



MAP®

Substrate Preparation Recommendations

Steps to Success

Step #1 – Matthews is for Professional Use Only.

Step #2 – Always follow proper safety precautions when using Matthews’s products. Safe usage requires reading, understanding, and following all label, MSDS, and other product literature before use.

Step #3 – The spray area and substrate must be warm and have adequate airflow. Application of primers, topcoats, and clear coats should never take place in temperatures under 60F/16C. Substrates should also be brought to or above this temperature guideline before applying any primer or topcoat.

Step #4 – Properly clean substrate. Professionals don’t even think about priming or painting over any substrate that hasn’t been properly cleaned and prepared. Use proper cleaning products and procedures.

Step #5 – Use the right primer for every specific substrate. Always use the appropriate primer and application techniques suggested from the Matthews substrate guide.

Step #6 – “When in doubt, test it out.” Recommend testing first, the process for any new product, primer, or first time application procedures before permanent production begins. Remember that the change of seasons effect the temperature and humidity during application so periodic testing on application and adhesion confirm the product and production performance.

Step #7 – Choose the proper reducer for each application. Review product data sheet for reducer temperature guidance.

Step #8 – Allow specific time between coats. For both primers, topcoats, and clears, extend flash times between each coat application.

Step #9 – Adjust spray equipment. Perform a spray pattern check prior to painting. Adjust flow, pressure, and tip if necessary. Use in well-ventilated facilities and with proper safety equipment.

Step #10 – Contact Matthews Paint Company with any questions. Matthews’s customer service and technical assistance are both available for any color formula match, specification, or technical question that may arise.

Call toll free at 1-800-323-6593

Or visit our web site at www.matthewspaint.com



Important Notes:

Always consult your local city, local air quality districts or government office to determine what regulations you must follow to be compliant with VOC regulations in your community.

Always consult the substrate manufacturer for information regarding proper cleaning and preparation for specialty coatings.

Always test adhesion on a sample of the substrate you are utilizing to ensure application process in your environment. Perform this test after a full cure of product has been applied (72 hours or more). A Cross-Hatch Adhesion test is the most common system utilized for this process.

Before opening the products listed – be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts.

Follow spray equipment manufacturer's instructions to prevent personal injury or fire.

Follow directions for respirator use.

Wear eye and skin protection.

Observe all application precautions.

See Material Safety Data Sheets and labels for additional safety information and handling instructions – available on web site at www.matthewspaint.com

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 toll free at 800-323-6593.



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Substrate Preparation Recommendations

- These are substrate guidelines to be used as a recommendation only.

| Substrate | Process |
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| <p>Aluminum – Shot, sanded, or media blasted.</p> <p>74 734SP Metal Pretreatment <u>may not</u> be the best choice of etching primer for use over Sanded, Shot, or Media blasted due to the <u>products ZERO filling properties.</u></p> | <p>Prime with Metal Pretreatment, PT Filler, HBPT Filler, Etching Filler, White or Black Epoxy primer, Polyester Primer Surfacer.</p> <p><u>Etching primer:</u></p> <p><u>74 734SP Metal Pretreatment: RTS 6.34 VOC</u></p> <ul style="list-style-type: none"> • Clean with 45 330SP Speed Prep Cleaner • Apply 1 wet coat Metal Pretreatment. • Allow 15-30 minutes to flash. • Topcoat. <p><u>74 760SP PT Filler: RTS 6.4 VOC:</u></p> <p>Clean with 45 330SP Speed Prep Cleaner Sandblasting or machine sand with 180-220 grit sandpaper to bare substrate. Clean again with 45 330SP Speed Prep Cleaner.</p> <ul style="list-style-type: none"> • Apply 1 wet coat PT Filler. • Allow 5 minutes to flash. • Apply 2nd wet coat PT Filler. • Allow 20-30 minutes to flash. • Topcoat <p><u>74 770SP HBPT Self-etching Metal Treatment: RTS 6.13 VOC</u></p> <p>Clean with 45 330SP Speed Prep Cleaner Sandblasting or machine sand with 120-220 grit sandpaper to bare substrate. Clean again with 45 330SP Speed Prep Cleaner.</p> <ul style="list-style-type: none"> • Apply 1 wet coat HBPT Filler. • Allow 5 minutes to flash. • Apply 2nd wet coat HBPT Filler. • Allow 20-30 minutes to flash. • Topcoat. |



