Select your substrate from the list below.

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Important Notes

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the general public.

Before any spray applications, 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.

Investigate or consult with the substrate manufacturer for information regarding proper cleaning and preparation for specialty coatings. If you cannot find your substrate in this guide, contact the substrate manufacturer.

Products mentioned may be hazardous. Always follow proper safety precautions when using Matthews products. Safe usage requires reading, understanding and following all labels, SDS, and Technical Data Sheets before use.

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.

Keys to Success

Statements and methods described are based upon the best information and practices known to Matthews Paint.

The spray area and substrate must be warm and have adequate airflow. Application of primers, topcoats, and clearcoats should never take place in temperatures under 60ºF/16ºC.

Knock down sharp edges whether routed or cut. Round any dramatic sharp edges on substrate. Primer and paint topcoat films are weakest on sharp 90 degree edges.

Follow the procedures listed for specific substrate in this guide for cleaning, preparation and primer recommendations.

Follow spray equipment manufacturer’s instructions for gun set-up and proper air pressure recommendations.

We recommend testing the process for any new substrate, product or first time application procedures before permanent production begins. Periodic testing on application and adhesion confirms the product and production performance.

Review Technical Data Sheets or Matthews Reducer Selection Charts for reducer selection guidance. Remember that the change of seasons affect the temperature and humidity during application.

Allow proper flash time between coats. Flash times will vary dependent upon film thickness, temperature, solvent selection, spray gun set-up, application, etc. Additional coats may require extended flash time.

For additional information regarding color formulas, specifications, or technical questions, contact Matthews Paint at 800-323-6593 or visit our web site at www.matthewspaint.com.
Aluminum

- Use proper Personal Protective Equipment (PPE) during sanding and product application.

Non-Chromate Etch Primer:

74350SP/01 and 74351SP/01: RTS 3.5 VOC

- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 1 full wet coat Non-Chromate Etch Primer only.
- Allow 30 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

743528SP/01 Gray • 743530SP/01 White • 743531SP/01 Black

PT Filler:

74760SP/01: RTS 6.4 VOC

- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 2 full wet coats, allowing proper flash time between coats.
- Allow 30 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

HBPT Self-Etching Metal Treatment:

74770SP/01: RTS 6.13 VOC

- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 2 full wet coats, allowing proper flash time between coats.
- Allow 30 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

2.1 Epoxy Primers:

274528SP/01 Gray • 274530SP/01 White • 274531SP/01 Black

- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 1 to 2 full wet coats, allowing proper flash time between coats.
- Allow 30 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

Continued on next page...
Aluminum (Continued)

White Epoxy Primer or Black Epoxy Primer:

274908SP/01 or 274808SP/01: Both are RTS 3.90-3.95 VOC
- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible
- Clean again with appropriate cleaner.
- Apply 2 full wet coats, allowing proper flash time between coats.
- Allow 30 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

U-Prime:

274685SP/01: RTS 2.8 or 3.5 VOC
- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 2 full wet coats, allowing proper flash time between coats.
- Allow 30 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

Metal Pretreatment:

74734SP/01: RTS 6.34 VOC
- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 220 -320 grit, finishing sanding with the finest grit possible
- Clean again with appropriate cleaner.
- Apply 2 medium wet coats, allowing proper flash time between coats.
- Allow 30 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

74734SP/01 Metal Pretreatment not for use over sand-blasted, shot-blasted or media-blasted aluminum due to the product’s ZERO filling properties.

74780SP/01: RTS 6.04 VOC
- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible
- Clean again with appropriate cleaner.
- Apply 2 full wet coats, allowing proper flash time between coats.
- Allow 30 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

HBEF Self-Etching Metal Treatment:

74780SP/01: RTS 6.04 VOC
- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible
- Clean again with appropriate cleaner.
- Apply 2 full wet coats, allowing proper flash time between coats.
- Allow 30 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.
Aluminum (Continued)

White Epoxy Primer:

MAP-LVU100/01: RTS 0.42 VOC
- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 1 to 2 full wet coats allowing proper flash time between coats.
- Allow 30 minutes (spraying) or 1.5 - 2.5 hours (brush/roll) before topcoating.
- Topcoat per technical data sheet recommendations.

Gray Epoxy Primer:

6007SP/01: 3.5 VOC
- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 2 full wet coats, allowing proper flash time between coats.
- Allow 45 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

Polyester Primer Surfacer:

6001SP/01: RTS 1.8 VOC
- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Mix Polyester Primer Surfacer according to instructions (see text box).
- Apply 2 full wet coats, allowing proper flash time between coats.
- Apply additional coats as necessary to achieve desired filling.
- Allow 1.5 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

When spraying 6001SP/01 Polyester Primer Surfacer, it is important to refer to the technical sheets for spray tip details. We recommend the use of a 2.0 tip or larger in the spray gun. When activated, mix thoroughly and apply immediately. Clean equipment immediately.
2.1 Epoxy Primers:

274528SP/01 Gray • 274530SP/01 White • 274531SP/01 Black

- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 1 to 2 full wet coats, allowing proper flash time between coats.
- Allow 30 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

MAP-LVU100/01:

2.1 Epoxy Primers:

274908SP/01 or 274808SP/01: Both are RTS 3.90-3.95 VOC

- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 2 full wet coats, allowing proper flash time between coats.
- Allow 30 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

White Epoxy Primer:

MAP-LVU100/01: RTS 0.42 VOC

- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 1 to 2 full wet coats allowing proper flash time between coats.
- Allow 30 minutes (spraying) or 1.5 - 2.5 hours (brush/roll) before topcoating.
- Topcoat per technical data sheet recommendations.

Gray Epoxy Primer:

6007SP/01: 3.5 VOC

- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 2 full wet coats, allowing proper flash time between coats.
- Allow 45 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.
Aluminum Composite Sheets
Alucobond®, Dibond, Alumilite, Alupanel, and Ecopanel

- Use proper Personal Protective Equipment (PPE) during sanding and product application.
- Topcoat can be directly applied providing bare aluminum is not exposed after abrading. If bare aluminum is exposed, use epoxy primer application prior to topcoating.

Matthews Topcoat:
- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary using 320 - 400 grit or equivalent scuff pad until sheen has been removed.
- Clean again with appropriate cleaner.
- Topcoat per technical data sheet recommendations.

