



product  
information

**6760 PRIMER SERIES**  
1# VOC SANDING ACRYLIC  
POLYURETHANE

**Cardinal's 6760** series is a 1 LB/GAL VOC solvent two component polyurethane sanding primer designed to be applied direct to a variety of plastics, wood and composite substrates. The product is defined by fast dry, chemical resistance, hydrolysis resistance, adhesion and sand ability.

**TYPICAL USES:**

- Plastic substrates
- Composite substrates
- Medical equipment

**BENEFITS:**

- Low V.O.C.
- Free of heavy metals
- Excellent chemical resistance
- Excellent sand ability
- RoHS / WEEE Compliant

**CURED FILM PROPERTIES:**

Testing conducted on 6760-4702 flat light gray, catalyzed with 340LASG at 1.5 mils DFT (Dry Film Thickness) over 20 gauge Bonderite 1000® test panel cured 30 minutes at 180°F and air dried 14 days.

TEST	METHOD	PARAMETERS	RESULT
Adhesion	ASTM D3359	Cross-hatch tape	0% failure
Hardness	ASTM D3363	Pencil	F- H
Solvent Resistance	ASTM D4752	MEK 25 rubs	No effect
		IPA 50 rubs	No effect

**Cure:** Air Dry – ambient air temperature @ 78° F

catalyst	dust free	tack free	dry to handle	recoat	dry hard	full cure
340SG	5 min	20 min	4 hrs	4-6 hrs	48 hrs	7 days
340HP	10 min	30 min	4 hrs	4-6 hrs	48 hrs	7 days

Force Dry - the following will approximate a 72 hour cure @ 78° F

30 min @ 140° F	20 min @ 180° F
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\* Some Air quality regulations require a maximum temp. of 194° F to qualify as an "air dry" system which generally have higher VOC limits than baking systems.

**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.

**Plastic —** All mold release should be completely removed. 6400 series polyurethane is compatible with a variety of plastics, however, since there are numerous different formulations of plastic, a trial sample should be painted and checked before running production. If 6400 attacks or weakens the plastic, a barrier coat of 3777-1 clear waterborne acrylic enamel may help.

**FOR INDUSTRIAL USE ONLY  
NOT FOR RESIDENTIAL USE**

**TYPE:** Acrylic polyurethane.

**COMPONENTS:** Two.

**COLORS:** Light Gray, Black, White and Red Oxide

**GLOSS:** Flat 0 - 5° @ 60 ∠

**COVERAGE:** At 1.0 mil DFT, 65% transfer efficiency(TE)

Mixed paint, 1.0 lbs/gal : 600 ft<sup>2</sup>/gal.

Calculation: 1604 ft<sup>2</sup>/gal x % volume solids x TE ÷ DFT

**VOC MIXED:** 120 grams/liter = 1.0 lbs/gal

51 grams/liter = 0.4 lbs/gal

See mix ratio table below.

**VOLUME SOLIDS:**

6700 S/G base ..... 67%

340HP / 340SG ..... 90%

Mixed to 1.0 lbs/gal ..... 56%

**FLASH POINT:**

6460-E12426, 6760-E15425, 6760-4702	method
-4° F	TCC

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

**APPLICATION:** After preparing the surface, thoroughly mix component 1 before adding catalyst. Mix only the amount of material needed. The base to catalyst proportion must be measured accurately, by volume only, to obtain optimum film properties. Do not use reducers that contain water or alcohol; these react with the catalyst and can cause a variety of problems. Be aware of spray-able pot life. Brushing, rolling and dipping are not recommended.

**MIX RATIOS:** Two components must be mixed properly to obtain coating performance. Thinning depends on applicator's regulatory VOC limits.

Mix	parts by volume
6760 base	9
catalyst	1 part 340HP / 340SG
solvent	3 parts HP-439
VOC =	1.0 lbs/gal

**VISCOSITY:** At 1.0 lbs/gal, the 6760 series primer will be in the 25"-30" #3 Zahn range

**SPRAY-able Pot Life-**3 hrs. at 1.0 lb. VOC/gal

**RECOMMENDED DFT:** 1.0 – 3.0 mils

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So. El Monte, CA 1329 Potrero Ave. 91733 (323) 283-9335 (626) 444-9274 Fax (626) 444-0382

[www.cardinalpaint.com](http://www.cardinalpaint.com)

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

**RELATED PRODUCTS:**

PRODUCT NO.	DESCRIPTION / FUNCTION
1600 Series Reducers	Thinners. Urethane grade. 1600-01, fast; 1600-02, medium; 1600-03, slow; 1600-06, very slow.
EL-005	Accelerator. Speeds up dry time (and shortens pot life).
J-3081	Surfactant. Helps eliminate blisters, bubbles, pin holes, solvent-pop.

**TROUBLE SHOOTING:**

PROBLEM	CAUSE	REMEDY
Blisters, pin holes or solvent pop	Water contamination. Entrapped air. Entrapped solvent	Eliminate water – Check air lines. Use fresh catalyst. Use urethane grade thinners. Increase atomization, decrease film build.
Craters	Contaminated ambient air, e.g., silicone mist, dust.	Locate and eliminate source of contamination.
Fish-eyes	Substrate contamination.	Clean and prepare substrate.
Not drying	Alcohol in reducer. Wrong catalyst ratio.	Use Cardinal's 1600 series or urethane grade reducers only. Double check mix ratio.
Poor adhesion	Improper surface preparation.	See surface preparation section.
Gloss variation	Variation in application, cure schedule, catalyst ratio, humidity.	Consistent gloss depends upon consistent process, e.g., air dried parts will not have same gloss as force dried parts.

**APPLICATION 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.

**EQUIPMENT CLEAN-UP:** Clean up should be done as soon as possible keeping in mind the pot life of the mixed paint. Avoid leaving catalyzed paint in the lines. Air quality regulations have limited the allowable emissions from cleaning operations.

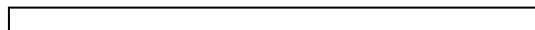
**PRODUCT LIMITATIONS:**

- 340SG is not recommended for outdoor exposure or UV radiation. Both will tend to yellow and also chalk sooner than 340HP.
- Catalyst reacts with water. Air supply should be dry. Containers should be kept tightly closed. Use urethane grade thinners only.
- Alcohols and glycols interfere with curing chemistry and should be avoided. They can be found in some lacquer thinners and certain synthetic reducers.
- Optimum film properties are dependent upon proper mixing of paint and catalyst.

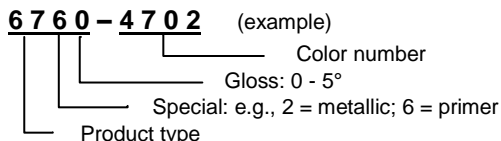
**SAFETY:** Refer to the product's Material Safety Data Sheet (MSDS) for complete safety information. Contains organic solvents. Use with adequate ventilation. Do not breathe vapors or spray mists. If component TLVs are exceeded, a NIOSH approved air supplied respirator is advised. See MSDS for TLV information.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



**PRODUCT IDENTIFICATION**



G12TL