



HIGH BUILD MAINTENANCE PRIMER

EPOXY COATING

DESCRIPTION: Cardinal's 7063-18 primer is a two-component high build modified polyamide cured epoxy coating designed to comply with the most stringent air quality rules for architectural and maintenance coatings. This product meets the VOC limits for general metal primer limits of 2.83 lb/gal (340 g/l) established by the SCAQMD and other California air quality management districts. The 7063-18 is well suited for surfaces that cannot be blasted but still require excellent weather, corrosion and chemical resistance.

INTENDED USAGE: This product is designed for applications where a high build chemical and corrosion resistant primer is necessary. Such applications would include: chemical plants, refineries, water treatment facilities, tank farms and power plants. This primer can be applied directly to steel substrates for stand alone protection or as a primer for application of a high performance industrial topcoat or maintenance coating. This primer is suitable for coating of structural steel components.

COLOR & GLOSS SELECTION: Light Gray/Semi Gloss

COVERAGE: 1100 Sq. ft. @ 1.0 mil dry film thickness and 100% transfer efficiency.

MIX RATIOS:

For general industrial metal priming- spray applied: 4 parts 7063 -18 (primer) to 1 part 706HE (hardener) to 1/2-part 706HE: VOC Content = 310 g/l (2.583 lb/gal)

	PAINT	706HE	706-02
VOC CONTENT (G/L)	267 g/l	214 g/l	848 g/l
VOC CONTENT (LBS/GAL)	2.22 lbs/gal	1.79 lbs/gal	7.07 lbs/gal
WEIGHT PER GALLON (LBS/GAL)	12.81	8.19	7.07
WEIGHT SOLIDS	82.64%	78.19%	0.00%
VOLUME SOLIDS	68.91%	74.31%	0.00%

POTLIFE: 6-8 hours. @ 77°F (25°C)

SHELF LIFE: 1 year @ 50 to 100 °F

INDUCTION TIME: 20 - 30 minutes

(over)

IMPORTANT: Warranty and Disclaimer – The performance characteristics of these product vary according to the product application, operating conditions, materials applied to or use. Since these factors can affect results, we strongly recommend that you make your own tests to determine your satisfaction whether the product is of acceptable quality, has not been affected by storage or transportation and is suitable for your particular purpose under your own operating 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.

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SURFACE PREPARATION; All surfaces to be coated must be free of dirt, grease, oil, mill scale, blistering, rust, peeling, or other surface defects which cause adhesion problems. When blast cleaning is not possible, wire brushing to SSPC SP3 is acceptable. Surface should be free of grease, oil, salts or other contaminants.

STEEL - Clean metal well. Older, weathered surfaces or surfaces with multiple coats of old paint sandblasted to a 1.0 to 1.5 mil profile is suggested.

ALUMINUM - New aluminum may require pretreatment primer

For General Application: 4860-50 or 3860-50 Pretreatment Primer

GALVANIZED - Remove pretreatment from surfaces. Aging or pickling improves adhesion. Cardinal's W-303-A Surface Preparation helps improve adhesion.

PLASTIC - Light scuff sanding will ensure maximum adhesion. Primer may be necessary for some plastics.

MIXING INSTRUCTIONS:

For General Industrial Applications:

Mix four (4) parts 7063-18 primer to one (1) part 706HE hardener to ½ part 706-02 epoxy reducer
[1 gallon (128 oz) Paint - 1 quart (32 oz) hardener - 1 pint (16 oz) reducer]

APPLICATION INSTRUCTIONS: Thinning depends upon temperature and application equipment. In most cases, thinning may not be required. Avoid application of coating when temperature is below 50°F. A minimum coat of 5 mils is recommended to attain best performance properties. Up to 10 mils can be applied in one coat without sag. The 7063-18 primer can be applied with conventional spray equipment, airless, or brush and hand roller .

	Wet Mils	Dry Mils
For General Metal Application: 7063-18 High Build Epoxy Primer	5.0 - 10.0	3.0 - 6.0
For High Performance Maintenance: 7063-18 High Build Epoxy Primer	8.0 - 14.0	6.0 - 10.0

DRYING TIME: Substrate temperature: 20° C (68° F)

Dust free	:	1 hour
Dry to handle	:	2 1/2 hours
Full Cure	:	3 - 5 days
Time to recoat	:	Overnight

TOPCOAT APPLICATION: For applications which require exterior durability or abrasion resistance, apply Cardinal 6400 Series High Solid polyurethane topcoat to 2.0 to 6.0 mils wet thickness. Subsequent dry film will be 1.0 to 3.0 mils. Maximum 3.0 wet mils per coat. Use lower fluid pressures than normal as high solids paint builds faster than conventional acrylic or urethane enamels.

NOTE: MUST BE TOP-COATED WITHIN 24 HOURS FOR INTER-COAT ADHESION; SCUFF SANDING IS RECOMMENDED IF NOT TOP-COATED WITHIN 24 HOURS.