| Substrate | Process |
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| | <p><u>74 780SP HBEF Self-etching Metal Treatment: RTS 6.04 VOC</u></p> <p>Clean with 45 330SP Speed Prep Cleaner Sandblasting or machine sand with 80-220 grit sandpaper to bare substrate. Clean again with 45 330SP Speed Prep Cleaner.</p> <ul style="list-style-type: none"> • Apply 1 wet coat HBEF Filler. • Allow 3-5 minutes to flash. • Apply 2nd wet coat HBEF Filler. • Allow 20-30 minutes to flash. • Topcoat. <p><u>Epoxy priming:</u></p> <p>274 908SP White Epoxy Primer RTS 3.26 VOC or 6013SP Black Epoxy Primer RTS 4.6 VOC</p> <ul style="list-style-type: none"> • Clean with 45 330SP Speed Prep Cleaner. • Sand with 80-220 grit sandpaper. • Clean again with 45 330SP Speed Prep Cleaner • Apply 1 wet coat Epoxy Primer. • Allow 10-15 minutes to flash. • Apply 2nd wet coat Epoxy Primer. • Allow 30-60 minutes to flash. • Topcoat. <p><u>6001SP Polyester Primer Surfacer: RTS 1.8 VOC</u></p> <p>Clean with 45 330SP Speed Prep Cleaner. Sand with 80-220 grit sandpaper. Clean again with 45 330SP Speed Prep Cleaner.</p> <ul style="list-style-type: none"> • Mix Polyester Primer according to instructions. • Apply 1 wet coat. • Allow 20 minutes to flash. • Apply 2nd wet coat. • Allow 20 minutes to flash. • Apply 3rd coat to cover porosity, if necessary. • Allow longer flash times between 3rd coats. • Allow 1.5 hours dry time before sanding, cleaning, and topcoating. |



| Substrate | Process |
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| <p>Anodized Aluminum</p> <p><u>Sanding must be performed to remove all the Anodized surface from the aluminum.</u></p> | <p><u>Epoxy priming:</u> 274 908SP White Epoxy Primer RTS 3.26 VOC or 6013SP Black Epoxy Primer RTS 4.6 VOC</p> <ul style="list-style-type: none"> • Clean with 45 330SP Speed Prep Cleaner. • Sand surface with a “dual action” sander using 280-320 grit sandpaper removing all color from the substrate. • Clean again with 45 330SP Speed Prep Cleaner. • Apply 1 wet coat of epoxy primer. • Allow 10-15 minutes to flash. • Apply 2nd wet coat of epoxy primer. • Allow 30-60 minutes to flash. • Topcoat. <p><u>74 793SP Spray Bond:</u></p> <ul style="list-style-type: none"> • Clean with 45 330SP Speed Prep Cleaner. • Apply 1 wet coat. • Flash 5-10 minutes between coats. • Follow with a second wet coat. • Do not let dry – let tack up 20 minutes. • Topcoat. |
| <p>Steel – Pre-Sanded, Shot, or Media Blasted</p> | <ul style="list-style-type: none"> • Prime with Metal Pretreatment, PT Filler, HBPT Filler, HBEF Etching Filler, White or Black Epoxy primers. <p><u>Etching priming:</u> 74 734SP Metal Pretreatment RTS 6.34 VOC 74 760SP PT Filler. RTS 6.4 VOC Sandblasting or machine sand with 180-220 grit sandpaper to bare substrate. 74 770SP HBPT Self-etching Metal Treatment. RTS 6.13 VOC Sandblasting or machine sand with 120-220 grit sandpaper to bare substrate. 74 780SP HBEF Self-etching Metal Treatment. RTS 6.04 VOC Sandblasting or machine sand with 80-220 grit sandpaper to bare substrate.</p> <ul style="list-style-type: none"> • Clean with 45 330SP Speed Prep Cleaner. • Apply 1 wet coat. • Allow 5 minutes to flash. • Apply 2nd wet coat. • Allow 20-30 minutes to flash. • Topcoat. |



| Substrate | Process |
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| | <p><u>Epoxy priming:</u> 274 908SP White Epoxy Primer RTS 3.26 VOC or 6013SP Black Epoxy Primer RTS 4.6 VOC</p> <ul style="list-style-type: none"> • Clean with 45 330SP Speed Prep Cleaner. Sandblasting or machine sand with 80-220 grit sandpaper to bare substrate. • Apply 1 wet coat epoxy primer. • Allow 10-15 minutes to flash. • Apply 2nd wet coat epoxy primer. • Allow 30-60 minutes to flash. • Topcoat. |
| <p>Steel – Bonderized, Phosphate Coated</p> | <p><u>Epoxy priming:</u> 274 908SP White Epoxy Primer RTS 3.26 VOC or 6013SP Black Epoxy Primer RTS 4.6 VOC</p> <ul style="list-style-type: none"> • Clean with 45 330SP Speed Prep Cleaner. • Scuff surface with Scotch-brite pad. • Clean again with 45 330SP Speed Prep Cleaner. • Apply 1 wet coat epoxy primer. • Allow 10-15 minutes to flash. • Apply 2nd wet coat epoxy primer. • Allow 30-60 minutes to flash. • Topcoat. |
| <p>Steel – New Galvanized, Gavaneal, Galvalume, or Zinc Coated.</p> | <p><u>Epoxy priming:</u> 274 908SP White Epoxy Primer RTS 3.26 VOC or 6013SP Black Epoxy Primer RTS 4.6 VOC</p> <ul style="list-style-type: none"> • Clean with 45 330SP Speed Prep Cleaner. • Verify all oils and surface contaminants have been removed. • Sand surface with 150-220 grit sandpaper. • Clean again with 45 330SP Speed Prep Cleaner. • Apply 1 wet coat epoxy primer. • Allow 10-15 minutes to flash. • Apply 2nd wet coat epoxy primer. • Allow 30-60 minutes to flash. • Topcoat. |