2.1 Epoxy Primers:
274528SP/01 Gray • 274530SP/01 White • 274531SP/01 Black
- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 1 to 2 full wet coats, allowing proper flash time between coats.
- Allow 30 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

White Epoxy Primer or Black Epoxy Primer:
274908SP/01 or 274808SP/01: Both are RTS 3.90-3.95 VOC
- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible
- Clean again with appropriate cleaner.
- Apply 2 full wet coats, allowing proper flash time between coats.
- Allow 30 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

White Epoxy Primer:
MAP-LVU100/01: RTS 0.42 VOC
- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 1 to 2 full wet coats allowing proper flash time between coats.
- Allow 30 minutes (spraying) or 1.5 - 2.5 hours (brush/roll) before topcoating.
- Topcoat per technical data sheet recommendations.

Continued on next page...
Aluminum Composite Sheets (Continued)

Gray Epoxy Primer:

6007SP/01: 3.5 VOC

- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 2 full wet coats, allowing proper flash time between coats.
- Allow 45 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

Steel

- Use proper Personal Protective Equipment (PPE) during sanding and product application.

2.1 Epoxy Primers:

274528SP/01 Gray • 274530SP/01 White • 274531SP/01 Black

- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 1 to 2 full wet coats, allowing proper flash time between coats.
- Allow 30 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

White Epoxy Primer or Black Epoxy Primer:

274908SP/01 or 274808SP/01: Both are RTS 3.90-3.95 VOC

- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 2 full wet coats, allowing proper flash time between coats.
- Allow 30 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.
Steel (Continued)

**White Epoxy Primer:**

**MAP-LVU100/01: RTS 0.42 VOC**
- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 1 to 2 full wet coats allowing proper flash time between coats.
- Allow 30 minutes (spraying) or 1.5 - 2.5 hours (brush/roll) before topcoating.
- Topcoat per technical data sheet recommendations.

**Gray Epoxy Primer:**

**6007SP/01: 3.5 VOC**
- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 2 full wet coats, allowing proper flash time between coats.
- Allow 45 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

**Non-Chromate Etch Primer:**

**74350SP/01 and 74351SP/01: RTS 3.5 VOC**
- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 1 full wet coat Non-Chromate Etch Primer only.
- Allow 30 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

**PT Filler:**

**74760SP/01: RTS 6.4 VOC**
- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 2 full wet coats, allowing proper flash time between coats.
- Allow 30 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.
Steel (Continued)

HBPT Self-Etching Metal Treatment:
74770SP/01: RTS 6.13 VOC
- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 2 full wet coats, allowing proper flash time between coats.
- Allow 30 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

HBEF Self-Etching Metal Treatment:
74780SP/01: RTS 6.04 VOC
- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 2 full wet coats, allowing proper flash time between coats.
- Allow 30 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

U-Prime:
274685SP/01: RTS 2.8 VOC
- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 2 full wet coats, allowing proper flash time between coats.
- Allow 30 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

Polyester Primer Surfacer:
6001SP/01: RTS 1.8 VOC
- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Mix Polyester Primer Surfacer according to instructions (see text box).
- Apply 2 full wet coats, allowing proper flash time between coats.
- Apply additional coats as necessary to achieve desired filling.
- Allow 1.5 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

When spraying 6001SP/01
Polyester Primer Surfacer, it
is important to refer to the
technical sheets for spray
tip details. We recommend
the use of a 2.0 tip or larger
in the spray gun. When
activated, mix thoroughly
and apply immediately.
Clean equipment
immediately.
Steel Carbon Steel, Cast Iron, Hot Dipped Galvanized, Galvaneal, Galvalume, Bonderized, Phosphate Coated, Passivators or Stabilizers

- Use proper Personal Protective Equipment (PPE) during sanding and product application.
- Many galvanized metal manufacturers apply an oil treatment to protect galvanized steel while in storage. This must be removed prior to abrading.
- If a passivator is present on the surface of galvanized steel, it should be completely removed before priming and topcoating.

2.1 Epoxy Primers:

274528SP/01 Gray • 274530SP/01 White • 274531SP/01 Black
- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 1 to 2 full wet coats, allowing proper flash time between coats.
- Allow 30 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

274908SP/01 or 274808SP/01: Both are RTS 3.90-3.95 VOC
- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 2 full wet coats, allowing proper flash time between coats.
- Allow 30 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

White Epoxy Primer or Black Epoxy Primer:

White Epoxy Primer:
MAP-LVU100/01: RTS 0.42 VOC
- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 1 to 2 full wet coats allowing proper flash time between coats.
- Allow 30 minutes (spraying) or 1.5 - 2.5 hours (brush/roll) before topcoating.
- Topcoat per technical data sheet recommendations.

Gray Epoxy Primer:

6007SP/01: 3.5 VOC
- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 2 full wet coats, allowing proper flash time between coats.
- Allow 45 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.
### Steel

- Use proper Personal Protective Equipment (PPE) during sanding and product application.

#### 2.1 Epoxy Primers:

**274528SP/01 Gray • 274530SP/01 White • 274531SP/01 Black**

- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 80 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 1 to 2 full wet coats, allowing proper flash time between coats.
- Allow 30 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

### Stainless

- Use proper Personal Protective Equipment (PPE) during sanding and product application.

#### 2.1 Epoxy Primers:

**274528SP/01 Gray • 274530SP/01 White • 274531SP/01 Black**

- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 220 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 1 to 2 full wet coats, allowing proper flash time between coats.
- Allow 30 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

### Powder Coated

- Use proper Personal Protective Equipment (PPE) during sanding and product application.

#### 2.1 Epoxy Primers:

**274528SP/01 Gray • 274530SP/01 White • 274531SP/01 Black**

- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 220 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 2 full wet coats, allowing proper flash time between coats.
- Allow 30 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

**White Epoxy Primer or Black Epoxy Primer:**

**274908SP/01 or 274808SP/01:** *Both are RTS 3.90-3.95 VOC*

- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 220 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 2 full wet coats, allowing proper flash time between coats.
- Allow 30 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

**White Epoxy Primer:**

**MAP-LVU100/01:** *RTS 0.42 VOC*

- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 220 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 1 to 2 full wet coats allowing proper flash time between coats.
- Allow 30 minutes (spraying) or 1.5 - 2.5 hours (brush/roll) before topcoating.
- Topcoat per technical data sheet recommendations.
Powder Coated (Continued):

Gray Epoxy Primer:

6007SP/01: 3.5 VOC

- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 220 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 2 full wet coats, allowing proper flash time between coats.
- Allow 45 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

Steel or Aluminum Repairs

Previously Primed and/or Painted Surfaces

- Use proper Personal Protective Equipment (PPE) during sanding and product application.
- Inspect existing coating for any delaminating or degradation to determine if existing coating should be removed. If so, repair or strip as necessary.

