

Product Data Sheet

Cromadex Liquid Coatings

Cromadex 840 Topcoat

Two Pack Non-Isocyanate Acrylic Fine Texture Topcoat

Product Description

Cromadex 840 is a two pack non-isocyanate acrylic fine texture topcoat with excellent exterior durability and chemical resistance. The product uses unique resin and pigment technology enable a wide variety of applications and a durable finish, whilst the fine texture appearance offers an aesthetic finish.

The product is formulated without isocyanate helping to reduce health and safety concerns.

Cromadex 840 is available in the full Cromadex range of colours and gloss levels, including BS, RAL and special matches all in a lead free finish.

Extra Life

Life expectancy of up to 9 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

840 Topcoat	No 6 Thinner	No 3 Thinner
800/840 Curing Agent	25-03 Thinner	

Suitable Substrates and Preparation

Mild Steel	Degrease with 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), HIPS, Acrylic, uPVC, Polycarbonate, PVC and PU Foam (flexible). Clean with a suitable anti-static cleaner prior to coating.

Application Details

Mixing Ratio	5 parts 840 Topcoat 1 part 800/840 Curing Agent 1-2 parts 25-03/No6/No3 Thinner (dependent on application equipment)	
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	25 – 35 microns DFT	70 – 80 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>	1.4 – 1.8 mm	0.7 bar (max)
<i>Pressure Pot HVLP</i>	1.0 – 1.4 mm	0.7 bar (max)
<i>Other Methods</i>	Not suitable	

Cromadex 840 Topcoat

Drying and Overcoating	Substrate Temperature	Drying Times		Overcoating Times	
		Touch Dry	Through Dry	Minimum	Maximum
	20°C	15 mins	4 hours	Not recommended	
	35°C	10 mins	3 hours		
Note: Wet edge can be extended with use on No 6 or No 3 Thinners					
	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			
	Full Properties	7 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	46 % 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	15.4 m ² /l @ 30 microns, assuming 100% transfer efficiency			
		VOC			Specific Gravity
	840 Topcoat	470 g/l	(dependent on colour)	1.13	(dependent on colour)
	800/840 Curing Agent	491 g/l		1.00	
	25-03 Thinner	873 g/l		0.87	
	No 6 Thinner	870 g/l		0.87	
	No 3 Thinner	930 g/l		0.93	
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>				