| Substrate | Process |
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| <p>Powder Coated Substrates</p> | <p><u>Epoxy Priming:</u> 274 908SP White Epoxy Primer RTS 3.26 VOC or 6013SP Black Epoxy Primer RTS 4.6 VOC</p> <ul style="list-style-type: none"> • Clean with 45 330SP Speed Prep Cleaner. • Sand surface thoroughly with a “dual action” sander using 150-220 grit sandpaper. • Clean again with 45 330SP Speed Prep Cleaner. • Apply 1 wet coat epoxy primer. • Allow 10-15 minutes to flash. • Apply 2nd wet coat epoxy primer. • Allow 30-60 minutes to flash. • Topcoat. |
| <p>Steel or Aluminum repairs next to primed and or painted surfaces.</p> | <p><u>Epoxy Priming:</u> 274 908SP White Epoxy Primer RTS 3.26 VOC or 6013SP Black Epoxy Primer RTS 4.6 VOC</p> <ul style="list-style-type: none"> • Inspect existing coating for any delaminating or degradation to determine if existing coating should be removed. If so, repair or strip as necessary. • Clean with 45 330SP Speed Prep Cleaner. • Sand complete surface area with 150/220 grit sandpaper. • Clean again with 45 330SP Speed Prep Cleaner. • Apply 1 wet coat epoxy primer over all surface areas. • Allow 10-15 minutes to flash. • Apply 2nd wet coat. • Allow 30-60 minutes to flash. • Topcoat. |
| <p>Painted Surfaces, not Matthews Paint (Refurbishing work)</p> <p>Always test painted surface for compatibility to use of Matthews primers and topcoats.</p> | <p><u>Epoxy Priming:</u> 274 908SP White Epoxy Primer RTS 3.26 VOC or 6013SP Black Epoxy Primer RTS 4.6 VOC</p> <ul style="list-style-type: none"> • Inspect existing coating for any delaminating or degradation to determine if existing coating should be removed. If so, repair or strip as necessary. • Clean with 45 330SP Speed Prep Cleaner. • Abrade with 280-400 grit sandpaper or scotch-bite pad as necessary. • Clean again with 45 330SP Speed Prep Cleaner. • Apply 1 wet coat epoxy primer. |



| Substrate | Process |
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| | <ul style="list-style-type: none"> • Allow 10-15 minutes to flash. • Apply 2nd wet coat of epoxy primer. • Allow 30-60 minutes to flash. Topcoat. |
| Bondo filled areas | <p><u>On repaired bare metal area:</u></p> <ul style="list-style-type: none"> • Clean with 45 330SP Speed Prep Cleaner. • Apply 1-2 wet coats of the 274 908SP White Epoxy Primer or 6013SP Black Epoxy Primer and allow to dry. • Clean repaired area with 45 330SP Speed Prep Cleaner. • Apply sufficient process of Bondo applications for desired filling property. • Allow to fully dry. Sand if necessary. • Clean with 45 330SP Speed Prep Cleaner all areas surrounding Bondo. <u>Cleaner should never come in contact with Bondo.</u> • Confirm that Bondo'd areas are thoroughly cured. • If necessary, to fill pin holes ONLY. Apply spot putty and allow to dry. • Sand or scuff painted areas around and including Bondo. • Clean again with 45 330SP Speed Prep Cleaner. <u>Cleaner should never come in contact with Bondo.</u> <p>Immediately prime with White or Black Epoxy, Polyester Primer Surfacer, or U-Prime.</p> <p><u>Epoxy priming:</u> 274 908SP White Epoxy Primer RTS 3.26 VOC or 6013SP Black Epoxy Primer RTS 4.6 VOC</p> <ul style="list-style-type: none"> • Apply 1 wet coat. • Allow 10-15 minutes to flash. • Apply 2nd wet coat. • Allow 30-60 minutes to flash. • Topcoat. <p><u>6001SP Polyester Primer Surfacer: RTS 1.8 VOC</u></p> <ul style="list-style-type: none"> • Mix Polyester Primer according to instructions. • Apply 1 wet coat. |



