



product  
information

**7760-E13242**  
ZINC RICH EPOXY PRIMER

Cardinal's 7760-E13242 is a zinc rich epoxy primer designed for extreme corrosion resistance and fast application environments.

**TYPICAL USES:**

- Steel enclosures
- Utility trailers
- Heavy duty equipment

**BENEFITS:**

- Low V.O.C.
- Excellent corrosion, chemical and solvent resistance
- RoHS / WEEE compliant

**CURED FILM PROPERTIES:**

Testing conducted on 7760-E13242 flat light gray, catalyzed with 77EH at 2.5 mils DFT (Dry Film Thickness) over SSPC-10 blasted steel with 6409-10 topcoat then test panel air dried 14 days.

TEST	METHOD	PARAMETERS	RESULT
Impact	ASTM D2794	Direct	20 in. lbs
Hardness	ASTM D3363	Pencil	2H
Salt Spray	ASTM B117	5000 hrs 95°, 5% salt solution	Less than 3/16" creep - along scribe, otherwise, no effect
Solvent Resistance	ASTM D4752	MEK 100 rubs	No effect
Water Submersion		2000 hrs	No effect

**Cure:** Air Dry – Substrate temperature 24° C @ 75° F

catalyst	Set-to-Touch	Dry-to-Handle	Full Cure	Recoat
77EH	1 hour	2 hours	7 days	2 hours – 1 week

**No Force Curing  
Prior to Topcoat**

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

**TYPE:** Epoxy.

**COMPONENTS:** Two.

**COLORS:** Gray

**GLOSS:** Flat 5 - 10° @ 60 ∠

**COVERAGE:** At 1.0 mil DFT, 65% transfer efficiency(TE)  
Mixed paint, 2.8 lbs/gal : 520 ft<sup>2</sup>/gal.

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

**VOC MIXED:** 340 grams/liter = 2.8 lbs/gal Excluding  
298 grams/liter = 2.48 lbs/gal Including  
See mix ratio table below.

**VOLUME SOLIDS:**

7760-E13242 Primer ... 50%  
77EH ..... 66%  
Mixed to 2.85 lbs/gal ..... 51%

**FLASH POINT:**

7760-E13242	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. 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
7760-E13242	10 parts
77EH catalyst	1 part
solvent	N/A
VOC =	2.8 lbs/gal

**VISCOSITY:** At 2.85 lbs/gal, the 7760-E13242 primer will be in the 20"-25" #3 Zahn range.

**SPRAY-able Pot Life:** 2-3 hrs. at 2.8 lbs. VOC/gal

**RECOMMENDED DFT:** 2.0 – 3.0 mils

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**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 — Blast clean per SSPC-SP10 to a uniform profile of 1.5 mils.

Stainless Steel — Blast clean per SSPC-SP 10 to a uniform profile of 1.5 mils.

**TOPCOAT SELECTION:**

PRODUCT NO.	DESCRIPTION	FUNCTION
6400 Series	2K Polyester Polyurethane	Good Performance and exterior durability

**RELATED PRODUCTS:**

PRODUCT NO.	DESCRIPTION / FUNCTION
HP-439	Medium reducer.
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.

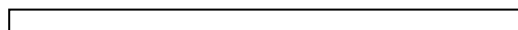
**PRODUCT LIMITATIONS:**

- 77EH is not recommended for outdoor exposure or UV radiation.
- 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.

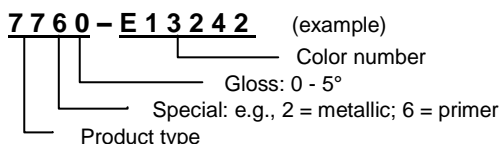
**SAFETY:** Refer to the product's Material Safety Data Sheet (MSDS) for complete safety information. Contains organic solvents. Use with adequate ventilation. Do not breathe vapors or spray mists. If component TLVs are exceeded, a NIOSH approved air supplied respirator is advised. See MSDS for TLV information.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