



product  
information

**6732-SERIES**  
POLYURETHANE HAMMER FINISH

**Cardinal's 6732-SERIES** is a high performance two component solvent borne aliphatic polyurethane hammer finish. The system forms a hammer when sprayed. The system exhibits good exterior performance, chemical resistance and a durable finish.

**TYPICAL USES:**

- High Performance requirements
- Outdoor applications
- General Industrial

**BENEFITS:**

- HAPS FREE
- Excellent chemical and solvent resistance
- Exterior grade pigments
- Excellent Weathering
- RoHS & WEEE Compliant

**TYPE:** Solvent based Acrylic Polyester Polyurethane.

**COMPONENTS:** Two.

**COLOR:** Full range of colors, 595C and specialty colors.

**GLOSS:** 20 +/- 5° Degrees. ( Degree of texture effects gloss)

**COVERAGE:** At 1.0 mil DFT, 65% transfer efficiency(TE)  
Mixed paint: 526 ft<sup>2</sup>/gal.  
Calculation: 1604 ft<sup>2</sup>/gal x % volume solids x TE ÷ DFT

**MIX RATIOS & VOC INFORMATION:**

Paint	340-HP	1600-02	VOC	VOC	Volume	Weight
6732-Series	Hardener	Reducer	Excluding	Including	Solids	Solids
4 Parts	1 Part	1 Part	420 g/l	420 g/l	47%	38%

**VOLUME SOLIDS:**

6732-Series.....52%  
340-HP .....91%

**FLASH POINT:** >24 °F TCC

**VISCOSITY:** 20"-25" #2 Zahn range.

**SPRAY-ABLE POT LIFE:** 2-3 hours not accelerated

**RECOMMENDED DFT:** 2.0 – 3.0 mils (depending on color)

**APPLICATION CONDITIONS:**

- When applying this material it is important to atomize the coating to create the hammer finish. The finer the atomization the more controlled the hammer effect is. Match spray technique with the desired hammer finish.
- Temperature- Apply coating within the range 55-100 F
- Relative Humidity- not recommended to apply in conditions greater than 85%
- Substrate temperature- 5° above the dew point and a minimum of 55°F

*If coating is not applied within these conditions then the cured coating properties may be representative.*

**EQUIPMENT:**

- Conventional- 40-50 psi / 0.055 fluid tip
- HVLP- 10 psi at air cap/ 0.055 fluid cap
- Pressure pot- 10-15 psi/ 0.046 fluid cap

**SHELF LIFE:** 1 year from date of manufacture in factory sealed container.

**DRY TIMES:**

<b>AIR DRY (2.0 mil dft, 75 F @ 50% RH)</b>	
Dust free	2 hours.
with 1oz/gal EL-005 accelerator	1 hour
Dry to touch	24 hours
with 1oz/gal EL-005 accelerator	12 hours.
Dry to recoat	2 hours.
with 1oz/gal EL-005 accelerator	1.5 hours
Dry to hard	72 hours
with 1oz/gal EL-005 accelerator	48 hours

**PHYSICAL PROPERTIES:**

All testing conducted on primed 7760 Bondrite 1000 phosphated Panels and were air dried for seven days at 75F@50%RH.

TEST	METHOD	PARAMETERS	RESULT
Hardness	ASTM D3363	Pencil	2H
Abrasion	ASTM D4060	CS 10, 1 Kg, 1000 Cycles	Less than 100 mg
Adhesion	ASTM D3359	Cross-hatch tape	0% failure
Flexibility	ASTM D1737	1/8" mandrel	No cracking
Salt Spray	ASTM B117	1000 hours	No effect
UV Resistance	ASTM G53	1000 hours QUV A	> 90% gloss retention
Impact	ASTM D2794	Direct	130 Direct, 60
		Reverse	Reverse
Humidity	ASTM D2247	100 hrs	No effect
Solvent Resistance	ASTM D4752	MEK 50 rubs	No effect
		IPA 100 rubs	No effect
Chemical & Stain Resistance	ASTM D1308 30 min. spot	A: No effect	A – IPA, hydrogen peroxide, 409®, toluene, hydrochloric acid, textile spirits, amyl acetate, trichloroethylene, methanol, ethylene dichloride, lacquer thinner, xylene, ethanol, ammonia, gasoline, motor oil, coffee, tea.
		B: Slight dulling	B – Acetone, MEK.
		C: Moderate effect	C – 50% sulfuric acid, 2.5N sodium hydroxide
		D: Discolored & softened	

(Continued on page 2)

So. El Monte, CA 1329 Potrero Ave. 91733 (323) 283-9335 (626) 444-9274 Fax (626) 444-0382

[www.cardinalpaint.com](http://www.cardinalpaint.com)

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

**RECOMMENDED COATING SUBSTRATE SYSTEMS:****ALUMINUM:**

## Prep

- Abrade surface with 220 or 400 grit sandpaper.
- Clean with W-500A or W-303A metal cleaning solution.

