



product  
information

**7063-SERIES**  
**HIGH BUILD EPOXY PRIMER**

**Cardinal's 7063-Series** primer is a high solids two-component modified cycloaliphatic amine coating designed for use on metal where chemical and corrosion resistance is essential. The 7063-Series is formulated to meet strict air quality regulations.

**TYPICAL USES:**

- Primer for protective use on metal, products.
- Primer coat of maintenance coating system.
- Machinery.
- Marine equipment.
- 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. Cardinal's W-303-A surface preparation solution will help improve adhesion.

**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, Black, White, Red Oxide

**GLOSS:** Semi gloss.

**COVERAGE:** At 1.0 mils DFT at 100% transfer efficiency.  
Mixed paint, VOC at 250 gms/liter: 1100 ft<sup>2</sup>/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:** 7063 = 24°F TCC

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

**APPLICATION:** After preparing the surface, mix the components together well in the amount needed for use within the sprayable pot life. The base to hardener proportion must be measured accurately to obtain optimum film properties. Brushing, rolling dipping are not recommended.

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

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

Parts by volume	
7063- base	3 parts
7063- hardener	1 part

**RECOMMENDED FILM THICKNESS:** 2.0 – 6.0 mils

**Cure:**

Dust free:	3 hours
Dry to handle:	8 hours
Full cure:	5-7 days
Time to recoat:	After 4 hrs & before 72 hours

After 72 hours, a scuff sanding of the surface is required.

**SPRAYABLE POT LIFE:** 3 hours at 77°F (25°C)

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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.

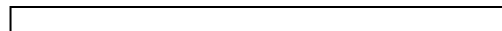
Avoid contact with eyes, skin, and clothing. Wash thoroughly after handling.

**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**

**7 0 6 3 - 4 7 0 2** (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.