| Substrate | Process |
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| | <ul style="list-style-type: none"> • Allow 20 minutes to flash. • Apply 2nd wet coat. • Allow 20 minutes to flash. • Apply 3rd or 4th coat to cover porosity, if necessary. • Allow longer flash times between 3rd and 4th coats. • Allow 1.5 hours dry time before sanding. • Sand repaired area. • Sand or scuff remaining surface area. • Clean with 45 330SP Speed Prep Cleaner. • Topcoat. <p><u>U-Prime application: RTS 3.5 or 2.8 VOC</u> 274 685SP U-Prime White Urethane Primer:</p> <ul style="list-style-type: none"> • Apply 1 wet coat. • Allow 10-15 minutes to flash. • Apply 2nd wet coat. • Allow 10-15 minutes to flash. • Apply 3rd coat if necessary. <p>Allow to dry 24 hours before sanding, cleaning, and top coating.</p> |
| <p>Acrylic (Acrsteel, Acrylite, Crylex, Plexiglass, Lucite, Implex)</p> | <p><u>Tie Bond Adhesive: RTS 6.4 – 6.6 VOC</u> 74 777SP Tie Bond Adhesive:</p> <ul style="list-style-type: none"> • Clean with 6428SP Plastic Speed Prep Cleaner. • Can use 6428SP Plastic Speed Prep Cleaner as an Anti-Static application, once surface has been cleaned by applying a mist coat over entire surface area and allow product to evaporate. • Apply 1 wet coat of Tie Bond Adhesive. • Allow 5-10 minutes to flash. • Apply 2nd wet coat of Tie Bond Adhesive. • Allow 5-10 minutes to flash. <p>Topcoat.</p> |
| <p>PVC - Expanded & Non Expanded (Kometex, Sintra, Seltec, Intacel, & Trovicel)</p> | <p><u>Tie Bond Adhesive: RTS 6.4 – 6.6 VOC</u> 74 777SP Tie Bond Adhesive:</p> <ul style="list-style-type: none"> • Clean with 6428SP Plastic Speed Prep Cleaner. • (To remove surface static, apply mist coat of 6428SP Plastic Speed Prep Cleaner, allow to dry) • Prime with 1 wet coat 74 777SP Tie Bond Adhesive. |



| Substrate | Process |
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| <p>Adhesive for topcoat adhesion.</p> | <ul style="list-style-type: none"> • Allow 10-15 minutes to flash • Apply 2nd medium wet coat |
| <p>Polycarbonate (Lexan) <u>Poly-Carbonate manufactures</u> recommend that all moisture be heat purged out of substrate before coating application. Use of any MPC primer or topcoat will alter this substrates impact strength.</p> | <p><u>Tie Bond Adhesive: RTS 6.4 – 6.6 VOC</u> 74 777SP Tie Bond Adhesive:</p> <ul style="list-style-type: none"> • Clean with 6428SP Plastic Speed Prep Cleaner. • Can use 6428SP Plastic Speed Prep Cleaner as an Anti-Static application, once surface has been cleaned by applying a mist coat over entire surface area and allow product to evaporate. • Apply 1 wet coat of Tie Bond Adhesive. • Allow 5-10 minutes to flash. • Apply 2nd wet coat of Tie Bond Adhesive. • Allow 5-10 minutes to flash. • Topcoat. <p>OR</p> <ul style="list-style-type: none"> • Apply 1 light coat of topcoat properly mixed with 74 102SP Converter (makes basecoat). • Allow 10-15 minutes to flash. • Apply 1 wet coat of MAP topcoat. • Allow 10-15 minutes to flash. • Apply 2nd wet coat of MAP topcoat. |
| <p>Vinyl (3M, Avery, Mactac, Oracale, FDC, Ultramark)</p> | <ul style="list-style-type: none"> • Clean with 6428SP Plastic Prep. • Scuff surface with Scotch-brite pad. • Clean again with 6428SP Plastic Prep. • Apply 1 wet coat of MAP topcoat mixed properly with 47 474SP Flex Additive. • Allow 10-15 minute to flash. • Apply 2nd wet coat of MAP topcoat mixed properly with Flex Additive. Allow to dry. |
| <p>Trim Cap (Jewelite, Silvertrim)</p> | <ul style="list-style-type: none"> • Clean with 45 330SP Speed Prep Cleaner • Abrade with Scotch-brite pad. • Clean again with 45 330SP Speed Prep Cleaner • Apply 1 wet coat of MAP topcoat mixed properly with 47 474SP Flex Additive. • Allow 10-15 minute to flash. • Apply 2nd wet coat of MAP topcoat mixed properly with Flex Additive. Allow to dry. |
| <p>Flexible Face (Cooley)</p> | <ul style="list-style-type: none"> • Clean with 45 330SP Speed Prep Cleaner. |



