



MPC160

Tie Bond Adhesive

74 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 amber 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:

74 777SP Tie Bond Adhesive may be applied over:

- | | |
|----------------|---------------------------------------|
| Acrylic | Acrylonitrile Butadiene Styrene (ABS) |
| Photopolymers | Expanded Polyvinyl Chloride (PVC) |
| Polycarbonate* | Styrene |

Warning:

Tie Bond can not be used directly under 6125SP TactileClear™ or 6178SP HP Clear. (For information on using Tie Bond with these clears, refer to Technical Bulletin MPC168 TactileClear or MPC182 HP Clear.)

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.

* The use of Tie Bond or any Matthews Polyurethane topcoats over polycarbonate will alter its impact strength.

Required Products:

Reducers

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

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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.*

Mix Ratios:

Mix Ratios (by volume):



74 777SP Tie Bond	MAP Reducer
2 parts	1/2 - 1 1/2 parts

Tie 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: Apply 2-3 medium wet coats
Flash 15 minutes
Apply topcoat

Caution: Tie Bond contains strong aggressive solvents and should be applied with light drier spray techniques over sensitive plastics (i.e. polycarbonate) to minimize crazing and warping.

Directions for Use

Drying Times:



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

Tack Free	10 - 15 minutes
To Topcoat	5 - 10 minutes

Compatible Topcoats:

MAP® or VOC MAP® Colors

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

VOC Information

74 777SP Tie Bond	6.2
MAP Reducer (Conventional)	7.0 - 7.15
Ready to Spray (2 : 1/2 - 1 1/2)	6.4 - 6.6*

* Local regulations may exempt use of spray applied adhesion promoters for plastic from VOC considerations.

Performance Characteristics

Volume Solids	14.8%
Volume Solids RTS	8.4 - 11.8%
Theoretical Coverage (1 mil @ 100% transfer efficiency)	135 - 190 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)

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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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