



product
information

6771-CLE21231-B
POLYURETHANE
SEMI GLOSS CLEAR BEADED

Cardinal's 6771-CLE21231-B is a clear semi gloss low VOC two-component beaded polyurethane coating. This coating is well suited for interior applications on plastic. The 6771-CLE21231-B was formulated to meet strict air quality regulations, while maintaining the application and performance benefits of a conventional polyurethane coating.

TYPICAL USES:

- Top coat for decorative and protective use on plastic.
- Electronic enclosures

BENEFITS:

- Excellent chemical and solvent resistance
- 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 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.

Plastic — All mold release should be completely removed. 6771-CLE21231-B 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 6771-CLE21231-B attacks or weakens the plastic, a barrier coat of 3777-1 clear waterborne acrylic enamel may help.

PRIMER SELECTION:

PRODUCT NO.	DESCRIPTION	FUNCTION
3777-1	Waterborne Acrylic Clear	Barrier coat for some plastics

RELATED PRODUCTS:

PRODUCT NO.	DESCRIPTION
1600 Series Reducers	Thinners. Urethane grade. 1600-01, fast; 1600-02, medium; 1600-03, slow; 1600-06, very slow.
EL-005	Accelerator. Speeds up dry time (and shortens pot life).
J-3081	Surfactant. Helps eliminate blisters, bubbles, pin holes, solvent-pop.
P-5033	Surfactant. Helps eliminate craters and fish-eyes.

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

TYPE: Aliphatic acrylic polyurethane.

COMPONENTS: Two.

COLORS: Clear.

GLOSS: Semi gloss.

COVERAGE: At 1.0 mil DFT, 65% transfer efficiency(TE)

Mixed paint, 3.5 lbs/gal : 365 ft²/gal.

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

VOC MIXED:

43 grams/liter = 0.35 lbs/gal excluding exempt

20 grams/liter = 0.17 lbs/gal including exempt

See mix ratio table below.

VOLUME SOLIDS:

6771-CLE21231-B..... 44%

6SLVH 40%

Mixed to 3.5 lbs/gal 35%

FLASH POINT: -4°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.

- 3 parts 6771-CLE21231-B (by volume)
- 1 part 6SLVH catalyst
- 1 part HP-439

VISCOSITY: 19"-21" #2 Zahn can be expected for most colors.

SPRAY-able Pot Life: 2 hrs. at 3.5 lbs. VOC/gal

Note: If material is accelerated the actual pot life may vary depending on amount added.

RECOMMENDED DFT: 1.5 – 2.5 mils (depending on color)

CURE:	<u>Air Dry</u>	<u>Force Dry *</u>
Tack free	2 hrs.	1 hr at 120° F
Dry to handle	24 hrs.	30 min at 140° F
Dry hard	72 hrs.	15 min at 180° F
(At 1.5 mils dry film thickness, 78° F, 50% RH)		

* Some Air quality regulations require a maximum temp. of 194° F to qualify as an "air dry" system which generally have higher VOC limits than baking systems.

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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.

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:

- 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.

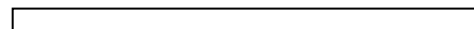
Avoid contact with eyes, skin, and clothing. Wash thoroughly after handling.

FIRST AID:

Eye contact: flush immediately with plenty of water for at least 15 min. and get medical attention.

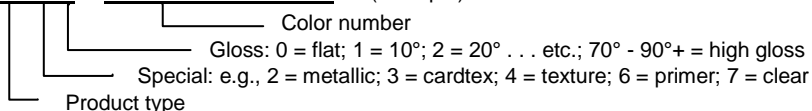
Skin contact: wash thoroughly with soap and water for 5 minutes.

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



PRODUCT IDENTIFICATION

6771 - CLE21231 - B (example)



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.