

Product Data Sheet

Cromadex Liquid Coatings Cromadex 635 Topcoat Two Pack Polyurethane Leatherette Topcoat

Product Description

Cromadex 635 is a two pack polyurethane leatherette topcoat with excellent exterior durability and chemical resistance. The product exhibits excellent colour retention adding value to the finished article, whilst the leatherette effect can help differentiate your finish.

The addition of Rapidcure can speed up the drying time helping improve productivity in your factory.

Cromadex 635 is available in the full Cromadex 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

635 Topcoat	600/635 Curing Agent
Rapidcure	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
GRP	Remove release coat, degrease and abrade with P280
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 635 Topcoat 1 part 600/635 Curing Agent Note: Once mixed, topcoat is ready for use. If necessary a small quantity of thinners may be added to assist application
Spraying Viscosity	As mixed
Pot Life	4 hours @ 20°C (dependent on colour)
Approved Thickness	60 – 100 microns DFT 120 – 190 microns WFT

Cromadex 635 Topcoat

Application Details	Spray Gun <i>Gravity Feed HVLP</i> <i>Pressure Pot HVLP</i>	Fluid tip size 1.4 – 1.8 mm 1.0 – 1.4 mm	Working pressure 0.7 bar (max) 0.7 bar (max)
	For best results it is recommended that a light coat followed by a full wet-coat be applied with a short flash-off period of 5-10 mins between coats.		
Drying and Overcoating	Substrate Temperature	Drying Times Touch Dry Through Dry	Overcoating Times Minimum Maximum
	20°C 35°C	45 mins 30 mins	8 hours 6 hours Not suitable for overcoating
	Note: For information on 600 Rapidcure please consult the data sheet		
	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 @ 20°C	
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	51 % mixed, dependent on colour	
	Colour	Full range available including BS, RAL and special matches – all lead chromate free	
	Gloss	Full gloss, other gloss levels available on request	
	Coverage	8.5 m ² /l @ 60 microns, assuming 100% transfer efficiency	
		VOC	Specific Gravity
	635 Topcoat	467 g/l (dependent on colour)	1.16 (dependent on colour)
	600/635 Curing Agent	314 g/l	1.05
	25-03 Thinner	873 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.		