2.1 Epoxy Primers:

274528SP/01 Gray • 274530SP/01 White • 274531SP/01 Black

- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 1 to 2 full wet coats, allowing proper flash time between coats.
- Allow 30 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

White Epoxy Primer or Black Epoxy Primer:

274908SP/01 or 274808SP/01: Both are RTS 3.90-3.95 VOC

- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 2 full wet coats, allowing proper flash time between coats.
- Allow 30 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

Continued on next page...
Steel or Aluminum Repairs (Continued)

Polyester Primer Surfacer:

6001SP/01: **RTS 1.8 VOC**
- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Mix Polyester Primer Surfacer according to instructions (see text box).
- Apply 2 full wet coats, allowing proper flash time between coats.
- Apply additional coats as necessary to achieve desired filling.
- Allow 1.5 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

U-Prime:

274685SP/01: **RTS 2.8 or 3.5 VOC**
- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 2 full wet coats, allowing proper flash time between coats.
- Allow 30 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

White Epoxy Primer:

MAP-LVU100/01: **RTS 0.42 VOC**
- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 1 to 2 full wet coats allowing proper flash time between coats.
- Allow 30 minutes (spraying) or 1.5 - 2.5 hours (brush/roll) before topcoating.
- Topcoat per technical data sheet recommendations.

Gray Epoxy Primer:

6007SP/01: **3.5 VOC**
- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 2 full wet coats, allowing proper flash time between coats.
- Allow 45 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.
Painted Surfaces  Matthews or Unidentified Finishes

- Use proper Personal Protective Equipment (PPE) during sanding and product application.
- Always test painted surface for compatibility before use of Matthews primers and topcoats.
- Inspect existing coating for any delaminating or degradation to determine if existing coating should be removed. If so, repair or strip as necessary.

Matthews Topcoat Option (No Primer):
If existing finish is fully cured and sound, Matthews Topcoat can be applied directly without primer.
- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 220 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Important: if bare substrate has been exposed, an appropriate Matthews Primer must be applied before topcoating.
- Topcoat per technical data sheet recommendations.

2.1 Epoxy Primers:
274528SP/01 Gray • 274530SP/01 White • 274531SP/01 Black
- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 1 to 2 full wet coats, allowing proper flash time between coats.
- Allow 30 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

White Epoxy Primer or Black Epoxy Primer:
274908SP/01 or 274808SP/01: Both are RTS 3.90-3.95 VOC
- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 2 full wet coats, allowing proper flash time between coats.
- Allow 30 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

White Epoxy Primer:
MAP-LVU100/01: RTS 0.42 VOC
- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 1 to 2 full wet coats allowing proper flash time between coats.
- Allow 30 minutes (spraying) or 1.5 - 2.5 hours (brush/roll) before topcoating.
- Topcoat per technical data sheet recommendations.

Gray Epoxy Primer:
6007SP/01: 3.5 VOC
- Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Apply 2 full wet coats, allowing proper flash time between coats.
- Allow 45 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.
Acrylic

- Use proper Personal Protective Equipment (PPE) during product application.
- 6405SP/01 or 6410SP/01 can be used as cleaners in VOC regulated areas but will not provide the same anti-static properties of the non-compliant 6428SP/01 Plastic Prep.
- Matthews strongly recommends the use of Tie Bond as an adhesive over acrylcs to ensure proper adhesion.

Tie Bond Adhesive:

274777SP/01: RTS 0 VOC

- Clean with 6428SP/01 Plastic Prep, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Apply a mist coat of 6428SP/01 Plastic Prep and allow to dry in order to reduce static surface charge.
- Apply 2 -3 medium wet coats, allowing proper flash time between coats.
- Allow 5-10 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

74777SP/01: RTS 6.4 - 6.6 VOC

- Clean with 6428SP/01 Plastic Prep, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Apply a mist coat of 6428SP Plastic Prep and allow to dry in order to reduce static surface charge.
- Apply 2 -3 medium wet coats, allowing proper flash time between coats.
- Allow 5-10 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

Acrylic  Laser-cut, Router-cut, Flame-treated

- Use proper Personal Protective Equipment (PPE) during product application.
- 6405SP/01 or 6410SP/01 can be used as cleaners in VOC regulated areas but will not provide the same anti-static properties of the non-compliant 6428SP/01 Plastic Prep.
- 6428SP/01 may be too aggressive for laser-cut acrylic.
- Matthews strongly recommends the use of Tie Bond as an adhesive over acrylcs to ensure proper adhesion.
- To avoid crazing on edges of laser-cut acrylic, use a lower temperature setting.

Tie Bond Adhesive:

274777SP/01: RTS 0 VOC

- Clean with 6405SP/01 Low VOC Cleaner or 6410SP/01 Low VOC PreCleaner.
- Apply a mist coat of 6428SP/01 Plastic Prep and allow to dry in order to reduce static surface charge.
- Apply 2 -3 medium wet coats, allowing proper flash time between coats.
- Allow 5-10 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.
Acrylonitrile Butadiene Styrene (ABS)

## Banner Up

- Use proper Personal Protective Equipment (PPE) during product application.
- 6405SP/01 or 6410SP/01 can be used as cleaners in VOC regulated areas but will not provide the same anti-static properties of the non-compliant 6428SP/01 Plastic Prep.

## Matthews Topcoat:

- Clean with 6428SP/01 Plastic Prep, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Topcoat per technical data sheet recommendations.

## Body Filler

- Use proper Personal Protective Equipment (PPE) during sanding and product application.

## Polyester Primer Surfacer:

**6001SP/01: RTS 1.8 VOC**

- Block sand body filler as necessary with 80-180 grit, finishing sanding with the finest grit possible.
- Clean area surrounding the repair* with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Sand or scuff areas around repair as necessary with 180-320 grit, finishing sanding with the finest grit possible.
- Clean area surrounding the repair* again with appropriate cleaner.
- Mix Polyester Primer Surfacer according to instructions (see text box).
- Apply 2 full wet coats, allowing proper flash time between coats.
- Apply additional coats as necessary to achieve desired filling.
- Allow 1.5 hours dry time before block sanding with 220-320 grit and recleaning.
- Apply epoxy primer or urethane primer followed by topcoat per technical data sheet recommendations.