| Substrate | Process |
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| | <ul style="list-style-type: none"> • Verify that all surface areas are <u>thoroughly cleaned</u>. • Repeat cleaning process if necessary • Apply 1 wet coat of MAP topcoat mixed properly with 47 474SP Flex Additive. • Allow 10-15 minutes to flash. • Apply 2nd wet coat of MAP topcoat mixed properly with Flex additive. • Allow to dry. |
| <p>HDU or Polyurethane Foam Board (Poly Board, Sign Foam, Precision Board)</p> <p>Apply two light coats; allow to dry before laying down wet coats. This helps seal pin holes. It may be necessary to fill pinholes with putty before sanding.</p> | <p>Prime with 274 685SP U-Prime White Urethane Primer, 274 908SP White Epoxy or 6013SP Black Epoxy Primer, or 6001SP Polyester Primer Surfacer.</p> <ul style="list-style-type: none"> • Apply the number of coats needed to fill the nooks and porosity in the foam. • Allow adequate flash times between coats. <p><u>Polyester Primer Surfacer priming:</u> 6001SP Polyester Primer Surfacer: RTS 1.8 VOC</p> <ul style="list-style-type: none"> • Clean substrate with clean compressed air. • Mix Polyester Primer according to instructions. • Apply 1 wet coat. • Allow 20 minutes to flash. • Apply 2nd wet coat. • Allow 20 minutes to flash. • Apply 3rd coat to cover porosity, if necessary. • Allow longer flash times between 3rd and 4th coats. <p>Allow 1.5 hours dry time before sanding, cleaning, and topcoating.</p> <p><u>U-Prime application: RTS 3.5 or 2.8 VOC</u> 274 685SP U-Prime White Urethane Primer:</p> <ul style="list-style-type: none"> • Clean substrate with clean compressed air. • Apply 1 wet coat • Allow 10-15 minutes to flash. • Apply 2nd wet coat • Allow 10-15 minutes to flash. • Apply 3rd coat, if necessary. • Allow 24 hours dry time before sanding, cleaning and topcoating. <p><u>Epoxy priming:</u> 274 908SP White Epoxy Primer RTS 3.26 VOC or 6013SP Black Epoxy Primer RTS 4.6 VOC</p> <ul style="list-style-type: none"> • Clean substrate with clean compressed air. • Apply 1 wet coat of epoxy primer. |



| Substrate | Process |
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| | <ul style="list-style-type: none"> • Allow 10-15 minutes to flash. • Apply 2nd wet coat of epoxy primer. • Allow 30-60 minutes to flash. • Apply 3rd coat, if necessary. <p>Allow 2-4 hours dry time before sanding, cleaning and topcoating.</p> |
| <p>EPS-Polystyrene (Gator Foam)</p> <p>Pittsburg Paint’s 17-21 Seal Grip Acrylic Latex Primer (water based) works well in this application. Allow at least 60 minutes after application for topcoating.</p> <p>Fiberglass – Un Gel coated</p> | <ul style="list-style-type: none"> • Clean substrate with clean compressed air. • Apply latex exterior primer in order to fill and seal the entire foam surface areas. Allow to dry. • Clean with 45 330SP Speed Prep Cleaner. • Scuff surface with Scotch-brite pad. • Clean again with 45 330SP Speed Prep Cleaner. • Topcoat. <p>Prime with either 274 908SP White Epoxy Primer, 6013SP Black Epoxy Primer, or 6001 Polyester Primer Surfacer</p> <p><u>Epoxy priming:</u> 274 908SP White Epoxy Primer RTS 3.26 VOC or 6013SP Black Epoxy Primer RTS 4.6 VOC</p> <ul style="list-style-type: none"> • Clean substrate with clean compressed air. • Clean with 45 330SP Speed Prep Cleaner. • Apply 1 wet coat of White or Black Epoxy primer. • Allow 10-15 minutes to flash. • Apply 2nd wet coat. • Allow 30-60 minutes to flash. • Apply the necessary number of coats to fill the nooks in the fiberglass. • Extend flash times between each application of epoxy when adding more than two coats to fill fiberglass. • Topcoat. |



| Substrate | Process |
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| Fiberglass – Un Gel coated | <p>Prime with either 274 908SP White Epoxy Primer, 6013SP Black Epoxy Primer, or 6001 Polyester Primer Surfacer</p> <p><u>Epoxy priming:</u> 274 908SP White Epoxy Primer RTS 3.26 VOC or 6013SP Black Epoxy Primer RTS 4.6 VOC</p> <ul style="list-style-type: none"> • Clean substrate with clean compressed air. • Clean with 45 330SP Speed Prep Cleaner. • Apply 1 wet coat of White or Black Epoxy primer. • Allow 10-15 minutes to flash. • Apply 2nd wet coat. • Allow 30-60 minutes to flash. • Apply the necessary number of coats to fill the nooks in the fiberglass. • Extend flash times between each application of epoxy when adding more than two coats to fill fiberglass. • Topcoat. <p><u>Polyester Primer Surfacer primer: RTS 1.8 VOC</u> 6001SP Polyester Primer Surfacer. Clean substrate with clean compressed air.</p> <ul style="list-style-type: none"> • Apply 1 wet coat polyester primer. • Allow 20 minutes to flash. • Apply 2nd wet coat polyester primer. • Allow 20 minutes to flash. • Apply 3rd coat to cover porosity, if necessary. • Allow longer flash times between 3rd and 4th coats. <p>Allow 1.5 hours dry time before sanding, cleaning, and topcoating.</p> |
| Fiberglass - Gel coated | <ul style="list-style-type: none"> • Inspect Gel Coat to ensure proper coverage of all pre-painted surfaces. • Clean with 45 330SP Speed Prep Cleaner. • Sand surface with 220-320 grit sandpaper. • Clean again with 45 330SP Speed Prep Cleaner. • Topcoat. |
| Wood (Applying color) | <ul style="list-style-type: none"> • Ensure throughout testing that moisture content of the wood is less than 13%. • Clean with 45 330SP Speed Prep Cleaner. • Sand any rough areas with 180-220 grit sandpaper. • Remove dust with clean compressed air, tack rag, or clean with 45 330SP Speed Prep Cleaner. |



