Product Data Sheet

Cromadex Liquid Coatings
Cromadex 800 Topcoat
Two Pack Non-Isocyanate Acrylic Topcoat

Product Description

Cromadex 800 is a two pack non-isocyanate acrylic topcoat with excellent exterior durability and chemical resistance. The product uses unique resin and pigment technology to enable a wide variety of applications and a durable finish.

The product is formulated without isocyanate helping to reduce health and safety concerns.

The product is also available in aerosols to help with on-site Interpon® powder coating repairs.

Cromadex 800 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 9 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

800 Topcoat	No 6 Thinner	No 3 Thinner
800 Curing Agent	25-03 Thinner	

Suitable Substrates and Preparation

Mild Steel	Degrease with 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
GRP	Remove release coat, degrease and abrade with P280
Powder Coating	Degrease and abrade with P280
Plastics	Direct adhesion to ABS, Noryl & PU Foam (Rigid), HIPS, Acrylic, uPVC, Polycarbonate, PVC and PU Foam (flexible). Clean with a suitable anti-static cleaner prior to coating. For Polypropylene use an adhesion promoter

Application Details

Mixing Ratio	5 parts 800 Topcoat 1 part 800 Curing Agent 1-2 parts 25-03 Thinner (dependent on application equipment) **Note**: 800 clear lacquer mixing ratio is 4:1 (base:curing agent)	
Spraying Viscosity	45 – 70 seconds ISO Cup4 @ 20°C 25 – 30 seconds BS Cup4 @ 20°C	
Pot Life	8 hours @ 20°C (dependent on colour)	
Approved Thickness	25 – 35 microns DFT	70 – 80 microns WFT

Cromadex 800 Topcoat

Application Details

Spray Gun	Fluid tip size	Working pressure
Conventional	1.4 – 1.8 mm	3.5 – 4.2 bar
Suction Feed HVLP	1.4 – 1.8 mm	0.7 bar (max)
Pressure Pot HVLP	1.0 – 1.4 mm	0.7 bar (max)
Airless	11 – 18 thou	
Electrostatic	Resistivity will require adjustment. Please inform your local Cromadex centre at time of purchase	

Drying and Overcoating

Substrate Temperature	Drying Times		Overcoating Times	
	Touch Dry	Through Dry	Minimum	Maximum
20°C	15 mins	4 hours	wet-on-wet	Indefinite
35°C	10 mins	3 hours	wet-on-wet	Indefinite

Note: Wet edge can be extended with use on No 6 Thinner

Force Drying Flash-off for 10-15 mins, then 60-80°C for 30 mins

Stoving Flash-off for 10-15 mins, then 120°C for 30 mins

Full Properties 7 days if air dried @ 20°C or immediately after stoving

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 and 400 ml aerosols

Physical Properties

Volume Solids 47 % 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) Semi gloss (60%)
Eggshell (30%) Matt (10%)
Plus intermediates on request
Measured at 30-35 microns DFT & 60º reflectance
A variance of +/-5% may be obtained dependent on application process

Coverage 16 m^2/l @ 30 microns, assuming 100% transfer efficiency

	VOC	Specific Gravity
800 Topcoat	466 g/l (dependent on colour & gloss)	1.14 (dependent on colour & gloss)
800 Curing Agent	491 g/l	1.00
25-03 Thinner	873 g/l	0.87
No 6 Thinner	870 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.