

Product Data Sheet

Cromadex Liquid Coatings Cromadex 940 Topcoat Fine Texture Stoving Topcoat

Product Description

Cromadex 940 is a stoving topcoat that comes in a fine texture finish that adds value to your article. The choice of stoving schedules enables production flexibility.

The mar resistance of Cromadex 940 makes it suitable in tough environments.

Cromadex 940 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 6 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

940 Topcoat
05-46 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

Application Details

Thinning Ratio	5 parts 940 Topcoat 1 part 05-46 Thinner (dependent on application equipment)	
Spraying Viscosity	45 – 65 seconds ISO Cup4 @ 20°C 25 – 30 seconds BS 4 Cup @ 20°C	
Approved Thickness	25 – 35 microns DFT	75– 75 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 Feed HVLP</i>	1.0 – 1.4 mm	0.7 bar (max)
	Other methods not suitable	

Drying and Overcoating

Substrate Temperature	Drying Times		Overcoating Times	
	Touch Dry	Through Dry	Minimum	Maximum
	STOVING ONLY		Not recommended	
Stoving	Flash-off for 10 – 15 mins, then stove at 120°C for 30 minutes – minimum 140°C for 30 minutes – optimum 160°C for 30 minutes – maximum			
Full Properties	After stoving			

Cromadex 940 Topcoat

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	18 m ² /l @ 25 microns, assuming 100% transfer efficiency	
	VOC	Specific Gravity
940 Topcoat	472 g/l (dependent on colour)	1.14 (dependent on colour)
05-46 Thinner	867 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.
