

Product Data Sheet

Cromadex Liquid Coatings Cromadex 400 Topcoat One Pack Lower Odour Polyurethane Topcoat

Product Description

Cromadex 400 is a one pack lower odour topcoat using polyurethane technology providing excellent gloss and colour retention. The product is an automotive standard product with proven performance.

The product has a long wet edge making it easier to apply to large items with no dry spray.

Cromadex 400 is available in the full Cromadex range of colours and gloss levels, including BS, RAL, metallic, sparkles and special matches all in a lead free finish.

Extra Life

Life expectancy of up to 6 years in a C3* external environment when used with a suitable Cromadex primer. See Extra Life brochure for full details.

* as determined in ISO12944

Products and Ancillaries

400 Topcoat	05-44 Thinner
05-46 Thinner	

Suitable Substrates and Preparation

Mild Steel	Degrease with Cromadex 678 Spirit Wipe and abrade steel with P180. If necessary blast clean to remove millscale, minimum surface preparation SA2. Apply suitable Cromadex primer
Aluminium & Galvanised Steel	Apply Cromadex 903 Chromate-Free Etch Primer (then other Cromadex primer is required to increase film build)
Stainless Steel	Use of Cromadex 903, AQ58, 750 or 850 primer is required

Application Details

Thinning Ratio	5 parts 400 Topcoat 1 part 05-44/05-46 Thinner (dependent on application equipment)	
Spraying Viscosity	45 – 65 seconds ISO Cup4 @ 20°C 25 – 30 seconds BS 4 Cup @ 20°C	
Approved Thickness	25 – 35 microns DFT	55 – 75 microns WFT
Spray Gun	Fluid tip size	Working pressure
<i>Conventional</i>	1.4 – 1.8 mm	3.5 – 4.2 bar
<i>Suction Feed HVLP</i>	1.4 – 1.8 mm	0.7 bar (max)
<i>Pressure Feed HVLP</i>	1.0 – 1.4 mm	0.7 bar (max)
<i>Airless</i>	9 – 13 thou	Fluid pressure approx 2000 psi
<i>Air Assisted Airless</i>	11 – 13 thou	Air Assist pressure 20-30 psi
Electrostatic	Resistivity will require adjustment. Please inform your local Cromadex centre at time of purchase.	
Brush/Roller	Suitable	
Heated Methods	Reduce thinning ratios as required	

Cromadex 400 Topcoat

Drying and Overcoating	Substrate Temperature	Drying Times		Overcoating Times	
		Touch Dry	Through Dry	Minimum	Maximum
	20°C	3 hours	12 hours	1 hour	24 hours
	35°C	2 hours	10 hours	45 mins	20 hours
	Force Drying	Flash-off for 10-15 mins, then 60-80°C for 30 mins			
	Full Properties	7 days			
Storage and Handling	Storage	Storage should be in accordance with the instructions in Section 7 of the relevant material safety data sheet			
	Shelf Life	12 months in an unopened, original container from date of mixing at Cromadex centre			
	Pack Size	5 & 20 litres			
Physical Properties	Volume Solids	45 % mixed, dependent on colour and gloss			
	Colour	Full range available including BS, RAL, metallics, sparkles and special matches – all lead chromate free			
	Gloss	Full gloss (90% min) Eggshell (30%) Plus intermediates on request		Semi gloss (60%) Matt (10%)	
		Measured at 30-35 microns DFT & 60° reflectance A variance of +/-5% may be obtained dependent on application process			
	Coverage	17.8 m ² /l @ 25 microns, assuming 100% transfer efficiency			
			VOC		Specific Gravity
	400 Topcoat	450 g/l (dependent on colour & gloss)		1.07 (dependent on colour & gloss)	
	05-44 Thinner	769 g/l		0.77	
	05-46 Thinner	867 g/l		0.87	
Safety Precautions and Disclaimer	Before using this product please refer to the Cromadex Material Safety Data Sheet.				
	The information contained in this data sheet is not intended to be exhaustive, and any person using the product without first obtaining written confirmation from us as to the suitability of the product for the intended purposes, does so at their own risk. Whilst we endeavour to ensure that all advice we give about the product (whether in this sheet or otherwise) is correct, we have no control over either the quality or condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree to do so, we do not accept any liability whatsoever arising from the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of the use of this product. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.				
	It is the user's responsibility to check that this data sheet is current prior to using the product.				