



product
information

4600-SERIES
ACRYLIC AIR DRY ENAMEL

Cardinal®4600-Series is a solventborne thermoplastic acrylic coating designed to be used on a variety of plastic substrates.

TYPICAL USES:

- Sign Industries
- General Plastic finishing

BENEFITS:

- Excellent Durability
- RoHS / WEEE compliant

CURED FILM PROPERTIES:

Testing conducted on 4600-10 flay white at 2.0 mils DFT (Dry Film Thickness) over 20 gauge Acrylic plastic test panels, force dried 30 minutes at 180°F, then air dried for 14 days.

TEST	METHOD	PARAMETERS	RESULT
Impact:	ASTM D2794	Direct	120 in. lbs.
		Reverse	100 in. lbs.
Flexibility:	ASTM D1737	1/8" mandrel	No cracking
Hardness	ASTM D3363	Pencil	F - H

REPAIR OR REFINISHING: Clean surface to be repainted, remove dirt, grease, oil, and all other contaminants. Abrade surface if necessary. Tack surface clean.

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.

Plastic — All mold release should be completely removed. 4P89-WHE18595-S Acrylic Air Dry Enamel 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 4P89-WHE18595-S attacks or weakens the plastic, a barrier coat of 3P77-1 clear waterborne acrylic enamel may help.

FOR INDUSTRIAL USE ONLY
NOT FOR RESIDENTIAL USE

TYPE: Acrylic.

COMPONENTS: One.

COLORS: Any

GLOSS: Flat.

COVERAGE: At 1.0 mil DFT.

630 ft²/gal. at 100% transfer efficiency (TE)

410 ft²/gal. at 65% TE

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

VOC: (as supplied)

542 grams/liter = 4.51 lbs/gal less water

542 grams/liter = 4.51 lbs/gal including water

VOLUME SOLIDS: 37 - 40%

FLASH POINT: 59°F TCC

SHELF LIFE: 6 months from date of manufacture in factory sealed container.

Mix Ratio: As follows

Parts are by volume	COLORS GLOSS
4600-Series	1
SB-44	1

APPLICATION: Thoroughly stir or agitate paint before applying. This material is designed for spray application. Brushing, rolling and dipping are not recommended. See surface preparation and priming section for further instructions.

Thinning: After mixing material is ready to spray. Avoid over thinning.

VISCOSITY: 2000 -6000 cps. at 78°F.
The viscosity will vary depending on color.

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

Cure: Air Dry

Dust free 15-30 min.

Tack free 1-1/2 hrs.

Dry hard 8-12 hrs.

Full cure 24 hours

Force Dry

Dry hard 1 hour at 140° F

30 min. at 180° F

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

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

Related Products:

PRODUCT NO.	DESCRIPTION
SB-03	Slow Reducer
SB-17	Exempt Slow Reducer
SB-26	Slow Reducer
6SLA-100	Surface Additive

Trouble Shooting:

PROBLEM	CAUSE	REMEDY
Too thin / low viscosity	Over reduced.	Remix at correct ratio
Dry spray	High atmospheric temperature. Over atomization Gun to part distance	Increase fluid pressure & decrease atomizing pressure. Reduce with SB-17: 1% - 2%. Add SB-17 at rate of 1 oz./gal.
Craters	Contamination of substrate, application equipment or environment.	Find and eliminate source of contamination. When craters persist, add 1/2 oz./gal of 6SLA-100 additive.
Poor adhesion	Improper surface preparation.	See surface preparation section.

EQUIPMENT CLEAN-UP: 1000-13 should always be used for primary cleaning. If something different is needed exempt solvents can be used for secondary cleaning, air quality regulations, in your area may have limited the allowable emissions from cleaning operations.

Product Limitations:

- Storage stability is limited to 6 months.

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.

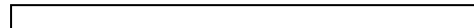
Avoid contact with eyes, skin, and clothing. Wash thoroughly after handling.

FIRST AID:

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

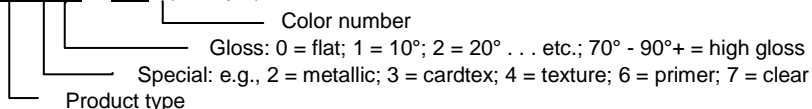
Skin contact: wash thoroughly with soap and water for 5 minutes.

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



PRODUCT IDENTIFICATION

4600 - 10 (example)



I13TL

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.