

# Product Data Sheet

## Cromadex Liquid Coatings Cromadex 850 Primer Two Pack Non-Isocyanate Acrylic Primer

### Product Description

Cromadex 850 is a two pack non-isocyanate acrylic primer for use over a wide range of substrates. It contains zinc phosphate giving added corrosion resistance for greater durability.

The product is formulated without isocyanate helping to reduce health and safety concerns. Cromadex 850 can be applied wet-on-wet giving improved productivity.

Cromadex 850 is available in white as standard, it can also be tinted to ensure complete coverage even on difficult lead free colours.

### Extra Life

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

\* as determined in ISO12944

### Products and Ancillaries

850 Primer	25-03 Thinner
850 Curing Agent	No 6 Thinner

### Suitable Substrates and Preparation

Degreasing with Cromadex 678 Spirit Wipe is recommended and should be carried out after any abrasion of the surface

<b>Steel</b>	Degrease and abrade with P180. If necessary blast clean to remove millscale, minimum surface preparation SA2
<b>Aluminium &amp; Galvanised Steel</b>	Degrease and abrade with P240 to remove surface oxide layer. For even greater system performance apply Cromadex 903 Chromate-Free Etch Primer
<b>Stainless Steel</b>	Degrease and abrade with P180
<b>GRP</b>	Remove release coat, degrease and abrade with P280
<b>Plastics</b>	Direct adhesion to ABS, Noryl & PU Foam (Rigid), HIPS, Acrylic, Polycarbonate, PVC and PU Foam (flexible). Clean with a suitable anti-static cleaner prior to coating
<b>MDF</b>	May be applied directly to medium density fibreboard. Exterior grades may require abrasion and degreasing to remove the surface wax coating

### Application Details

<b>Mixing Ratio</b>	5 parts 850 Primer 1 part 850 Curing Agent 1-2 parts 25-03 Thinner (dependent on application equipment)
<b>Spraying Viscosity</b>	45 – 70 seconds ISO Cup4 @ 20°C
<b>Pot Life</b>	When mixed 8 hours @ 20°C
<b>Approved Thickness</b>	30 – 40 microns DFT 85 – 110 microns WFT

## Cromadex 850 Primer

<b>Application Details</b>	<b>Spray Gun</b>	<b>Fluid tip size</b>	<b>Working pressure</b>		
	<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>	11 – 18 thou			
	<i>Air Assisted Airless</i>	11 – 15 thou			
	<i>Electrostatic</i>	Ready for use			
<b>Drying and Overcoating</b>	<b>Substrate Temperature</b>	<b>Drying Times</b>		<b>Overcoating Times</b>	
		<b>Touch Dry</b>	<b>Through Dry</b>	<b>Minimum</b>	<b>Maximum</b>
	20°C	15 mins	3 hours	wet-on-wet	Indefinite
	35°C	10 mins	2 hours	wet-on-wet	Indefinite
	Note: If primer is not overcoated within 14 days then abrade with either P240 or P320 and clean with Cromadex 678 Spirit Wipe Wet edge can be extended with use of No 6 Thinner				
	<b>Force Drying</b>	Flash-off for 10-15 mins, then 60-80°C for 30 mins			
	<b>Stoving</b>	Flash-off for 10-15 mins, then 120°C for 30 mins (only suitable if overcoated wet-on-wet with Cromadex 800 topcoat)			
	<b>Full Properties</b>	7 days if air dried @ 20°C, or immediately after stoving			
<b>Storage and Handling</b>	<b>Storage</b>	Storage should be in accordance with the instructions in Section 7 of the relevant material safety data sheet			
	<b>Shelf Life</b>	12 months in an unopened, original container from date of mixing at Cromadex centre			
	<b>Pack Size</b>	5 litres			
<b>Physical Properties</b>	<b>Volume Solids</b>	35 % mixed			
	<b>Colour</b>	White Tinted shades available – all lead chromate free			
	<b>Coverage</b>	12 m <sup>2</sup> /l @ 30 microns (mixed), assuming 100% transfer efficiency			
		<b>VOC</b>	<b>Specific Gravity</b>		
	<i>850 Primer</i>	570 g/l	1.28		
	<i>850 Curing Agent</i>	579 g/l	0.97		
	<i>25-03 Thinner</i>	870 g/l	0.87		
<i>No 6 Thinner</i>	870 g/l	0.87			
<b>Safety Precautions and Disclaimer</b>	<b>Before using this product please refer to the Cromadex Material Safety Data Sheet.</b>				
	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.				