*NOTE: Cleaner should never come in contact with body filler.*

When spraying 6001SP/01 Polyester Primer Surfacer, it is important to refer to the technical sheets for spray tip details. We recommend the use of a 2.0 tip or larger in the spray gun. When activated, mix thoroughly and apply immediately. Clean equipment immediately.
**PVC** Expanded and Non Expanded  
(Komatex, Sintra, Celtec, Intacel, EX-Cel, and Trovicel)

- Use proper Personal Protective Equipment (PPE) during sanding and product application.  
- 6405SP/01 or 6410SP/01 can be used as cleaners in VOC regulated areas but will not provide the same anti-static properties of the non-compliant 6428SP/01 Plastic Prep.  
- For exterior application, it is important to completely encapsulate the entire PVC substrate to prevent warping.

If Side Fill is required, apply 6001SP Polyester Primer Surfacer on rough sides prior to topcoating:

- Using a roller, apply 1-3 coats of 6001SP/01 Polyester Primer Surfacer on rough side sections only (do not apply 6001SP/01 to face of the PVC).  
- Allow 1.5 hours to dry.  
- Sand to desired smoothness.  
- Clean with 6405SP/01 Low VOC Cleaner or 6410SP/01 Low VOC PreCleaner.  
- Apply Tie Bond Adhesive as per technical data sheet recommendations.  
- Topcoat per technical data sheet recommendations.

**Tie Bond Adhesive:**

**274777SP/01: RTS 0 VOC**

- Clean with 6428SP/01 Plastic Prep, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.  
- Apply a mist coat of 6428SP/01 Plastic Prep and allow to dry in order to reduce static surface charge.  
- Apply 2 -3 medium wet coats, allowing proper flash time between coats.  
- Allow 5-10 minutes to flash before topcoating.  
- Topcoat per technical data sheet recommendations.

**Tie Bond Adhesive:**

**74777SP/01: RTS 6.4 - 6.6 VOC**

- Clean with 6428SP/01 Plastic Prep, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.  
- Apply a mist coat of 6428SP/01 Plastic Prep and allow to dry in order to reduce static surface charge.  
- Apply 2 -3 medium wet coats, allowing proper flash time between coats.  
- Allow 5-10 minutes to flash before topcoating.  
- Topcoat per technical data sheet recommendations.
Photopolymer Nova (NovAcryl PT and NovAcryl EX)

- Use proper Personal Protective Equipment (PPE) during product application.
- 6405SP/01 or 6410SP/01 can be used as cleaners in VOC regulated areas but will not provide the same anti-static properties of the non-compliant 6428SP/01 Plastic Prep.

First Surface Painting (Tie Bond not needed):
- Clean with 6428SP/01 Plastic Prep, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner using a short-bristled brush.
- While surface is still wet, blow dry with compressed air.
- Apply a mist coat of 6428SP/01 Plastic Prep and allow to dry in order to reduce static surface charge.
- Topcoat or Clearcoat directly per technical data sheet recommendations.

Optional Second Surface Painting of NovAcryl PT (Tie Bond not needed):
- Clean with 6428SP/01 Plastic Prep, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner using a short-bristled brush.
- While surface is still wet, blow dry with compressed air.
- Apply a mist coat of 6428SP/01 Plastic Prep and allow to dry in order to reduce static surface charge.
- Topcoat second surface directly per technical data sheet recommendations.
- Important! When applying paint to second surface NovAcryl PT, you must clearcoat the first surface to protect the photopolymer. Apply clearcoat per technical data sheet recommendations.

Photopolymer Nova (NovAcryl LP, NovAcryl ECR-3, NovAcryl AL and Permaglow)

- Use proper Personal Protective Equipment (PPE) during product application.
- 6405SP/01 or 6410SP/01 can be used as cleaners in VOC regulated areas but will not provide the same anti-static properties of the non-compliant 6428SP/01 Plastic Prep.

First Surface Coating:
- Clean with 6428SP/01 Plastic Prep, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner using a short-bristled brush.
- While surface is still wet, blow dry with compressed air.
- Apply a mist coat of 6428SP Plastic Prep and allow to dry in order to reduce static surface charge.
- Clearcoat directly per technical data sheet recommendations.
Photopolymer  Jet

- Use proper Personal Protective Equipment (PPE) during product application.
- 6405SP/01 or 6410SP/01 can be used as cleaners in VOC regulated areas but will not provide the same anti-static properties of the non-compliant 6428SP/01 Plastic Prep.

Tie Bond Adhesive:

274777SP/01: RTS 0 VOC

- Clean with 6428SP/01 Plastic Prep, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Apply a mist coat of 6428SP/01 Plastic Prep and allow to dry in order to reduce static surface charge.
- Apply 2 -3 medium wet coats, allowing proper flash time between coats.
- Allow 5-10 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

Tie Bond Adhesive:

74777SP/01: RTS 6.4 - 6.6 VOC

- Clean with 6428SP/01 Plastic Prep, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Apply a mist coat of 6428SP/01 Plastic Prep and allow to dry in order to reduce static surface charge.
- Apply 2 -3 medium wet coats, allowing proper flash time between coats.
- Allow 5-10 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

Copolyesters, PETG and Mustang (Plaskolite)

We do not recommend coating copolyesters and PETG substrates with Matthews.

3D Printing Massivit

- Use proper Personal Protective Equipment (PPE) during product application.
- 6405SP/01 or 6410SP/01 can be used as cleaners in VOC regulated areas but will not provide the same anti-static properties of the non-compliant 6428SP/01 Plastic Prep.

Matthews Topcoat:

- Clean with 6428SP/01 Plastic Prep, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Topcoat per technical data sheet recommendations.
Polycarbonate

- Use proper Personal Protective Equipment (PPE) during product application.
- Polycarbonate manufacturers recommend that all moisture be heat-purged out of substrate before coating application.
- Application of any primer, adhesive, or topcoat will alter this substrate’s impact strength.
- 6405SP/01 or 6410SP/01 can be used as cleaners in VOC regulated areas but will not provide the same anti-static properties of the non-compliant 6428SP/01 Plastic Prep.
- 6428SP/01 may be too aggressive for polycarbonate.
- For translucent finishes, Lacryl 400 Series Translucent Spray Paint should be used (refer to Technical Data Sheet L400).

