Cardinal’s 6732-SERIES is a high performance two component solvent borne aliphatic polyurethane hammer finish. The system is forms a hammer when sprayed. The system exhibits good exterior performance, chemical resistance and a durable finish.

**Typical Uses:**
- High Performance requirements
- Outdoor applications
- General Industrial
- Exterior grade pigments
- Excellent Weathering
- RoHS & WEEE Compliant

**Benefits:**
- HAPS FREE
- Excellent chemical and solvent resistance

**Type:** Solvent based Acrylic Polyester Polyurethane.

**Components:** Two.

**Color:** Full range of colors, 595C and specialty colors.

**Gloss:** 20 +/- 5° Degrees. (Degree of texture effects gloss)

**Coverage:** At 1.0 mil DFT, 65% transfer efficiency (TE)
- Mixed paint: 526 ft²/gal.
- Calculation: 1604 ft²/gal x % volume solids x TE ÷ DFT

**Mix Ratios & VOC Information:**

<table>
<thead>
<tr>
<th>Paint</th>
<th>340-HP Hardener</th>
<th>1600-02 Reducer</th>
<th>VOC Excluding</th>
<th>VOC Including</th>
<th>Volume Solids</th>
<th>Weight Solids</th>
</tr>
</thead>
<tbody>
<tr>
<td>6732-Series</td>
<td>4 Parts</td>
<td>1 Part</td>
<td>1 Part</td>
<td>420 g/l</td>
<td>420 g/l</td>
<td>47%</td>
</tr>
<tr>
<td>340-HP</td>
<td>1 Part</td>
<td>1 Part</td>
<td>420 g/l</td>
<td>420 g/l</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**Volume Solids:**
- 6732-Series.............52%
- 340-HP .................91%

**Flash Point:** >24 °F TCC

**Viscosity:** 20°-25° #2 Zahn range.

**Sprayable Pot Life:** 2-3 hours not accelerated

**Recommended DFT:** 2.0 – 3.0 mils (depending on color)

**Application Conditions:**
- When applying this material it is important to atomize the coating to create the hammer finish. The fine the atomization the more controlled the hammer effect is. Match spray technique with the desired hammer finish.
- Temperature- Apply coating within the range 55-100 F
- Relative Humidity- not recommended to apply in conditions greater then 85%
- Substrate temperature- 5° above the dew point and a minimum of 55°F

If coating is not applied within these conditions then the cured coating properties may be representative.

**Equipment:**
- Conventional- 40-50 psi / 0.055 fluid tip
- HVLP- 10 psi at air cap/ 0.055 fluid cap
- Pressure pot- 10-15 psi/ 0.046 fluid cap

**Shelf Life:** 1 year from date of manufacture in factory sealed container.

**Dry Times:**

<table>
<thead>
<tr>
<th>Air Dry (2.0 mil dft, 75 F @ 50% RH)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dust free</td>
</tr>
<tr>
<td>with 1oz/gal EL-005 accelerator</td>
</tr>
<tr>
<td>Dry to touch</td>
</tr>
<tr>
<td>with 1oz/gal EL-005 accelerator</td>
</tr>
<tr>
<td>Dry to recoat</td>
</tr>
<tr>
<td>with 1oz/gal EL-005 accelerator</td>
</tr>
<tr>
<td>Dry to hard</td>
</tr>
<tr>
<td>with 1oz/gal EL-005 accelerator</td>
</tr>
</tbody>
</table>

**Physical Properties:**
All testing conducted on primed 7760 Bondrite 1000 phosphated Panels and were air dried for seven days at 75°F@50%RH.

<table>
<thead>
<tr>
<th>Test</th>
<th>Method</th>
<th>Parameters</th>
<th>Result</th>
</tr>
</thead>
<tbody>
<tr>
<td>Hardness</td>
<td>ASTM D3363</td>
<td>Pencil</td>
<td>2H</td>
</tr>
<tr>
<td>Abrasion</td>
<td>ASTM D4060</td>
<td>CS 10, 1 Kg, 1000 Cycles</td>
<td>Less than 100 mg</td>
</tr>
<tr>
<td>Adhesion</td>
<td>ASTM D3359</td>
<td>Cross-hatch tape</td>
<td>0% failure</td>
</tr>
<tr>
<td>Flexibility</td>
<td>ASTM D1737</td>
<td>1/8” mandrel</td>
<td>No cracking</td>
</tr>
<tr>
<td>Salt Spray</td>
<td>ASTM B117</td>
<td>1000 hours</td>
<td>No effect</td>
</tr>
<tr>
<td>UV Resistance</td>
<td>ASTM G53</td>
<td>1000 hours QUV A</td>
<td>&gt; 90% gloss retention</td>
</tr>
<tr>
<td>Impact</td>
<td>ASTM D2794</td>
<td>Direct, Reverse</td>
<td>130 Direct, 60 Reverse</td>
</tr>
<tr>
<td>Humidity</td>
<td>ASTM D2247</td>
<td>100 hrs</td>
<td>No effect</td>
</tr>
<tr>
<td>Solvent Resistance</td>
<td>ASTM D4752</td>
<td>MEK 50 rubs</td>
<td>No effect</td>
</tr>
<tr>
<td>Chemical &amp; Stain Resistance</td>
<td>ASTM D1308 30 min. spot</td>
<td>IPA 100 rubs</td>
<td>No effect</td>
</tr>
</tbody>
</table>

**A:** No effect
- A – IPA, hydrogen peroxide, 409®, toluene, hydrochloric acid, textile spirits, amyl acetate, trichloroethylene, methanol, ethylene dichloride, lacquer thinner, xylene, ethanol, ammonia, gasoline, motor oil, coffee, tea.

