



product
information

6491-E14268
SEMI GLOSS ESD GRAY

Cardinal's 6491-E14268 is a 2.8 LB/GAL VOC two-component high solids polyurethane designed for interior uses. The product is defined by excellent chemical resistance, electro static dissipative properties and adhesion. This product has been formulated for spray application.

TYPICAL USES:

- Metal Enclosures

BENEFITS:

- Low VOC content
- Excellent ESD
- RoHS / WEEE compliant

REPAIR OR REFINISHING: Clean surface to be repainted, remove dirt, grease, oil, and all other contaminants. Abrade surface if necessary. Tack surface clean.

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.

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.

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.

Related Products:

PRODUCT NO.	DESCRIPTION
HP-439	Slow Exempt Reducer
SB-32	Slow Reducer

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

TYPE: Polyester

COMPONENTS: Two.

COLORS: ESD Gray

GLOSS: 3° +/- 1 degree.

SURFACE RESISTANCE: Less than 10⁶ Ohms over phosphate steel.

COVERAGE: At 1.0 mil DFT.

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

625 ft²/gal. at 65% TE

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

VOC: (as applied)

340 grams/liter = 2.83lbs/gal less water

340 grams/liter = 2.83 lbs/gal including water

VOLUME SOLIDS: 56.8%

FLASH POINT: 24°F TCC

SHELF LIFE: 1 year from date of manufacture in factory sealed container @ 50 to 100 °F.

Mix Ratio:

Component	Parts by Volume
6491-E14268	4
340HP	1

APPLICATION: Thoroughly stir or agitate paint before applying. This material is designed for spray application. Brushing, rolling and dipping are not recommended. See surface preparation and priming section for further instructions.

RECOMMENDED SPRAY EQUIPMENT:

HVLP; fluid nozzle 97, air cap 93P, fluid pressure 40-50 psi, air pressure 55psi

VISCOSITY: 50" – 60" seconds, #3 Zahn cup at 78°F.

POT LIFE: 3 Hours @ 77°F

RECOMMENDED DFT: 1.5 – 2.5 mils

CURE:

DRYING TIME:	Set-to-Touch	Dry-to-Handle	Full Cure
Air Dry			
Substrate temperature 78F	1hours	6 hours	7 -14 days

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Trouble Shooting:

PROBLEM	CAUSE	REMEDY
Too thin / low viscosity	Over reduced.	Remix at correct ratio
Dry spray	High atmospheric temperature. Over atomization Gun to part distance	Increase fluid pressure & decrease atomizing pressure. Reduce with SB-17: 1% - 2%. Add SB-17 at rate of 1 oz./gal.
Craters	Contamination of substrate, application equipment or environment.	Find and eliminate source of contamination. When craters persist, add ½ oz./gal of 6SLA-100 additive.
Poor adhesion	Improper surface preparation.	See surface preparation section.

EQUIPMENT CLEAN-UP: 1000-13 should always be used for primary cleaning. If something different is needed exempt solvents can be used for secondary cleaning, air quality regulations, in your area may have limited the allowable emissions from cleaning operations.

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.

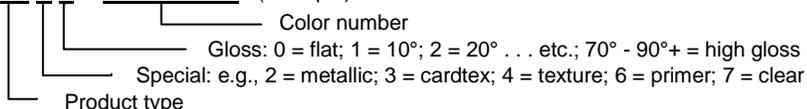
Skin contact: wash thoroughly with soap and water for 5 minutes.

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



PRODUCT IDENTIFICATION

6 4 9 1 - E 1 4 2 8 6 (example)



G12TL