

Product Data Sheet

Cromadex Liquid Coatings Cromadex 630 Topcoat Two Pack Polyurethane Self Spatter Topcoat

Product Description

Cromadex 630 is a two pack polyurethane self spatter topcoat with excellent exterior durability and chemical resistance. The product's self spatter application helps hide minor substrate defects.

Cromadex 630 demonstrates good mar resistance, ideal if the end product is to be widely handled.

Cromadex 630 is a high solids product enabling it to be used as part of VOC reduction programme.

Cromadex 630 is available in a wide range of colours, including BS, RAL and special matches all in a lead free finish.

Extra Life

Life expectancy of up to 15 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

630 Topcoat	No 6 Thinner
600/630 Curing Agent	
25-03 Thinner	

Suitable Substrates and Preparation

Mild Steel	Degrease with Cromadex 678 Spirit Wipe 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
Powder Coating	Degrease and abrade with P280
Plastics	Direct adhesion to ABS, Noryl & PU Foam (Rigid), for HIPS, Acrylic, Polycarbonate, PVC and PU Foam (flexible) consult your local Cromadex centre. Clean with a suitable anti-static cleaner prior to coating

Application Details

Mixing Ratio	5 parts 630 Topcoat 1 part 600/630 Curing Agent Thinner not normally required	
Spraying Viscosity	As mixed	
Pot Life	2-4 hours @ 20°C (dependent on colour)	
Approved Thickness	60 – 100 microns DFT	100 – 165 microns WFT
Spray Gun	Fluid tip size	Working pressure
<i>Gravity Feed Conventional</i>	1.8 – 2.2 mm	3.1 – 4.2 bar
<i>Pressure Feed Conventional</i>	1.8 – 2.2 mm	3.1 – 4.2 bar
<i>Airless</i>	11 – 18 thou	
<i>Other Methods</i>	Not recommended	

Cromadex 630 Topcoat

Drying and Overcoating	Substrate Temperature	Drying Times		Overcoating Times	
		Touch Dry	Through Dry	Minimum	Maximum
	20°C	2 hours	4 hours	Not recommended	
	35°C	90 mins	3 hours	Not recommended	
Note: Wet edge can be extended with use of No 6 Thinner					
	Force Drying	Flash-off for 10-15 mins, then 60-80°C for 30 mins Note: force drying may result in change of gloss level			
	Full Properties	7 days			
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	59 % mixed, dependent on colour			
	Colour	Extended colour range all lead chromate free. Due to the nature of the product, it is not suitable in white or pastel shade.			
	Gloss	Visual appearance will be affected by the spatter effect achieved			
	Coverage	10 m ² /l @ 60 microns, assuming 100% transfer efficiency			
			VOC		Specific Gravity
	630 Topcoat	380 g/l (dependent on colour)		1.64 (dependent on colour)	
	600/630 Curing Agent	314 g/l		1.05	
	25-03 Thinner	873 g/l		0.87	
	No 6 Thinner	870 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>				