

Product Data Sheet

Cromadex Liquid Coatings Cromadex 475 Primer Finish Heat Resistant (up to 250°C) Primer Finish

Product Description

Cromadex 475 is a heat resistant primer finish suitable for items reaching temperatures of up to 250°C.

The product has a fast touch dry time helping to improve productivity. It has excellent covering power helping to reduce application costs.

Cromadex 475 is available in black.

Products and Ancillaries

475 Primer Finish
No 1 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

Application Details

Thinning Ratio 5 parts 475 Primer Finish
1 part No 1 Thinner (dependent on application equipment)

Spraying Viscosity 30 – 40 seconds ISO Cup4 @ 20°C

Approved Thickness 15 – 25 microns DFT 75 – 125 microns WFT

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>	1.8 mm	0.7 bar (max)
<i>Pressure Pot HVLP</i>	1.0 – 1.4 mm	0.7 bar (max)
<i>Airless</i>	11 – 21 thou	
<i>Air Assisted Airless</i>	11 – 15 thou	

Electrostatic Resistivity will require adjustment. Please inform your local Cromadex centre at time of purchase.

Heated Methods Reduce thinning ratios as required

Drying and Overcoating

Substrate Temperature	Drying Times		Overcoating Times	
	Touch Dry	Through Dry	Minimum	Maximum
20°C	20 mins	4 hours	Not recommended	

Full Properties When heated article is in use.

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

Cromadex 475 Primer Finish

Physical Properties

Volume Solids	18 %	
Colour	Black	
Gloss	Matt (10%) <small>A variance of +/-5% may be obtained dependent on application process</small>	
Coverage	8 m ² /l @ 20 microns, assuming 100% transfer efficiency	
	VOC	Specific Gravity
475 Primer	750 g/l	0.97
No 1 Thinner	868 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.