| Substrate | Process |
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| | <ul style="list-style-type: none"> • Spot prime over knots, cut areas, or ends with 274 908SP White Epoxy Primer or 6013SP Black Epoxy Primer. • Allow to dry 30-60 minutes. • Topcoat. <p><u>Epoxy priming:</u> 274 908SP White Epoxy Primer RTS 3.26 VOC or 6013SP Black Epoxy Primer RTS 4.6 VOC</p> <ul style="list-style-type: none"> • Clean with 45 330SP Speed Prep Cleaner. • Apply 1 wet coat epoxy primer. • Allow 5-15 minutes to flash. • Apply 2nd wet coat epoxy primer. • Allow 30-60 minutes to flash. • Topcoat. <p>All areas of wood must be sealed.</p> |
| Limestone | <p><u>Epoxy priming:</u> 274 908SP White Epoxy Primer RTS 3.26 VOC or 6013SP Black Epoxy Primer RTS 4.6 VOC</p> <ul style="list-style-type: none"> • Clean substrate with compressed air. • Clean with 5% Muratic acid & water solution. (Follow all safety instructions recommended by manufacture!) • Rinse substrate thoroughly with clean water and allow surface to dry. • Clean again with compressed air. • Apply 1 wet coat epoxy primer. • Allow 10-15 minutes to flash. • Apply 2nd wet coat epoxy primer. • Allow 30-60 minutes to flash. • Topcoat. |



| Substrate | Process |
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| Granite – Sandblasted | <ul style="list-style-type: none"> • Clean substrate with compressed air. • Brush away any loose debris. • Clean again with compressed air. • Topcoat. |
| Granite – Polished or Smooth | <p><u>Epoxy priming:</u> 274 908SP White Epoxy Primer or 6013SP Black Epoxy Primer.</p> <ul style="list-style-type: none"> • Clean surface with water to remove debris. • Clean with 5% Muratic acid & water solution. (Use recommended safety instructions from manufacture!) • Rinse substrate thoroughly with clean water and allow surface to dry completely. • Apply 1 wet coat epoxy primer. • Allow 10-15 minutes to flash. • Apply 2nd wet coat epoxy primer. • Allow 30-60 minutes to flash. • Topcoat. |
| <p>Cement – Masonry, Concrete, Concrete Block, Dryvit, Stucco, & Texcoat</p> <p><u>Failure to ensure that moisture and PH levels are within recommend limits will result in apparent or eventual coating failure.</u></p> | <ul style="list-style-type: none"> • Pressure clean entire surface with 2000 PSI at 3-5 GPM (Gallons Per Minute). • PH test level of substrate. Proper PH level must be less than 10 and higher than 5, neutral is 7, and preferred. (PH test pencils can be purchased at http://www.cole-palmer.com) • Moisture Test level of substrate. Requires less than 13%. <p><u>Epoxy priming:</u> 274 908SP White Epoxy Primer or 6013SP Black Epoxy Primer.</p> <ul style="list-style-type: none"> • Sand blast surface and remove debris with compressed air. • Clean surface with a mixture 10% Hydrochloric Acid and water solution. (Use recommended safety instructions from manufacture!) • Rinse well with water. • Allow to dry completely. • Apply 1 wet coat epoxy primer. • Allow 10-15 minutes to flash. • Apply 2nd wet coat epoxy primer. • Allow 30-60 minutes to flash. • Topcoat. |



