F (21 - 29°C)
	6372SP Hot temperature, 80°F (27°C) & above

Note: if 3.5 VOC is not required, any Matthews conventional or low VOC reducer can be used.

# 274 808SP/ Black, 274 908SP/ White

## 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)

274 808SP / Black	274 908SP / White	274 909SP	Reducer**
3 parts*	1 part	1 part	

\*Any combination of black and white may be mixed together to make gray prior to catalyzing and reducing.

To achieve various shades of gray the table below may be used as a guideline.

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

\*\*Choose VOC MAP reducer

For 3.5 VOC:

- 6370SP Cool temperature, 60 - 75°F (16 - 24°C)
- 6371SP Warm temperature, 70 - 85°F (21 - 29°C)
- 6372SP Hot temperature, 80°F (27°C) & above
- NOTE: Larger jobs may require a hotter temperature reducer.

If 3.5 VOC is not required, any Matthews conventional or low VOC reducer can be used.

- All components should be mixed thoroughly before using
- Strain material after mixing



**Pot Life:** 4 hours

Pot-life is the amount of time before spray viscosity doubles. These are estimates based on lab results at 50% relative humidity, 70°F/21°C—results will vary based on application conditions, reducer selection, and accelerator choice.

Note: mix no more product than can be used within pot life.

**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: 1.3 - 1.5 mm 0.051 - 0.059 fluid tip  
 HVLP: 1.3 - 1.5 mm 0.051 - 0.059 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 one to two full wet coats, allowing proper flash time\* between coats.  
Apply additional coats as necessary to achieve total dry film thickness.  
**\*Flash times will vary dependent upon film thickness, temperature, solvent selection, spray gun set-up, application, etc.**

Recommended Film Thickness:	One Coat Application	Two Coat Application
Wet Film Thickness (WFT)	2.0 - 3.0 mils	4.0 - 6.0 mils
Dry Film Thickness (DFT)	0.8 - 1.2 mils	1.6 - 2.4 mils

**Caution:** All 2-component crosslinking slows significantly at temperatures below 60°F or 16°C. Never spray or subject freshly painted coatings to these conditions or loss of gloss, decreased durability and improper curing can occur.

### Estimated Drying Times:



Air-Dry @ 50% Relative Humidity, 70°F/21°C  
Dust Free 20 - 30 minutes  
Dry to Touch 25 - 35 minutes  
Dry to Handle 30 - 45 minutes  
Dry to Topcoat 30 minutes - 24 hours (max)\*

\*After 24 hours, sand with a 220-400 grit dry, or equivalent sanding pad. Do not sand below minimum dry film thickness, otherwise reprime before topcoating.

### Equipment Cleaning:

Clean equipment promptly with lacquer thinner or equivalent cleaning solvent.

**Note: Do not leave mixed material in equipment.**

### Technical Data:

#### 3.5 VOC Information

VOC Actual RTS	2.64 lbs/gal
VOC Actual RTS	316 g/L
VOC Regulatory (less water less exempt) RTS	3.3 lbs/gal
VOC Regulatory (less water less exempt) RTS	395 g/L

#### Above 3.5 VOC\* Information

VOC Actual RTS	4.07 lbs/gal
VOC Actual RTS	487 g/L
VOC Regulatory (less water less exempt) RTS	4.07 lbs/gal
VOC Regulatory (less water less exempt) RTS	487 g/L

\*>3.5 VOC calculations when using 45 290SP as an example

For complete VOC information, visit [MatthewsPaint.com](http://MatthewsPaint.com) > Quick Links > VOC Data

#### Performance Characteristics

Volume solids (RTS)	42.8%
Theoretical Coverage (1 mil @ 100% transfer efficiency)	685 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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## 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 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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760 Pittsburgh Drive  
Delaware, OH 43015  
Toll Free: 800/323-6593  
Toll Free FAX: 800/947-0377