

Product Data Sheet

Cromadex Liquid Coatings

Cromadex 395 Primer Anti-Corrosive Primer

Product Description

Cromadex 395 is an anti-corrosive primer containing zinc phosphate giving added corrosion resistance for greater durability. It is higher in solids giving superb opacity and coverage.

The product has superb flow and levelling giving excellent topcoat appearance and can be used over sound existing paintwork, making it ideal for refurbishment work.

Cromadex 395 is available in off-white (nr RAL 9002) and black 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

395 Primer
05-46 Thinner
85-72 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
Sound existing paint work	Dry sand using P320-P240

Application Details

Thinning Ratio	7 parts 395 Primer 1 part 05-46/85-72 Thinner (dependent on application equipment)	
Spraying Viscosity	45 – 70 seconds ISO Cup4 @ 20°C	
Approved Thickness	35 – 45 microns DFT	75 – 100 microns WFT

Application Details

Spray Gun	Fluid tip size	Working pressure
<i>Conventional</i>	1.6 – 1.8 mm	50 – 60 psi
<i>Suction Feed HVLP</i>	2.3 mm	10 psi (max)
<i>Pressure Pot HVLP</i>	1.4 mm	10 psi (max)
<i>Airless</i>	11 – 15 thou	2500 psi (170 bar)
<i>Air Assisted Airless</i>	13 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 395 Primer

Drying and Overcoating	Substrate Temperature	Drying Times		Overcoating Times	
		Touch Dry	Through Dry	Minimum	Maximum
	20°C	30 mins	6 hours	30 mins	Indefinite
	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°C for 45 mins			
	Full Properties	7 days			
	395 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	45.8 %			
	Colour	Off-white (nr RAL 9002) & black Tinted shades available – all lead chromate free			
	Coverage	13 m ² /l @ 35 microns, assuming 100% transfer efficiency			
		VOC	Specific Gravity		
	395 Primer	470 g/l	1.27		
	05-46 Thinner	870 g/l	0.87		
	85-72 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.				