| Substrate | Process |
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| Cement – Masonry, Concrete, Concrete Block - Previously Coated | <p><u>Epoxy priming:</u> 274 908SP White Epoxy Primer or 6013SP Black Epoxy Primer.</p> <ul style="list-style-type: none"> • Inspect coating to ensure a sound and secure finish. • Sand blast away any loose coating from surface. • Remove debris with compressed air. • Rinse well with water and allow to dry. • Sand surface with 180-220 grit sandpaper. • Clean with water and allow to dry completely. • Apply 1 wet coat epoxy primer. • Allow 10-15 minutes to flash. • Apply 2nd wet coat epoxy primer. • Allow 30-60 minutes to flash. • Topcoat. |
| Drywall | <p><u>Epoxy Priming:</u> 274 908SP White Epoxy Primer Primer:</p> <ul style="list-style-type: none"> • Surface needs to be vacuumed clean of all dust. • Wipe surface with tack cloth. • Apply 1 medium coat of 274 908SP White Epoxy Primer • Allow 30 minutes to flash. • Apply 2nd wet coat epoxy primer. • Allow to dry overnight. • Sand with 220-320 grit sandpaper. • Clean with 45 330SP Speed Prep Cleaner. • Topcoat. |
| Polypropylene or Polyethylene | <ul style="list-style-type: none"> • Requires Flame or Chroma treatment in order to alter the surface molecular structure, which allows a <u>limited time</u> period for the substrate to be paint receptive. All propylene and ethylene structures are different, so test for adhesion. • Clean with 6428SP Plastic Speed Prep Cleaner • Topcoat. |
| Glass & Porcelain | <ul style="list-style-type: none"> • Clean with 45 330SP Speed Prep Cleaner • Treat with diluted muriatic acid and rinse completely. • Use recommended safety instructions from manufacturers. • Use 1 part acid to 2 parts water. • When thoroughly dry, topcoat. |



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MAP®

Clear Coat Preparation Recommendations

- These are substrate guidelines to be used as a recommendation only.

| Clear Coat | Process |
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| <p>Matthews Topcoat (Wet)</p> | <ul style="list-style-type: none"> • Allow topcoat 30 minutes to flash. • 15 minutes with 287 437SP Accelerator. • Apply 1 wet coat of MAP Clear. • Allow 5–10 minutes to flash. • Apply 2nd wet coat MAP Clear. • Verify proper wet film build. • Allow to dry. <p><u>If choosing to wait before applying a clear coat, allow top coat to dry 24 Hrs.</u></p> <ul style="list-style-type: none"> • Clean with 45 330SP Speed Prep Cleaner. • Scuff surface with Scotch-brite or sand with 600 grit sandpaper. • Clean again with 45 330SP Speed Prep Cleaner. • Apply 1 wet coat of MAP Clear. • Allow 5-10 minutes to flash. • Apply 2nd wet coat of MAP Clear. • Verify proper wet film build. • Allow to dry. |



| Clear Coat | Process |
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| <p>Matthews Topcoat (After 24 hours)</p> | <ul style="list-style-type: none"> • Clean with 45 330SP Speed Prep Cleaner. • Scuff surface with Scotch-brite pad or sand with 320 - 600 grit sandpaper. • Clean again with 45 330SP Speed Prep Cleaner • Apply 1 wet coat MAP Clear. • Allow 5–10 minutes to flash. • Apply 2nd wet coat MAP Clear. • Verify proper wet film build. • Allow to dry. |
| <p>Aluminum</p> | <p><u>Spray Bond Adhesive:</u> <u>74 793SP Spray Bond Adhesive: RTS 7.12 – 7.16</u> <u>VOC</u></p> <ul style="list-style-type: none"> • Clean with 45 330SP Speed Prep Cleaner. • Apply 1 wet coat of 74 793SP Spray Bond Adhesive. • Do not allow Spray Bond to dry before clear coating. • Allow 5-10 minutes to flash. • Apply 2nd wet coat of Spray Bond. • Allow 5-10 minutes to flash • Apply 1 wet coat MAP Clear. • Allow 5–10 minutes to flash. • Apply 2nd wet coat MAP Clear. • Verify proper wet film build. • Allow to dry. |



| Clear Coat | Process |
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| Acrylic | <p><u>Tie Bond Adhesive:</u> <u>74 777SP Tie Bond Adhesive: RTS 6.4 – 6.6 VOC</u></p> <ul style="list-style-type: none">• Clean with 6428SP Plastic Prep. (1st or 2nd surface)• Apply a mist coat of 6428SP Plastic Prep and allow to dry in order to reduce static surface charge.• Apply 1 full wet coat 74 777SP Tie Bond Adhesive.• Do not allow Tie Bond Adhesive to dry before clear coating.• Allow 5–10 minutes to flash.• Apply 2nd wet coat of Tie Bond.• Allow 5-10 minutes to flash.• Apply 1 wet coat MAP Clear.• Allow 5-10 minutes to flash.• Apply 2nd wet coat of MAP Clear.• Verify proper wet film build.• Allow to dry. |



