



MPC180

**VOC Satin Clear**

# 281 228SP

VOC Satin Clear 281 228SP is a two-component, 2.8 or 3.5 VOC acrylic polyurethane with a natural satin finish. It is produced from the same technology that makes our colors unparalleled in their resistance to the elements.

281 228SP VOC Satin Clear is formulated with a UV screening package that ensures protection of the color and substrate underneath.

281 228SP VOC Satin Clear is designed for topcoat applications to protect color coated signage components and vinyl graphics or to highlight architectural metals.



**Features:**

- Satin-in-the-Can
- 2K Acrylic Polyurethane
- UV Resistant

**Benefits:**

- No post-add flattening paste needed
- Consistent gloss from can to can
- Chemically Resistant
- Most graffiti wipes right off with the appropriate solvent
- Great gloss retention

**Compatible Surfaces:**

**281 228SP VOC Satin Clear may be applied over:**

- All VOC and SVOC MAP® Acrylic Polyurethane colors
- 74 777SP Tie Bond
- 74 793SP Spray Bond

**Required Products:**

- 283 800SP VOC Map Catalyst
- 287 484SP HS Turbo Enhancer

**2.8 VOC Reducers**

- 6370SP Exempt Cool Temperature, 60 - 75°F (16 - 24°C)
- 6371SP Exempt Warm Temperature, 70 - 85°F (21 - 29°C)
- 6372SP Exempt Hot Temperature, 80°F (27°C) & above

**3.5 VOC Reducers**

- 6300SP Cool Temperature, 60° - 75°F (16 - 24°C)
- 6301SP Warm Temperature, 70° - 85°F (21 - 29°C)
- 6302SP Hot Temperature, 80°F (27°C) & above

# 281 228SP

## Directions for Use

### Surface Preparation:

• Substrate should be prepared according to product instructions prior to clearcoat application.

### Mix Ratio:

Mix Ratios (by volume)



281 228SP VOC Satin Clear	283 800SP VOC MAP Catalyst	Appropriate 2.8 or 3.5 VOC Reducer	287 484SP * HS Turbo Enhancer
3 parts	1 part	1 part	+ 4 oz. per RTS Gal.

*\* Reducing the amount of 287 484SP will significantly increase your dry times and will also increase your pot life. All information provided is based off of mixing 4 oz. of 287 484SP per RTS gallon. Adding 1 to 4 oz. per RTS gallon is recommended for best dry time and pot life.*

*Do not add more than 4 oz. per RTS gallon of 287 484SP, doing so, will compromise the coatings performance over time.*



Pot life is 1 - 2 hours at 70°F (21°C)

### Reducers:

#### Exempt MAP Reducers (2.8 VOC):

6370SP Exempt Cool Temperature, 60 - 75°F (16 - 24°C)  
6371SP Exempt Warm Temperature, 70 - 85°F (21 - 29°C)  
6372SP Exempt Hot Temperature, 80°F (27°C) & above

#### Low VOC MAP Reducers (3.5 VOC):

6300SP Cool Temperature, 60° - 75°F (16 - 24°C)  
6301SP Warm Temperature, 70° - 85°F (21 - 29°C)  
6302SP Hot Temperature, 80°F (27°C) & above

### Additives:



287 484SP HS Turbo Enhancer - Required for optimum dry time & pot life.

### Spray Set Up:



Air Pressure: Conventional: 40 - 50 psi at the gun  
HVL P: 10 psi at the cap  
Pot Pressure: 15 - 18 psi

Gun Set Up: Siphon Feed: 1.4 mm 0.055 fluid tip  
HVL P: 1.4 mm 0.055 fluid tip  
Pressure Pot: 1.2 mm 0.046 fluid tip

### Application:



Apply: 1 full wet coat  
Flash 5 - 10 minutes between coats  
Follow with a second full wet coat

Recommended  
Wet Film Thickness: 2 coats @ 1.5 - 2.0 mils/coat

Recommended  
Dry Film Thickness: 2 mils minimum (DFT)

**Caution:** All 2 component cross-linking stops or slows significantly at temperatures below 60°F or 16°C. Never spray or subject freshly painted coatings to these conditions or loss of gloss, poor water and chemical resistance, decreased durability and improper curing will occur.

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## Directions for Use

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### Drying Times:



Dry Times at 70°F (21°C)		
Dust Free Time		
with 287 484SP HS Turbo Enhancer		20 - 30 minutes
Set to Handle		
with 287 484SP HS Turbo Enhancer		60 - 90 minutes
Tack Free Time		
with 287 484SP HS Turbo Enhancer		1.5 - 2 hours
Taping Time		
with 287 484SP HS Turbo Enhancer		4 hours

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### Equipment Cleaning:

Clean up equipment promptly with 45 340SP Cleanz-It or an all purpose clean up solvent.

Do not leave mixed material in equipment.

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### Technical Data:

#### 2.8 VOC Information

281 228SP VOC Satin Clear	3.05
283 800SP VOC MAP Catalyst	0.94
6370SP, 6371SP, 6372SP Exempt Reducers	0.00
287 484SP HS Turbo Enhancer	7.65
Ready to Spray (3:1:1 + 4 oz. 287 484SP/RTS Gal.)	2.69

#### 3.5 VOC Information

281 228SP VOC Satin Clear	3.05
283 800SP VOC MAP Catalyst	0.94
6300SP, 6301SP or 6302SP Reducer	6.36 Ave
287 484SP HS Turbo Enhancer	7.65
Ready to Spray (3:1:1 + 4 oz. 287 484SP/RTS Gal.)	3.09

#### Performance Characteristics

Volume solids	56.42%
Volume solids (RTS)	49.90%
Theoretical Coverage (1.0 mil @ 100% transfer efficiency)	800 sq.ft./RTS gal.
Application Conditions	60°F (16°C) minimum 100°F (38°C) maximum
Relative Humidity	85% maximum 5° above dew point
Gloss	15° - 20° ± 5° w/60° meter
Flash Point (Tag closed cup)	Below 80°F (27°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.

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**See Material Safety Data Sheet and Labels for additional safety information and handling instructions.**

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EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION - US (412) 434-4515; CANADA (514) 645-1320; MEXICO 01-800-00-21-400

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