## Primer

- 7760-10 epoxy primer (2-3 dry mils/ 6-7 wet mils)
- 7260-4702 Fast dry primer (2-3 dry mils/6-7 wet mils)
- 6460-4257 Polyester Spray fill (2-3 dry mils/ 4-5 wet mils)
- 7065-10 High build epoxy (2-3 dry mils/ 4-5 wet mils)
- 4860-52 Etch primer (0.2-0.5 dry mils/ 5-10 wet mils)

## Adhesion Promoter for clear coating Aluminum

- 6SAP-100 Metal adhesion promoter (0.15-0.30 dry mils/ 2-4 wet mils)

## Topcoat

- 6S00 series semi or gloss pigmented (1.5-2.5 dry mils depending on color)
- 6S00 series semi or gloss clear (2.0 dry mils)

**STEEL:**

## Prep

- Abrade surface with 220 or 400 grit sandpaper.
- Clean with W-500A or W303A metal cleaning solution.

## Primer

- 7760-10 epoxy primer (2-3 dry mils/ 6-7 wet mils)
- 7260-4702 Fast dry primer (2-3 dry mils/6-7 wet mils)
- 6460-4257 Polyester Spray fill (2-3 dry mils/ 4-5 wet mils)
- 7065-10 High build epoxy (2-3 dry mils/ 4-5 wet mils)
- 4860-52 Etch primer (0.2-0.5 dry mils/ 5-10 wet mils)

## Topcoat

- 6S00 series semi or gloss pigmented (1.5-2.5 dry mils depending on color)

**BRASS/COPPER:**

## Prep

- Once substrate is polished spray with W-900 anti tarnish solution prior to coating

## Adhesion Promoter

- 6SAP-100 Metal adhesion promoter (0.15-0.30 dry mils/ 2-4 wet mils)

## Topcoat

- 6S00- series anti-tarnish clear coats 6S73-3010 and 6S79-3010 (2.0 dry mils)

**GLASS:**

## Prep

- Clean surface of glass with glass cleaner

## Prime

- 7260-4702 Fast dry primer (1.5-2.0 dry mils/3-6 wet mils). Not compliant to SCAQMD rule 1145.

## Adhesion Promoter

- W-805A glass adhesion promoter.

## Topcoat

- 6S00 series semi or gloss pigmented (1.5-2.5 dry mils depending on color)
- 6S00 series semi or gloss clear (2.0 dry mils)

**PLASTICS:** Polycarbonate, Polyurethane, ABS, Fiberglass, Acrylic, PVC & TPO.

## Prep

- If necessary remove any mold release with Cardinal W-502P plastics cleaner or acetone if permitted.
- Light sanding with a 400 grit sandpaper will help adhere to difficult substrates.

## Prime

- 6760-E12426 Acrylic primer (1.5-2.0 dry mils/ 3-6 wet mils). Compliant to SCAQMD rule 1145.
- 7260-4702 Fast dry primer (1.5-2.0 dry mils/3-6 wet mils). Not compliant to SCAQMD rule 1145.
- 6460-4257 Polyester spray fill primer (1.5-2.0 dry mils/ 2-4 wet mils). Not compliant to SCAQMD rule 1145.

## Adhesion Promoter

- W-700A plastics adhesion promoter for polyolefin type plastics
- 6SAP-200 tie coat adhesion promoter for difficult to adhere plastics.

## Topcoat

- 6S00 series semi or gloss pigmented (1.5-2.5 dry mils depending on color)
- **NOTE: check adhesion of primer or adhesion promoter before top coating.**

**WOOD:**

## Prep

- Sand surface with 220 or 400 grit sandpaper

## Prime

- 6760-E12426 Acrylic primer (2-3 dry mils/ 3-6 wet mils)
- 6460-4257 Polyester spray fill primer (1.5-2.0 dry mils/ 2-4 wet mils).

## Topcoat

- 6S00 series semi or gloss pigmented (1.5-2.5 dry mils depending on color)
- 6S00 series semi or gloss clear (2.0 dry mils)

**MASONRY:**

## Prep

- Acid wash surface and allow to dry before coating

## Prime

- 7760-10 epoxy primer (2-3 dry mils/ 6-7 wet mils)
- 7260-4702 Fast dry primer (2-3 dry mils/6-7 wet mils)
- 6460-4257 Polyester Spray fill (2-3 dry mils/ 4-5 wet mils)
- 7065-10 High build epoxy (2-3 dry mils/ 4-5 wet mils)

## Topcoat

- 6S00 series semi or gloss pigmented (1.5-2.5 dry mils depending on color)

**ADDITIONAL PRODUCT INFORMATION:****REDUCERS FOR 6700-SERIES**

- 1600-01 fast reducer
- 1600-02 medium reducer
- 1600-03 slow reducer
- HP-439 Exempt reducer

**ADDITIVES TO COMPLIMENT 6700-SERIES**

- 6SFP-100 zero VOC flattening paste
- EL-005 Accelerator
- JS-3081 Anti crater additive

For Health information refer to Material Safety Data Sheet

FOR INDUSTRIAL USE ONLY  
NOT FOR RESIDENTIAL USE

G12TL