



product  
information

## 4100 SERIES

### ACRYLIC AIR DRY ENAMEL

Cardinal's 4100 series is an acrylic enamel coating designed fast drying and quick packaging. It can be used on unprimed cold rolled steel and other primed metal substrates.

#### TYPICAL USES:

- Business Machines
- Decorative Metal
- Marking and identification

#### BENEFITS:

- Fast dry
- Low VOC content
- Easy to apply
- RoHS / WEEE Compliant

#### CURED FILM PROPERTIES:

Unless otherwise indicated, testing conducted on 4108-10 gloss white at 1.5 mils DFT (Dry Film Thickness) over 20 gauge Bonderite 1000 test panel, cured 7 days air dried in ambient room temperature (78 F)

TEST	METHOD	PARAMETERS	RESULT
Adhesion	ASTM D3359	Cross-hatch tape	0% loss
Impact	ASTM D2794	Direct	20 in. lbs
Hardness	ASTM D3363	Pencil HB - H	F

#### TROUBLE SHOOTING:

PROBLEM	CAUSE	REMEDY
Bubbles and blisters	Gas entrapment	Add 1 oz/gal SB-09
Paint spatter	Spray tip obstructed	Clean with lacquer thinner.
Runs and sags	Paint too wet	Spray further away from part while applying. Speed up rate of application.
Dry spray	Paint too dry	Spray closer to part while applying. Slow down rate of application.

#### PRODUCT IDENTIFICATION

**4108-11350** (example)

Color number

Gloss: 0 = flat; 1 = 10°; 2 = 20° . . . etc.; 70° - 80°+ = high gloss

Special: eg., 2 = metallic; 3 = hammer; 4 = texture; 6 = primer; 7 = clear

Product type

FOR INDUSTRIAL USE ONLY  
NOT FOR RESIDENTIAL USE

**TYPE:** Acrylic enamel

**COMPONENTS:** One

**COLORS:** Full range including metallics.

**GLOSS:** High, semi and flat.

**COVERAGE:** 575 sq ft per gallon at DFT 1.0 mil. @ 100% TE

**VOC CONTENT: (AS SUPPLIED)**  
518 GRAMS/LITER (4.32 LBS/GAL)

**VOLUME SOLIDS:** 33% -36%

**FLASH POINT:** 24°F TCC

**SHELF LIFE:** 6 months from date of manufacture.

#### APPLICATION:

Thoroughly mix the paint prior to reducing. Apply a uniform coating to the specified substrate. Brushing, rolling and dipping are not recommended. See Surface Preparation and Priming section for further instructions.

**RECOMMENDED FILM THICKNESS:** 1.0 – 1.5 mils

**CURE:**

	<u>Air Dry</u>
Tack free	10 min.
Dry to handle	30 min.
Dry hard	2 hrs.

(At 1.5 mils dry film thickness, 78° F, 50% RH)

**CLEAN-UP:** Clean up should be done as soon as possible. The drier the paint, the more resistant it is to clean up. Air quality regulations may limit allowable emissions from cleaning operations.

#### PRODUCT LIMITATIONS:

- Not intended for exterior applications.
- For industrial use only.

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NO WARRANTY EXPRESSED OR IMPLIED, ACCEPTABILITY TO BE DETERMINED BY USER, SPECIFICATIONS ARE SUBJECT TO CHANGE WITHOUT NOTICE

**Safety:** Contains organic solvents. Use with adequate ventilation - do not breath vapors or spray mists. If component TLVs are exceeded, a NIOSH approved air supplied respirator is advised. See MSDS for TLV information.

Contents are extremely FLAMMABLE and are under PRESSURE. Do not puncture or incinerate. Keep from heat, sparks or open flame. Exposure to heat may cause bursting.

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.

*Inhalation*, remove to fresh air.

**RELATED PRODUCTS:**

PRODUCT NO.	DESCRIPTION
A-4100 Series	Acrylic aerosol

C12TL