

Product Data Sheet

Cromadex Liquid Coatings

Cromadex 2100 Primer

One Pack Universal Primer

Product Description

Cromadex 2100 is a one pack primer containing zinc phosphate giving added corrosion resistance for greater durability. It is fast drying helping to improve productivity.

The product can be air dried or stoved giving flexibility in your production line.

Cromadex 2100 is available in white, grey, red oxide and buff as standard, it can also be tinted to ensure complete coverage even on difficult lead free colours.

Extra Life

Life expectancy of up to 3 years in a C2* external environment when used with a suitable Cromadex topcoat. See Extra Life brochure for full details.

* as determined in ISO12944

Products and Ancillaries

2100 Primer
05-46 Thinner

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

Application Details

Thinning Ratio 5 parts 2100 Primer
1 part 05-46 Thinner (dependent on application equipment)

Spraying Viscosity 45 – 55 seconds ISO Cup4 @ 20°C

Approved Thickness 25 – 50 microns DFT 70 – 140 microns WFT

Application Details

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 Pot HVLP</i>	1.0 – 1.4 mm	0.7 bar (max)
<i>Airless</i>	11 – 18 thou	2500 psi (170 bar)
<i>Air Assisted Airless</i>	11 – 15 thou	1500 – 2000 psi (100-170 bar) fluid pressure 10 – 20 psi (0.7-1.4 bar) air assist

Heated Methods Reduce thinning ratios as required

Cromadex 2100 Primer

Drying and Overcoating

Substrate Temperature	Drying Times		Overcoating Times	
	Touch Dry	Through Dry	Minimum	Maximum
20°C	25 mins	6 hours	25 mins	Unlimited
35°C	15 mins	5 hours	15 mins	Unlimited

Note: If primer is not overcoated within 14 days then abrade with either P240 or P320 and clean with Cromadex 678 Spirit Wipe

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

2100 Primer is overcoatable after the minimum drying time (above) with all Cromadex General Industrial Topcoats except 700, 740 & 742.

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 35.6 % (dependent on colour)

Colour White (nr RAL 9010), light grey (nr RAL 7035), dark grey (nr RAL 7001), red oxide & buff (nr RAL 1001)
Tinted shades available – all lead chromate free

Coverage 13-15 m²/l @ 25 microns (dependent on colour), assuming 100% transfer efficiency

	VOC	Specific Gravity
2100 Primer	527-575 g/l (dependent on colour)	1.21 (dependent on colour)
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.