Tie Bond Adhesive:
274777SP/01: RTS 0 VOC
- Clean with 6428SP/01 Plastic Prep, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Apply a mist coat of 6428SP/01 Plastic Prep and allow to dry in order to reduce static surface charge.
- Apply 2-3 medium wet coats, allowing proper flash time between coats.
- Allow 5-10 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

Tie Bond Adhesive:
74777SP/01: RTS 6.4 - 6.6 VOC
- Clean with 6428SP/01 Plastic Prep, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Apply a mist coat of 6428SP/01 Plastic Prep and allow to dry in order to reduce static surface charge.
- Apply 2-3 medium wet coats, allowing proper flash time between coats.
- Allow 5-10 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

Matthews Basecoat Option (No Tie Bond):
- Clean with 6428SP/01 Plastic Prep, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Apply a mist coat of 6428SP/01 Plastic Prep and allow to dry in order to reduce static surface charge.
- Apply 1 light coat of converted Matthews basecoat (SOA, N, or SVOC) as barrier coat (refer to technical data sheet for 287103SP/01 Low VOC Basecoat Converter).
- Allow 10-15 minutes to flash.
- Apply additional coats to achieve desired color and coverage.
- NOTE: For first surface painting, apply Clearcoat per technical data sheet recommendations.

Some Polycarbonates can be sensitive to crazing when using 74777SP/01 Tie Bond. Using Matthews converted basecoat (SOA, N, or SVOC) instead of 74777SP/01 is a less aggressive option.
Vinyl

- Use proper Personal Protective Equipment (PPE) during product application.
- 6405SP/01 or 6410SP/01 can be used as cleaners in VOC regulated areas but will not provide the same anti-static properties of the non-compliant 6428SP/01 Plastic Prep.
- Flex additive is not required when applying Matthews Topcoat to completed pre-applied vinyl.

Tie Bond Adhesive:

**274777SP/01: RTS 0 VOC**
- Clean with 6428SP/01 Plastic Prep, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Apply 2 - 3 medium wet coats, allowing proper flash time between coats.
- Allow 5-10 minutes to flash before topcoating.
- SOA, N, or SVOC topcoat: mix with 47474SP/04 Flex Additive per technical data sheet recommendations.
- MAP-LV topcoats do not require flex additive.
- Topcoat per technical data sheet recommendations.

**74777SP/01: RTS 6.4 - 6.6 VOC**
- Clean with 6428SP/01 Plastic Prep, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Apply 2 - 3 medium wet coats, allowing proper flash time between coats.
- Allow 5-10 minutes to flash before topcoating.
- SOA, N, or SVOC topcoat: mix with 47474SP/04 Flex Additive per technical data sheet recommendations.
- MAP-LV topcoats do not require flex additive.
- Topcoat per technical data sheet recommendations.

Matthews Topcoat Option (No Tie Bond):
- Clean with 6428SP/01 Plastic Prep, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade with scuff pad.
- Clean again with appropriate cleaner.
- Topcoat per technical data sheet recommendations.
**Trim Cap**  
*Jewelite*

- Use proper Personal Protective Equipment (PPE) during product application.
- **6405SP/01 or 6410SP/01** can be used as cleaners in VOC regulated areas but will not provide the same anti-static properties of the non-compliant **6428SP/01 Plastic Prep**.
- Flex additive is **not required** when applying Matthews Topcoat to completed pre-applied trim cap.

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**Tie Bond Adhesive:**

**274777SP/01: RTS 0 VOC**

- Clean with 6428SP/01 Plastic Prep, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Apply 2 - 3 medium wet coats, allowing proper flash time between coats.
- Allow 5 - 10 minutes to flash before topcoating.
- SOA, N, or SVOC topcoat: mix with 47474SP/04 Flex Additive per technical data sheet recommendations.
- MAP-LV topcoats do not require flex additive.
- Topcoat per technical data sheet recommendations.

**74777SP/01: RTS 6.4 - 6.6 VOC**

- Clean with 6428SP/01 Plastic Prep, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Apply 2 - 3 medium wet coats, allowing proper flash time between coats.
- Allow 5 - 10 minutes to flash before topcoating.
- SOA, N, or SVOC topcoat: mix with 47474SP/04 Flex Additive per technical data sheet recommendations.
- MAP-LV topcoats do not require flex additive.
- Topcoat per technical data sheet recommendations.

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**EPS-Polystyrene**  
*Gator Foam*

- Use proper Personal Protective Equipment (PPE) during sanding and product application.

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**Acrylic Latex Primer:**

- Clean substrate with clean compressed air.
- Apply latex exterior primer in order to fill and seal the entire foam surface areas.
- Allow to dry for at least 60 minutes.
- Scuff surface with scuff pad.
- Clean 6405SP/01 Low VOC Cleaner or 6410SP/01 Low VOC PreCleaner.
- Topcoat per technical data sheet recommendations.
Flexible Face (Cooley)

- Use proper Personal Protective Equipment (PPE) during product application.
- 6405SP/01 or 6410SP/01 can be used as cleaners in VOC regulated areas but will not provide the same anti-static properties of the non-compliant 6428SP/01 Plastic Prep.

Tie Bond Adhesive:

274777SP/01: RTS 0 VOC
- Clean with 6428SP/01 Plastic Prep, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Apply 2 - 3 medium wet coats, allowing proper flash time between coats.
- Allow 5 - 10 minutes to flash before topcoating.
- SOA, N, or SVOC topcoat: mix with 47474SP/04 Flex Additive per technical data sheet recommendations.
- MAP-LV topcoats do not require flex additive.
- Topcoat per technical data sheet recommendations.

Tie Bond Adhesive:

74777SP/01: RTS 6.4 - 6.6 VOC
- Clean with 6428SP/01 Plastic Prep, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Apply 2 - 3 medium wet coats, allowing proper flash time between coats.
- Allow 5 - 10 minutes to flash before topcoating.
- SOA, N, or SVOC topcoat: mix with 47474SP/04 Flex Additive per technical data sheet recommendations.
- MAP-LV topcoats do not require flex additive.
- Topcoat per technical data sheet recommendations.

