

Product Data Sheet

Cromadex Liquid Coatings

Cromadex 230 Primer Stoving Primer Filler

Product Description

Cromadex 230 is a stoving primer filler containing melamine giving improved durability.

The product can be overcoated wet-on-wet enabling rapid application.

Cromadex 230 is available in white as standard, it can also be tinted to ensure complete coverage even on difficult lead free colours.

Extra Life

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

* as determined in ISO12944

Products and Ancillaries

230 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. Apply Cromadex 903 Chromate-Free Etch Primer

Application Details

Thinning Ratio 5 parts 230 Primer
1 part 05-46 Thinner (dependent on application equipment)

Spraying Viscosity 45 – 70 seconds ISO Cup4 @ 20°C

Approved Thickness 25 – 50 microns DFT 55 – 115 microns WFT

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	2500 psi (170 bar)
Air Assisted Airless	11 – 15 thou	1500 – 2000 psi (100-170 bar) fluid pressure 10 – 20 psi (0.7-1.4 bar) air assist
Disc/Bell	Please inform your local Cromadex Centre at time of purchase	
Heated Methods	Reduce thinning ratios as required	

Cromadex 230 Primer

Drying and Overcoating	Substrate Temperature	Drying Times		Overcoating Times	
		Touch Dry	Through Dry	Minimum	Maximum
	20°C	STOVING ONLY		15 mins	N/A
	Note: If primer is not overcoated within 14 days then abrade with either P240 or P320 and clean with Cromadex 678 Spirit Wipe				
	Stoving	Flash-off for 10-15 mins, then 120°C for 30 mins			
	Full Properties	Achieved after recommended stoving schedule			
	230 Primer is overcoatable after the minimum drying time (above) with all Cromadex 310 & 943 Topcoats.				
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	44.1 %			
	Colour	White Tinted shades available – all lead chromate free			
	Coverage	18 m ² /l @ 25 microns, assuming 100% transfer efficiency			
		VOC	Specific Gravity		
	230 Primer	481 g/l	1.41		
05-46 Thinner	867 g/l	0.87			
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>				