



product
information

7708-77638
EPOXY FLOOR COATING

Cardinal's 7063-77638 is a light gray high solids two-component high build modified cycloaliphatic amine cured epoxy coating designed to meet strict air quality regulations. This coating meets the VOC limits for industrial coatings limits of 2.00 pounds per gallon (250 grams per liter). The 7708-77638 is suited for surfaces that cannot be blasted but still require excellent corrosion and chemical resistance.

TYPICAL USES:

- Concrete Flooring.
- Chemical Plants
- Structural Steel Components
- One coat protective finish.

BENEFITS:

- Low VOC – 250 grams / liter.
- Excellent chemical and corrosion resistance.
- Suited for surfaces that cannot be blasted.
- RoHS & WEEE Compliant

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, do not hesitate to call 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.

Steel — Clean metal well. Sandblasting is suggested for older, weathered surfaces or surfaces with multiple coats of old paint.

Aluminum — For new unweathered 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 — Remove pretreatment from surfaces. Without aging or pickling galvanized steel, paint will not adhere. Cardinal's W-303-A surface preparation solution will help improve adhesion.

TROUBLE SHOOTING:

PROBLEM	CAUSE	REMEDY
Blisters, pin holes or solvent pop	Water contamination. Entrapped air. Entrapped solvent	Eliminate water – Check air lines. Use fresh hardener. Increase atomization, decrease film build.
Craters	Contaminated ambient air, i.e., silicone mist, dust.	Locate and eliminate source of contamination.
Fish-eyes	Substrate contamination.	Clean and prepare substrate.
Not drying	Wrong catalyst ratio.	Double check mix ratio.
Poor adhesion	Improper surface preparation.	See surface preparation section.

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

TYPE: Modified cycloaliphatic amine epoxy.

COMPONENTS: Two.

COLOR: Gray

GLOSS: Gloss.

COVERAGE: At 1.0 mils DFT at 100% transfer efficiency.

Mixed paint, VOC at 250 gms/liter: 1100 ft²/gal

VOC MIXED: 250 grams/liter (2.1 lbs/gal) maximum.

See mix ratio table below.

VOLUME SOLIDS: (VOC)

With hardener no reducer 70% (250 gms/l)

FLASH POINT: 7708-77638 = 24°F TCC

SHELF LIFE: 1 year from date of manufacture on the factory unopened container.

MIX RATIOS: Two components must be mixed properly to obtain a cured film. Thinning depends on applicator's regulatory limitations.

	Parts by volume
7708-77638	3 parts
77FC- hardener	1 part

INDUCTION TIME: After mixing, wait 30 minutes before applying.

POT LIFE : 3 hours at 77°F (25°C)

RECOMMENDED FILM THICKNESS: 2.0 – 6.0 mils

Surface Preparation: All burrs and loose concrete should be completely removed. Concrete should cure at least 30 days and have a moist content prior to coating below 8% as measured by an instrument such as a Delmhorst Model DP. Oil, grease and heavy deposits of surface contaminants should be removed by solvent or detergent cleaning.

Cleaning and Etching: Clean surface by abrasive blast or etch with 10% hydrochloric acid. If etching is employed, the acid solution should be applied at a rate of 1 ½ pints per square yard to obtain total wetting of the substrate and thoroughly worked into the surface by stiff bristled brushes until bubbling reaction has subsided. **PROTECTIVE CLOTHING AND EQUIPMENT SHOULD BE USED WHENEVER WORKING WITH ACIDS.** The Etched surface should be thoroughly washed and scrubbed with clean water and stiff bristled brushes and /or high pressure water hosing to remove all salts and loose particles. Surface must be dry before proceeding with any coating.

Application Instructions: Avoid application of coating below 50°F. A minimum coat of five mils is recommended to attain best performance properties. Cardinal's 7708-77638 floor coating can be applied with conventional spray equipment, airless or brush and hard roller. Two coats are suggested for floors in high traffic areas; allow 3 to 4 hours dry time between coats

Dry Time:

Dust free:	1 hours
Dry to handle:	2 1/2 hours
Full cure:	3 - 5 days
Time to recoat:	3 - 4 hours

(Continued on page 2)

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

www.cardinalpaint.com

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APPLICATION EQUIPMENT: Most air quality regulations require the paint application transfer efficiency to be 65% or better. This can be accomplished by using 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. Strong solvents such as acetone provide adequate cleaning.

PRODUCT LIMITATIONS:

- Optimum film properties are dependent upon proper mixing of paint and catalyst.
- Orders for custom colors have a minimum of 25 gallons.

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.

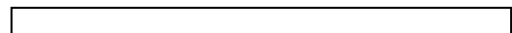
Avoid contact with eyes, skin, and clothing. Wash thoroughly after handling.

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

7708-77638 (example)

Color number

Gloss: 0 = flat; 1 = 10°; 2 = 20° . . . etc.

Special: e.g., 6 = primer

Product type

G12TL

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.