Polypropylene and Polyethylene

- Requires Flame or Corona treatment in order to alter the surface molecular structure, which allows a limited time period for the substrate to be paint receptive. All propylene and ethylene structures are different, so test for adhesion.
- Clean with 6428SP/01 Plastic Prep.
- Topcoat per technical data sheet recommendations.

Glass and Porcelain

We do not recommend coating glass or porcelain with Matthews.
Wood (Including MDO, MDF, and Extira)

- Use proper Personal Protective Equipment (PPE) during sanding and product application.
- Certain applications using exterior wood as a substrate will expand and/or contract too much for Matthews to be used.
- For exterior application, it is important to completely encapsulate the entire substrate to prevent moisture penetration.

General Cleaning and Preparation Steps:
- Test moisture level of substrate. Moisture level should be less than 13%.
- Remove debris with clean compressed air.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Remove dust with clean compressed air and tack rag.
- If heavy filling/blocking is required to fill grain, knots, or other imperfections, 6001SP/01 Polyester Primer Surfacer provides the most fill. Otherwise, any Matthew Epoxy primer can be used.

Polyester Primer Surfacer:

6001SP/01: RTS 1.8 VOC
- Blow off substrate with clean compressed air.
- Mix Polyester Primer Surfacer according to instructions (see text box).
- Apply 2 full wet coats, allowing proper flash time between coats.
- Apply additional coats as necessary to achieve desired filling.
- Allow 1.5 hours dry time before sanding with 220-320 grit.
- Clean* with 45330SP/01 Speed Prep, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Apply epoxy primer or urethane primer followed by topcoat per technical data sheet recommendations.
*NOTE: Cleaner should never come in contact with exposed wood.

U-Prime:

274685SP/01: RTS 2.8 VOC
- Blow off substrate with clean compressed air.
- Apply 2 full wet coats, allowing proper flash time between coats.
- Apply additional coats as necessary to achieve desired filling.
- Allow 16 hours dry time before sanding with 220-320 grit.
- Clean* with 45330SP/01 Speed Prep, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Apply epoxy primer or urethane primer followed by topcoat per technical data sheet recommendations.
*NOTE: Cleaner should never come in contact with exposed wood.

Continued on next page...
Wood (Continued) (Including MDO, MDF, and Extira)

White Epoxy Primer or Black Epoxy Primer:
274908SP/01 or 274808SP/01: Both are RTS 3.90-3.95 VOC
- Blow off substrate with clean compressed air.
- Apply 2 full wet coats, allowing proper flash time between coats.
- Apply additional coats as necessary to achieve total dry film thickness.
- Allow 30 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

Gray Epoxy Primer:
6007SP/01: 3.5 VOC
- Blow off substrate with clean compressed air.
- Apply 2 full wet coats, allowing proper flash time between coats.
- Apply additional coats as necessary to achieve total dry film thickness.
- Allow 45 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

White Epoxy Primer:
MAP-LVU100/01: RTS 0.42 VOC
- Blow off substrate with clean compressed air.
- Apply 1 to 2 full wet coats allowing proper flash time between coats.
- Allow 30 minutes (spraying) or 1.5 - 2.5 hours (brush/roll) before topcoating.
- Topcoat per technical data sheet recommendations.

2.1 Epoxy Primers:
274528SP/01 Gray • 274530SP/01 White • 274531SP/01 Black
- Blow off substrate with clean compressed air.
- Apply 2 full wet coats, allowing proper flash time between coats.
- Apply additional coats as necessary to achieve total dry film thickness.
- Allow 30 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

Scooter Board
- Use proper Personal Protective Equipment (PPE) during sanding and product application.

Tie Bond Adhesive:
274777SP/01: RTS 0 VOC
- Remove dust with clean compressed air and tack rag.
- Abrade as necessary with 220 -320 grit, finishing sanding with the finest grit possible.
- Remove dust with clean compressed air and tack rag.
- Apply 2 -3 medium wet coats, allowing proper flash time between coats.
- Allow 5-10 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.
**Scooter Board (Continued)**

**Tie Bond Adhesive:**

74777SP/01: RTS 6.4 - 6.6 VOC
- Remove dust with clean compressed air and tack rag.
- Abrade as necessary with 220 -320 grit, finishing sanding with the finest grit possible.
- Remove dust with clean compressed air and tack rag.
- Apply 2 -3 medium wet coats, allowing proper flash time between coats.
- Allow 5-10 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

**Fiberglass Non Gel-Coated (Raw)**

- Use proper Personal Protective Equipment (PPE) during sanding and product application.

**Polyester Primer Surfacer:**

6001SP/01: RTS 1.8 VOC
- Remove dust with clean compressed air and tack rag.
- Abrade as necessary with 180 -320 grit, finishing sanding with the finest grit possible.
- Remove dust with clean compressed air and tack rag.
- Mix Polyester Primer Surfacer according to instructions (see text box).
- Apply 2 full wet coats, allowing proper flash time between coats.
- Apply additional coats as necessary to achieve desired filling.
- Allow 1.5 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.

When spraying 6001SP/01 Polyester Primer Surfacer, it is important to refer to the technical sheets for spray tip details. We recommend the use of a 2.0 tip or larger in the spray gun. When activated, mix thoroughly and apply immediately. Clean equipment immediately.

**White Epoxy Primer or Black Epoxy Primer:**

274908SP/01 or 274808SP/01: Both are RTS 3.90-3.95 VOC
- Remove dust with clean compressed air and tack rag.
- Abrade as necessary with 180 -320 grit, finishing sanding with the finest grit possible.
- Remove dust with clean compressed air and tack rag.
- Apply 2 full wet coats, allowing proper flash time between coats.
- Apply additional coats as necessary to achieve total dry film thickness.
- Allow 24 hours dry time before sanding, cleaning and topcoating.
- Topcoat per technical data sheet recommendations.
Fiberglass Gel-Coated

- Use proper Personal Protective Equipment (PPE) during sanding and product application.
- 6405SP/01 or 6410SP/01 can be used as cleaners in VOC regulated areas but will not provide the same anti-static properties of the non-compliant 6428SP/01 Plastic Prep.
- All mold release agent must be removed prior to sanding. Multiple cleaning steps may be required.

Matthews Topcoat:
- Thoroughly clean with 6428SP/01 Plastic Prep, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade as necessary using 320-400 grit, finishing sanding with the finest grit possible.
- Clean again with appropriate cleaner.
- Topcoat per technical data sheet recommendations.

