

Product Data Sheet

Cromadex Liquid Coatings

Cromadex 943 Topcoat Acrylic Stoving Topcoat

Product Description

Cromadex 943 is a stoving topcoat with direct metal adhesion, helping to reduce application costs.

It has good exterior durability making it suitable for many applications.

Cromadex 943 is available in the full Cromadex range of colours and gloss levels, including BS, RAL, metallics, sparkles 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

943 Topcoat	No 3 Thinner
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 943 Topcoat 1 part Thinner (dependent on application equipment)	
Spraying Viscosity	45 – 55 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)
Electrostatic	Resistivity will require adjustment. Please inform your local Cromadex Centre at time of purchase	
Disc or Bell	Resistivity will require adjustment. Please inform your local Cromadex Centre at time of purchase	
Heated Methods	Reduce thinning ratios as required	

Cromadex 943 Topcoat

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			
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, metallics, sparkles and special matches – all lead chromate free			
	Gloss	Full gloss (90% min) Eggshell (30%)		Semi gloss (60%) Matt (10%)	
	Coverage	Measured at 30-35 microns DFT & 60° reflectance A variance of +/-5% may be obtained dependent on application process			
		19 m ² /l @ 25 microns, assuming 100% transfer efficiency			
		VOC	Specific Gravity		
	943 Topcoat	475 g/l (dependent on colour gloss)	1.12 (dependent on colour & gloss)		
	05-46 Thinner	867 g/l	0.87		
	No 3 Thinner	930 g/l	0.93		
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.				