| Clear Coat | Process |
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| <p>Polycarbonate (Lexan) Some Polycarbonate substrates can be too solvent sensitive for use of the preferred Tie Bond Adhesive. The application of a “converted” coat as a primer may provide the adhesion required and not adversely affect the substrate.</p> <p><u>PolyCarbonate manufactures</u> recommend that all moisture be heat purged out of substrate before any coating application. Use of any MPC primer or topcoat may alter the substrates impact strength.</p> | <p><u>Tie Bond Adhesive:</u> <u>74 777SP Tie Bond Adhesive: RTS 6.4 – 6.6 VOC</u></p> <ul style="list-style-type: none"> • Clean with 6428SP Plastic Prep. (1st or 2nd surface) • Apply a mist coat of 6428SP Plastic Prep and allow to dry in order to reduce static surface charge. • Apply 1 full wet coat 74 777SP Tie Bond Adhesive. • Do not allow Tie Bond Adhesive to dry before clear coating. • Allow 5–10 minutes to flash. • Apply 2nd wet coat of Tie Bond Adhesive. • Allow 5-10 minutes to flash. • Apply 1 wet coat MAP Clear. • Allow 5-10 minutes to flash. • Apply 2nd wet coat of MAP Clear. • Verify proper wet film build. <p>OR</p> <ul style="list-style-type: none"> • Clean with 6428SP Plastic Prep. (1st or 2nd surface) • Apply a mist coat of 6428SP Plastic Prep and allow to dry in order to reduce static surface charge. • Apply 1 light coat of MAP Clear mixed with 74 102SP MAP Converter (basecoat). • Allow 10-15 minutes to flash. • Apply 1 wet coat MAP Clear. • Allow 5–10 minutes to flash. • Apply 2nd wet coat MAP Clear. • Verify proper wet film build. • Allow to dry. |



| Clear Coat | Process |
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| <p>Vinyl (3M, Avery, Mactac, Ultramark)</p> | <ul style="list-style-type: none"> • Clean with 45 330SP Speed Prep Cleaner • Scuff surface with Scotch-brite pad. • Clean again with 45 330SP Speed Prep Cleaner. • Apply 1 wet coat MAP Clear mixed with 47 474SP Flex Additive. • Allow 5–10 minutes to flash. • Apply 2nd wet coat MAP Clear. • Verify proper wet film build. • Allow to dry. |
| <p>Trim Cap (Jewelite, Silvertrim)</p> | <ul style="list-style-type: none"> • Clean with 45 330SP Speed Prep Cleaner. • Scuff surface with Scotch-brite pad. • Clean again with 45 330SP Speed Prep Cleaner. • Apply 1 wet coat MAP Clear mixed with 47 474SP Flex Additive. • Allow 5–10 minutes to flash. • Apply 2nd wet coat of MAP Clear. • Verify proper wet film build. • Allow to dry. |



| Clear Coat | Process |
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| <p>Brass, Copper, or Cast Bronze</p> | <p><u>Spray Bond Adhesive:</u> <u>74 793SP Spray Bond Adhesive: RTS 7.12 – 7.16</u> <u>VOC</u></p> <ul style="list-style-type: none"> • Clean substrate to remove oils, contaminants, oxidation, and watermarks. • Texture surface with 400 grit sandpaper or Scotch-brite pad. • Clean surface with 45 330SP Speed Prep Cleaner. • Wipe substrate with a damp cloth of 74 737SP Braco Anti-Tarnish Pre-Treatment and allow to dry. Do not streak. • Apply 1 wet coat of 74 793SP Spray Bond Adhesive. • Do not allow 74 793SP Spray Bond Adhesive to dry before clear coating. • Allow 5-10 minutes to flash. • Apply 2nd wet coat of Spray Bond Adhesive. • Allow 5-10 minutes to flash. • Apply 1 wet coat MAP Clear. • Allow 5–10 minutes to flash. • Apply 2nd wet coat MAP Clear. • Verify proper wet film build. • Allow to dry. |
| <p>Luminore</p> | <p><u>Spray Bond Adhesive:</u> <u>74 793SP Spray Bond Adhesive: RTS 7.12 – 7.16</u> <u>VOC</u></p> <ul style="list-style-type: none"> • Clean with 45 330SP Speed Prep Cleaner. Apply 1 wet coat of 74 793SP Spray Bond Adhesive. • Do not allow 74 793SP Spray Bond Adhesive to dry before clear coating. • Allow 5–10 minutes to flash. • Apply 2nd wet coat of Spray Bond Adhesive. • Allow 5-10 minutes to flash. • Apply 1 wet coat MAP Clear. • Allow 5–10 minutes to flash. • Apply 2nd wet coat MAP Clear. • Verify proper wet film build. • Allow to dry. |



| Clear Coat | Process |
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| <p>Wood</p> <p>Test for the moisture content of the wood before any application. Wood moisture should be less than 13%. Certain applications using exterior decorative wood as a substrate may move too much for MPC to be used.</p> | <ul style="list-style-type: none">• Clean with 45 330SP Speed Prep Cleaner.• Sand any rough areas with 400-600 grit sand paper.• Remove dust with clean compressed air, tack cloth, or 45 330SP Speed Prep Cleaner.• Apply 1 wet coat MAP Clear.• Allow 5–10 minutes to flash.• Apply 2nd wet coat MAP Clear.• Verify proper wet film build.• Allow to dry.• All surface areas of the wood must be sealed. The less moisture in the wood is preferred. |