HDU or Polyurethane Foam Board
Poly Board, Sign Foam, Precision Board, Jasper Board, Corafoam®/Dunaboard

- Use proper Personal Protective Equipment (PPE) during sanding and product application.

Polyester Primer Surfacer:
6001SP/01: RTS 1.8 VOC
- Blow off substrate with clean compressed air.
- Mix Polyester Primer Surfacer according to instructions (see text box).
- Apply 2 full wet coats, allowing proper flash time between coats.
- Apply additional coats as necessary to achieve desired filling.
- Allow 1.5 hours dry time before sanding with 220-320 grit.
- Clean* with 45330SP/01 Speed Prep, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Apply epoxy primer or urethane primer followed by topcoat per technical data sheet recommendations.
*NOTE: Cleaner should never come in contact with exposed foam.

U-Prime:
274685SP/01: RTS 2.8 VOC
- Blow off substrate with clean compressed air.
- Apply 2 full wet coats, allowing proper flash time between coats.
- Apply additional coats as necessary to achieve desired filling.
- Allow 16 hours dry time before sanding with 220-320 grit.
- Clean* with 45330SP/01 Speed Prep, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Apply epoxy primer or urethane primer followed by topcoat per technical data sheet recommendations.
*NOTE: Cleaner should never come in contact with exposed foam.
Granite

• Use proper Personal Protective Equipment (PPE) during sanding and product application.

2.1 Epoxy Primers:

274528SP/01 Gray • 274530SP/01 White • 274531SP/01 Black

• Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
• Sandblast or abrade as necessary with 180 -320 grit, finishing sanding with the finest grit possible.
• Clean again with appropriate cleaner (for sandblasted granite, blow off with clean compressed air only).
• Apply 1 to 2 full wet coats, allowing proper flash time between coats.
• Allow 30 minutes to flash before topcoating.
• Topcoat per technical data sheet recommendations.

White Epoxy Primer or Black Epoxy Primer:

274908SP/01 or 274808SP/01: Both are RTS 3.90-3.95 VOC

• Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
• Sandblast or abrade as necessary with 180 -320 grit, finishing sanding with the finest grit possible.
• Clean again with appropriate cleaner (for sandblasted granite, blow off with clean compressed air only).
• Apply 2 full wet coats, allowing proper flash time between coats.
• Allow 30 minutes to flash before topcoating.
• Topcoat per technical data sheet recommendations.

White Epoxy Primer:

MAP-LVU100/01: RTS 0.42 VOC

• Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
• Sandblast or abrade as necessary with 180 -320 grit, finishing sanding with the finest grit possible.
• Clean again with appropriate cleaner (for sandblasted granite, blow off with clean compressed air only).
• Apply 1 to 2 full wet coats, allowing proper flash time between coats.
• Allow 30 minutes to flash before topcoating.
• Topcoat per technical data sheet recommendations.

Gray Epoxy Primer:

6007SP/01: 3.5 VOC

• Clean with 45330SP/01 Speed Prep Cleaner, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
• Sandblast or abrade as necessary with 180 -320 grit, finishing sanding with the finest grit possible.
• Clean again with appropriate cleaner (for sandblasted granite, blow off with clean compressed air only).
• Apply 2 full wet coats, allowing proper flash time between coats.
• Allow 45 minutes to flash before topcoating.
• Topcoat per technical data sheet recommendations.
Cement Bare

- Use proper Personal Protective Equipment (PPE) during preparation and product application.

General Cleaning and Preparation Steps:
- Pay careful attention to these instructions, as they are very important to follow properly!
- Pressure-clean entire surface with 2000 PSI at 3-5 GPM (Gallons Per Minute).
- Clean with 5% Muriatic acid and water solution. (Use recommended safety instructions from Muriatic acid manufacturer!)
- Rinse well with water and allow to dry.
- Remove debris with compressed air.
- Test PH 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)
- Test moisture level of substrate. Moisture level should be less than 13%.
- Important: Failure to ensure that moisture and PH levels are within recommended limits will result in apparent or eventual coating failure.
- Apply Primer and Topcoat per recommendations below.

2.1 Epoxy Primers:
274528SP/01 Gray • 274530SP/01 White • 274531SP/01 Black
- Apply 1 to 2 full wet coats, allowing proper flash time between coats.
- Allow 30 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

White Epoxy Primer or Black Epoxy Primer:
274908SP/01 or 274808SP/01: Both are RTS 3.90-3.95 VOC
- Apply 2 full wet coats, allowing proper flash time between coats.
- Allow 30 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

White Epoxy Primer:
MAP-LVU100/01: RTS 0.42 VOC
- Apply 1 to 2 full wet coats, allowing proper flash time between coats.
- Allow 30 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.

Gray Epoxy Primer:
6007SP/01: 3.5 VOC
- Apply 2 full wet coats, allowing proper flash time between coats.
- Allow 45 minutes to flash before topcoating.
- Topcoat per technical data sheet recommendations.
Matthews Paint Substrate Preparation Recommendations. These recommendations are to be used as general guidelines only.

Matthews Topcoat (Color)

- Use proper Personal Protective Equipment (PPE) during sanding and product application.

Immediately following the application of Matthews Topcoat:
- Allow topcoat 15 minutes to flash.
- Apply 2 full wet coats of Matthews Clear, allowing proper flash time between coats.

If topcoat is allowed to dry more than 24 hours:
- Clean with appropriate Matthews cleaner.
- Lightly dry scuff sand with 320 - 400g by hand/machine or wet sand with 600g.
- Clean again with appropriate cleaner.
- Apply 2 full wet coats of Matthews Clear, allowing proper flash time between coats.

Aluminum, Brass, Copper, or Bronze

- Use proper Personal Protective Equipment (PPE) during sanding and product application.
- Chamfer or knock down all sharp edges before applying Spray Bond.
- For Brass and Copper, 42260SP/01 and 282260SP/01 Braco Clears contain an anti-tarnish agent.

Spray Bond Adhesive:

**274793SP/01: RTS 0 VOC**

- Clean with 45330/01 Speed Prep, 6405SP/01 Low VOC Cleaner or 6410SP/01 Low VOC PreCleaner.
- Apply 2 -3 light to medium coats, allowing proper flash time between coats.
- Allow 5-10 minutes to flash before clearcoating.
- Clearcoat per technical data sheet recommendations.
Acrylic

- Use proper Personal Protective Equipment (PPE) during product application.
- 6405SP/01 or 6410SP/01 can be used as cleaners in VOC regulated areas but will not provide the same anti-static properties of the non-compliant 6428SP/01 Plastic Prep.
- 6428SP/01 may be too aggressive for laser-cut acrylic.

