



product
information

4360 SERIES
ALKYD AIR DRY PRIMER

Cardinal's 4360 series is a quality, quick dry, single component solvent-borne modified alkyd primer formulated to conform to VOC requirements. This product is designed for a variety of metallic substrates including: cold and hot rolled steel, galvanized steel, aluminum and can be used direct to metal for exterior surfaces.

TYPICAL USES:

- Heavy equipment
- Utility trailers
- Farm Equipment
- Waste management equipment
- Ornamental iron work

BENEFITS:

- Fast dry
- Single component
- Excellent recoat
- RoHS / WEEE Compliant

CURED FILM PROPERTIES:

Unless otherwise indicated, testing conducted on 4360-73687 Gray at 1.5 mils DFT (Dry Film Thickness) over 20 gauge Bonderite 1000 test panel, cured 7 days air dried in ambient room temperature (78°F).

TEST	METHOD	PARAMETERS	RESULT
Adhesion	ASTM D3359	Cross-hatch tape	No loss
Impact:	ASTM D2794	Direct Reverse	60 in. lbs. 20 in. lbs
Flexibility:	ASTM D1737	1/4" mandrel	Pass
Hardness	ASTM D3363	Pencil	HB – F
Salt Spray	ASTM B117	250 hrs 95°, 5% salt solution	Less than 1/8" creepage
Solvent Resistance	ASTM D4752	MEK 10 rubs IPA 50 rubs	Softens but recovers No effect

SURFACE PREPARATION AND PRIMING: The most important steps in a successful coating process are cleaning, pretreatment and priming. The following is a brief outline of some basics for unpainted substrates. It is not intended to be all-inclusive. For more information on your particular application contact Cardinal.

Cleaning the substrate: All surfaces to be coated, must be free of dirt, grease, oil, oxidation, mill scale, and all other contaminants. The surface must be thoroughly dry before painting. Air quality regulations have limited the allowable emissions from cleaning operations.

Steel — A phosphate chemical conversion coating is highly recommended. When this is not possible, Cardinal's W-303-A surface preparation solution prior to a vinyl acid wash pretreatment primer is recommended such as Cardinal's 4860 series primers.

Aluminum — A chemical conversion coating is highly recommended. When this is not possible, Cardinal's W-303-A surface preparation solution prior to a vinyl acid wash pretreatment primer is recommended such as Cardinal's 4860 series primers.

Galvanized — Remove all white rust, Cardinal's W-303-A surface preparation solution improves adhesion.

FOR INDUSTRIAL USE ONLY
NOT FOR RESIDENTIAL USE

TYPE: Modified alkyd co-polymer.

COMPONENTS: One.

COLORS: Grey.

GLOSS: 0 - 5°

COVERAGE: At 1.0 mil DFT.

960 ft²/gal. at 100% transfer efficiency (TE)

625 ft²/gal. at 65% TE

Calculation: 1604 ft²/gal x % volume solids x TE ÷ DFT

VOC MIXED: (as supplied)

420 grams/liter = 3.5 lbs/gal excluding exempt solvents

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VOLUME SOLIDS: 50%

FLASH POINT: 79°F TCC

SHELF LIFE: 1 year from date of manufacture in factory sealed container.

APPLICATION: Thoroughly stir or agitate paint before applying. Brushing, rolling and dipping are not recommended. See Surface Preparation and Priming section for further instructions.

VISCOSITY: 20" – 30" seconds, #3 Zahn cup at 78°F.

Will vary depending on color.

RECOAT: After 30 minutes.

RECOMMENDED DFT: 1.5 – 2.5 mils (depending on color)

CURE: Air Dry

Tack free 3 - 5 min.

Dry to handle 20 min.

Full cure 3 days

EQUIPMENT: Most air quality regulations require the paint application transfer efficiency to be 65% or better. This generally means using electrostatic or high volume low pressure (HVLP) spray guns. Otherwise, conventional pressure feed, airless or air assisted airless spray equipment can be used. Air supply lines need water and oil traps.

CLEAN-UP: Clean up should be done as soon as possible. The drier the paint, the more resistant it is to clean up. Air quality regulations have limited the allowable emissions from cleaning operations

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NO WARRANTY EXPRESSED OR IMPLIED, ACCEPTABILITY TO BE DETERMINED BY USER, SPECIFICATIONS ARE SUBJECT TO CHANGE WITHOUT NOTICE

RELATED PRODUCTS:

PRODUCT NO.	DESCRIPTION
1000-13	Fast exempt reducer and gun cleaner
HP-439	Medium exempt reducer

TROUBLE SHOOTING:

PROBLEM	CAUSE	REMEDY
Not drying	Too heavy – film thickness	Lower fluid pressure Spray multiple coats
Craters Fish-eyes	Surface tension	Add 1/2 oz./gal. of J-3081
Wrinkling	Recoat too soon	Lengthen recoat window

PRODUCT LIMITATIONS:

- Do not recoat prior to 30 minutes. Temperature, humidity or film thickness may change recoat times.
- Do not apply below 50°F.

SAFETY: Refer to the product's Material Safety Data Sheet (MSDS) for complete safety information. Contains organic solvents. Use with adequate ventilation. Do not breathe vapors or spray mists. If component TLVs are exceeded, a NIOSH approved air supplied respirator is advised. See MSDS for TLV information.

Contents are FLAMMABLE. Keep from heat, sparks or open flame.

Allergic reactions are possible. Avoid use by persons with respiratory problems.

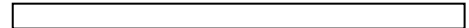
Avoid contact with eyes, skin, and clothing. Wash thoroughly after handling.

FIRST AID:

Eye contact: flush immediately with plenty of water for at least 15 min. and get medical attention.

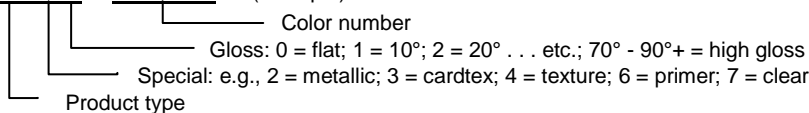
Skin contact: wash thoroughly with soap and water for 5 minutes.

If swallowed, do not induce vomiting, get medical attention immediately.



PRODUCT IDENTIFICATION

4 3 6 0 - 7 3 6 8 7 (example)



G12TL

IMPORTANT: Warranty and Disclaimer — The performance characteristics of these products vary according to product application, operating conditions, materials applied to or with and use. Since these factors can affect results, we strongly recommend that you make your own test to determine to your satisfaction whether the product is of acceptable quality, has not been affected by storage or transport and is suitable for your particular purpose under your own operation conditions prior to using any product in full scale production. Seller warrants the products to be free from defects in materials and workmanship. SUCH WARRANTY IS EXCLUSIVE AND IS IN LIEU OF ANY OTHER WARRANTY, EXPRESSED OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OF FITNESS FOR A PARTICULAR PURPOSE. No representative of ours has authority to waive or change this provision, which applies to all sales of these products.