

Product Data Sheet

Cromadex Liquid Coatings Cromadex 683 Primer Finish Two Pack Polyurethane Eggshell Primer Finish

Product Description

Cromadex 683 is a two pack eggshell primer finish; the high quality resin and curing agent help to produce excellent long term colour stability.

The product contains zinc phosphate giving added corrosion resistance for greater durability.

Cromadex 683 is available in full Cromadex range of colours, including BS, RAL, and special matches all in a lead free finish.

Products and Ancillaries

683 Primer Finish	690 Curing Agent
25-03 Thinner	No 6 Thinner
Pot Life Extender	

Suitable Substrates and Preparation

Degreasing with Cromadex 678 Spirit Wipe is recommended and should be carried out after any abrasion of the surface

Steel	Degrease and abrade with P180. If necessary blast clean to remove millscale, minimum surface preparation SA2
Aluminium & Galvanised Steel	Degrease and abrade with P240 to remove surface oxide layer. For even greater system performance apply Cromadex 903 Chromate-Free Etch Primer (then other Cromadex primer if required to increase film build)
Stainless Steel	Use of Cromadex 903, AQ58, 750 or 850 primer is required.
GRP	Remove release coat, degrease and abrade with P280. Primer with Cromadex 750 primer.
Powder Coating	Degrease and abrade with P280. Prime as necessary with Cromadex 750 or 850 primer.

Application Details

Mixing Ratio	8 parts 683 Primer Finish 1 part 690 Curing Agent Thinning not normally required, dependent on application equipment	
Pot Life	4 hours @ 20°C (dependent on colour) For extended life, add 150 mls of Cromadex Pot Life Extender per 5 litres of base (prior to mixing with curing agent)	
Approved Thickness	70 – 90 microns DFT	125 – 155 microns WFT
Spray Gun	Fluid tip size	Working pressure
<i>Pressure Pot HVLP</i>	1.0 – 1.4 mm	0.7 bar (10 psi)
<i>Airless</i>	11 – 13 thou	2,200 – 2,700 psi
<i>Air Assisted Airless</i>	11 – 13 thou	1,800 – 2,200 psi and 20 – 30 psi air pressure

Cromadex 683 Primer Finish

Drying and Overcoating	Substrate Temperature	Drying Times		Overcoating Times	
		Touch Dry	Through Dry	Minimum	Maximum
	20°C	30 mins	6 hours	Not applicable	
	Note: Wet edge can be extended with use on No 6 Thinner For information on Pot Life Extender please consult the data sheet				
	Force drying	Flash off for 20 mins, then 60 – 80°C for 30 mins Note: force drying may result in change of gloss level			
	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 litres			
Physical Properties	Volume Solids	59 % (mixed, dependent on colour)			
	Colour	Full range available including BS, RAL and special matches – all lead chromate free			
	Gloss	Eggshell (30%) Measured at 70-75 microns DFT & 60° reflectance A variance of +/-5% may be obtained dependent on application process			
	Coverage	7.9 m ² /l @ 75 microns (dependent on colour), assuming 100% transfer efficiency			
			VOC	Specific Gravity	
	683 Primer Finish	363 g/l (dependent on colour)	1.60 (dependent on colour)		
	690 Curing Agent	207 g/l	1.09		
	25-03 Thinner	873 g/l	0.87		
	No 6 Thinner	870 g/l	0.87		
	Pot Life Extender	876 g/l	0.97		
Safety Precautions and Disclaimer	<p>Before using this product please refer to the Cromadex Material Safety Data Sheet.</p> <p>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.</p> <p>It is the user's responsibility to check that this data sheet is current prior to using the product.</p>				