**B:** Slight dulling
- B – Acetone, MEK.

**C:** Moderate effect
- C – 50% sulfuric acid, 2.5N sodium hydroxide

**D:** Discolored & softened

(Continued on page 2)
**RECOMMENDED COATING SUBSTRATE SYSTEMS:**

**ALUMINUM:**
- Prep: Abrade surface with 220 or 400 grit sandpaper.
- Clean with W-500A or W-303A metal cleaning solution.
- Primer: 7760-10 epoxy primer (2-3 dry mils/6-7 wet mils)
- 7260-4702 Fast dry primer (2-3 dry mils/6-7 wet mils)
- 6460-4257 Polyester Spray fill (2-3 dry mils/4-5 wet mils)
- 7065-10 High build epoxy (2-3 dry mils/4-5 wet mils)
- 4860-52 Etch primer (0.2-0.5 dry mils/5-10 wet mils)
- Adhesion Promoter for clear coating Aluminum: 6SAP-100 Metal adhesion promoter (0.15-0.30 dry mils/2-4 wet mils)
- Topcoat: 6S00 series semi or gloss pigmented (1.5-2.5 dry mils depending on color)
- 6500 series semi or gloss clear (2.0 dry mils)

**STEEL:**
- Prep: Abrade surface with 220 or 400 grit sandpaper.
- Clean with W-500A or W303A metal cleaning solution.
- Primer: 7760-10 epoxy primer (2-3 dry mils/6-7 wet mils)
- 7260-4702 Fast dry primer (2-3 dry mils/6-7 wet mils)
- 6460-4257 Polyester Spray fill (2-3 dry mils/4-5 wet mils)
- 7065-10 High build epoxy (2-3 dry mils/4-5 wet mils)
- 4860-52 Etch primer (0.2-0.5 dry mils/5-10 wet mils)
- Topcoat: 6S00 series semi or gloss pigmented (1.5-2.5 dry mils depending on color)

**BRASS/COPPER:**
- Prep: Once substrate is polished spray with W-900 anti tarnish solution prior to coating
- Adhesion Promoter: 6SAP-100 Metal adhesion promoter (0.15-0.30 dry mils/2-4 wet mils)
- Topcoat: 6S00- series anti-tarnish clear coats 6S73-3010 and 6S79-3010 (2.0 dry mils)

**GLASS:**
- Prep: Clean surface of glass with glass cleaner
- Prime: 7260-4702 Fast dry primer (1.5-2.0 dry mils/3-6 wet mils). Not compliant to SCAQMD rule 1145.
- Adhesion Promoter: W-805A glass adhesion promoter.
- Topcoat: 6S00 series semi or gloss pigmented (1.5-2.5 dry mils depending on color)
- 6500 series semi or gloss clear (2.0 dry mils)

**PLASTICS:** Polycarbonate, Polyurethane, ABS, Fiberglass, Acrylic, PVC & TPO.
- Prep: If necessary remove any mold release with Cardinal W-502P plastics cleaner or acetone if permitted.
- Light sanding with a 400 grit sandpaper will help adhere to difficult substrates.
- Prime: 6760-E12426 Acrylic primer (1.5-2.0 dry mils/3-6 wet mils). Compliant to SCAQMD rule 1145.
- 7260-4702 Fast dry primer (1.5-2.0 dry mils/3-6 wet mils). Not compliant to SCAQMD rule 1145.
- 6460-4257 Polyester spray fill primer (1.5-2.0 dry mils/2-4 wet mils). Not compliant to SCAQMD rule 1145.
- Adhesion Promoter: W-700A plastics adhesion promoter for polyolefin type plastics
- 6SAP-200 tie coat adhesion promoter for difficult to adhere plastics.
- Topcoat: 6S00 series semi or gloss pigmented (1.5-2.5 dry mils depending on color)
- NOTE: check adhesion of primer or adhesion promoter before top coating.

**WOOD:**
- Prep: Sand surface with 220 or 400 grit sandpaper
- Prime: 6760-E12426 Acrylic primer (2-3 dry mils/3-6 wet mils)
- 6460-4257 Polyester spray fill primer (1.5-2.0 dry mils/2-4 wet mils).
- Topcoat: 6S00 series semi or gloss pigmented (1.5-2.5 dry mils depending on color)
- 6500 series semi or gloss clear (2.0 dry mils)

**MASONRY:**
- Prep: Acid wash surface and allow to dry before coating
- Prime: 7760-10 epoxy primer (2-3 dry mils/6-7 wet mils)
- 7260-4702 Fast dry primer (2-3 dry mils/6-7 wet mils)
- 6460-4257 Polyester Spray fill (2-3 dry mils/4-5 wet mils)
- 7065-10 High build epoxy (2-3 dry mils/4-5 wet mils)
- Topcoat: 6S00 series semi or gloss pigmented (1.5-2.5 dry mils depending on color)

**ADDITIONAL PRODUCT INFORMATION:**

**REDUCERS FOR 6700-SERIES**
- 1600-01 fast reducer
- 1600-02 medium reducer
- 1600-03 slow reducer
- HP-439 Exempt reducer

**ADDITIVES TO COMPLIMENT 6700-SERIES**
- 6SFP-100 zero VOC flattening paste
- EL-005 Accelerator
- JS-3081 Anti crater additive

For Health information refer to Material Safety Data Sheet

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**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.