

Product Data Sheet

Cromadex Liquid Coatings Cromadex 740 Topcoat Two Pack Epoxy Fine Texture Topcoat

Product Description

Cromadex 740 is a two pack epoxy fine texture topcoat with excellent chemical resistance suitable for interior use only. The product offers a fine texture appearance for an aesthetic finish.

The product can be air dried or stoved enabling flexibility in production.

Cromadex 740 is available in the full Cromadex range of colours and gloss levels, including BS, RAL and special matches all in a lead free finish.

In common with all epoxies, Cromadex 740 will chalk and discolour on exterior exposure. However, this will have no adverse effect on anti-corrosion properties.

Extra Life

Life expectancy of up to 12 years in a C3* internal environment when used with a suitable Cromadex primer. See Extra Life brochure for full details.

* as determined in ISO12944

Products and Ancillaries

740 Topcoat
700/740 Curing Agent
No 1 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

Application Details

Mixing Ratio	5 parts 740 Topcoat 2 parts 700/740 Curing Agent 1-2 parts No 1 Thinner
	Dependent on application equipment Note: products should be mixed 10 minutes prior to application
Spraying Viscosity	45 – 70 seconds ISO Cup4 @ 20°C 25 – 30 seconds BS Cup4 @ 20°C
Pot Life	8 hours @ 20°C (dependent on colour)
Approved Thickness	30 – 35 microns DFT 60 – 70 microns WFT

Cromadex 740 Topcoat

Application Details	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>	1.4 – 1.8 mm	0.7 bar (max)		
	<i>Pressure Pot HVLP</i>	1.0 – 1.4 mm	0.7 bar (max)		
	<i>Airless</i>	9 – 13 thou	1,500 – 2,000 psi		
	<i>Air Assisted Airless</i>	11-13 thou			
	<i>Other Methods</i>	Not Suitable			
Drying and Overcoating	Substrate Temperature	Drying Times		Overcoating Times	
		Touch Dry	Through Dry	Minimum	Maximum
	20°C	1 hour	12 hours	Not recommended	
	35°C	45 mins	9 hours		
	Force Drying	Flash-off for 10-15 mins, then 60-80°C for 30 mins			
Stoving	Flash-off for 10-15 mins, then 120°C for 30 mins Note: This product may yellow if stoved in a gas fired oven				
Full Properties	14 days if air dried @ 20°C or immediately after stoving				
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	50 % mixed, dependent on colour			
	Colour	Full range available including BS, RAL and special matches – all lead chromate free			
	Gloss	Visual appearance will be affected by the fine texture additive			
	Coverage	16.6 m ² /l @ 30 microns, assuming 100% transfer efficiency			
		VOC	Specific Gravity		
	<i>740 Topcoat</i>	458 g/l (dependent on colour)	1.14 (dependent on colour)		
	<i>700/740 Curing Agent</i>	449 g/l	0.92		
	<i>No 1 Thinner</i>	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.				