



product  
information

**7067-4702**  
**FAST DRY HIGH BUILD EPOXY PRIMER**

**Cardinal's 7067-4702** is a fast drying high build two-component epoxy polyamide primer. 7067-4702 epoxy primer is well suited for metal surfaces that require weather, corrosion and chemical resistance. Such applications would include: As epoxy coatings tend to lose gloss under prolonged exposure to sunlight, high solid polyurethane coatings are recommended for exterior topcoat applications where gloss and color retention is required.

**TYPICAL USES:**

- Steel enclosures
- Utility trailers
- Heavy duty equipment

**BENEFITS:**

- Low V.O.C.
- Free of heavy metals
- Excellent chemical and solvent resistance
- RoHS / WEEE compliant

**CURED FILM PROPERTIES:**

Testing conducted on 7067-4702 s/g light gray, catalyzed with 706HB at 2.0 mils DFT (Dry Film Thickness) over sand blasted steel panel cured 14 days at ambient temperature

TEST	METHOD	PARAMETERS	RESULT
Adhesion	ASTM D3359	Cross-hatch tape	0% failure
Hardness	ASTM D3363	Pencil	H
Water Submersion		500 hours D.I water	No effect
Salt Spray	ASTM B117	1000 hrs 95°, 5% salt solution	Less than 3/16" creep - along scribe, otherwise, no effect

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

Set-to Touch	Dry to handle	Full cure	Recoat
1 hour	6-8 hours	7 days (air dry)	6 hours – 1 week

**No Force Curing  
Prior to Topcoat**

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

**TYPE:** Epoxy / Polyamide

**COMPONENTS:** Two.

**COLORS:** Gray

**GLOSS:** 65 - 75° @ 60 ∠

**COVERAGE:** At 1.0 mil DFT, 100% transfer efficiency (TE)

Mixed paint, 2.08 lbs/gal : 1100 ft<sup>2</sup>/gal.

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

**VOC MIXED:** 250 grams/liter = 2.08 lbs/gal Excluding  
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See mix ratio table below.

**VOLUME SOLIDS:**

7067 Primer base ..... 70%

706HB ..... 72%

Mixed to 2.08 lbs/gal ..... 70%

**FLASH POINT:**

7067-4702	method
24° 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. 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
7067-4702	3 parts
706HB catalyst	1 part
VOC =	2.08 lbs/gal

**VISCOSITY:** At 2.08 lbs/gal, the 7067 series primer will be in the 25"-35" #3 Zahn range.

**SPRAY-able Pot Life:** 2-3 hrs. at 2.08 lbs. VOC/gal

**RECOMMENDED DFT:** 2.0 – 3.0 mils

(Continued on page 2)

**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, 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, a vinyl acid wash pretreatment primer is recommended such as Cardinal's 4860 series primers.

**Galvanized** — Cardinal's W-303-A surface preparation solution helps improve adhesion followed by a vinyl acid wash pretreatment primer such as Cardinal's 4860 series primers.

**Stainless Steel** — Brush-off or blast clean per SSPC-SP 7 to a uniform profile of 1.5 mils. Cardinal's W-303-A surface preparation solution can help improve adhesion followed by a vinyl acid wash pretreatment primer such as Cardinal's 4860 series primers.

**RELATED PRODUCTS:**

PRODUCT NO.	DESCRIPTION / FUNCTION
HP-439	Medium reducer.
J-3081	Surfactant. Helps eliminate blisters, bubbles, pin holes, solvent-pop.
6400- Series	High Solids Polyurethane

**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:**

- 7067-4702 is not recommended for outdoor exposure or UV radiation.
- Air supply should be dry. Containers should be kept tightly closed. Use urethane grade thinners only.
- 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.

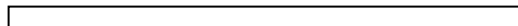
Avoid contact with eyes, skin, and clothing. Wash thoroughly after handling.

**FIRST AID:**

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

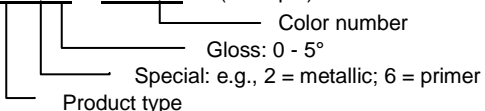
Skin contact: wash thoroughly with soap and water for 5 minutes.

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



**PRODUCT IDENTIFICATION**

**7067-4702** (example)



**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.