Tie Bond Adhesive:

274777SP/01: RTS 0 VOC
- Clean with 6428SP/01 Plastic Prep, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Apply a mist coat of 6428SP/01 Plastic Prep and allow to dry in order to reduce static surface charge.
- Apply 2 -3 medium wet coats, allowing proper flash time between coats.
- Allow 5 - 10 minutes to flash before clearcoating.
- Clearcoat per technical data sheet recommendations.

Laser-cut, Router-cut, and Flame-treated acrylics can be susceptible to crazing on the edges. Use lower temperature settings if possible and prime with 274777SP/01 Tie Bond only.

Tie Bond Adhesive:

74777SP/01: RTS 6.4 - 6.6 VOC
- Clean with 6428SP/01 Plastic Prep, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Apply a mist coat of 6428SP/01 Plastic Prep and allow to dry in order to reduce static surface charge.
- Apply 2 -3 medium wet coats, allowing proper flash time between coats.
- Allow 5 - 10 minutes to flash before clearcoating.
- Clearcoat per technical data sheet recommendations.
Polycarbonate

- Use proper Personal Protective Equipment (PPE) during product application.
- Polycarbonate manufacturers recommend that all moisture be heat-purged out of substrate before coating application.
- Application of any primer, adhesive, or topcoat will alter this substrate’s impact strength.
- 6405SP/01 or 6410SP/01 can be used as cleaners in VOC regulated areas but will not provide the same anti-static properties of the non-compliant 6428SP/01 Plastic Prep.
- 6428SP/01 may be too aggressive for polycarbonate.

Tie Bond Adhesive:

274777SP/01: RTS 0 VOC
- Clean with 6428SP/01 Plastic Prep, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Apply a mist coat of 6428SP/01 Plastic Prep and allow to dry in order to reduce static surface charge.
- Apply 2-3 medium wet coats, allowing proper flash time between coats.
- Allow 5-10 minutes to flash before clearcoating.
- Clearcoat per technical data sheet recommendations.

74777SP/01: RTS 6.4 - 6.6 VOC
- Clean with 6428SP/01 Plastic Prep, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Apply a mist coat of 6428SP/01 Plastic Prep and allow to dry in order to reduce static surface charge.
- Apply 2-3 medium wet coats, allowing proper flash time between coats.
- Allow 5-10 minutes to flash before clearcoating.
- Clearcoat per technical data sheet recommendations.

Matthews Converted Clearcoat Option (No Tie Bond):
- Clean with 6428SP/01 Plastic Prep, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Apply a mist coat of 6428SP/01 Plastic Prep and allow to dry in order to reduce static surface charge.
- Apply 1 light coat of converted Matthews clear (conventional or Low VOC*) as barrier coat (refer to technical data sheet for 287103SP/01 Low VOC Basecoat Converter).
- Allow 10-15 minutes to flash.
- Apply clearcoat per technical data sheet recommendations.
*287103SP/01 is not to be used in MAP-LV Ultra Low clearcoats

Some Polycarbonates can be sensitive to crazing when using Tie Bond. Using Matthews converted clearcoats (excluding MAP-LVC clearcoats) instead of 74777SP/01 is a less aggressive option.
Vinyl

- Use proper Personal Protective Equipment (PPE) during product application.
- 6405SP/01 or 6410SP/01 can be used as cleaners in VOC regulated areas but will not provide the same anti-static properties of the non-compliant 6428SP/01 Plastic Prep.
- Flex additive is not required when applying Matthews Topcoat to completed pre-applied vinyl.

**Tie Bond Adhesive:**

**274777SP/01: RTS 0 VOC**

- Clean with 6428SP/01 Plastic Prep, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Apply 2 - 3 medium wet coats, allowing proper flash time between coats.
- Allow 5 - 10 minutes to flash before clearcoating.
- Conventional or Low VOC clears: mix with 47474SP/01 Flex Additive per technical data sheet recommendations.
- MAP-LV topcoats do not require flex additive.
- Clearcoat per technical data sheet recommendations.

**Tie Bond Adhesive:**

**74777SP/01: RTS 6.4 - 6.6 VOC**

- Clean with 6428SP/01 Plastic Prep, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Apply 2 - 3 medium wet coats, allowing proper flash time between coats.
- Allow 5 - 10 minutes to flash before clearcoating.
- Conventional or Low VOC clears: mix with 47474SP/01 Flex Additive per technical data sheet recommendations.
- MAP-LV topcoats do not require flex additive.
- Clearcoat per technical data sheet recommendations.

**Matthews Clearcoat Option (No Tie Bond):**

- Clean with 6428SP/01 Plastic Prep, 6405SP/01 Low VOC Cleaner, or 6410SP/01 Low VOC PreCleaner.
- Abrade with scuff pad.
- Clean again with appropriate cleaner.
- Topcoat per technical data sheet recommendations.
Luminore

- Use proper Personal Protective Equipment (PPE) during product application.

Spray Bond Adhesive:

**274793SP/01: RTS 0 VOC**

- Clean with 45330/01 Speed Prep, 6405SP/01 Low VOC Cleaner or 6410SP/01 Low VOC PreCleaner.
- Apply 2 - 3 light to medium coats, allowing proper flash time between coats.
- Allow 5 - 10 minutes to flash before clearcoating.
- Clearcoat per technical data sheet recommendations.

Wood

- Use proper Personal Protective Equipment (PPE) during sanding and product application.
- Certain applications using exterior wood as a substrate will expand and/or contract too much for Matthews to be used.
- For exterior application, it is important to completely encapsulate the entire substrate to prevent moisture penetration.

General Cleaning and Preparation Steps:

- Test moisture level of substrate. Moisture level should be less than 13%.
- Remove debris with clean compressed air.
- Abrade as necessary with 180 - 320 grit, finishing sanding with the finest grit possible.
- Remove dust with clean compressed air and tack rag.
- Seal the wood by applying 2 full wet coats of Matthews Gloss clear allowing proper flash time between coats.
- Allow the clear to fully dry before sanding with 320 grit or finer to smooth surface.
- Remove debris with clean compressed air.
- Apply 2 full wet coats of Matthews clear allowing proper flash time between coats.