

Product Data Sheet

Cromadex Liquid Coatings

Cromadex V60 Topcoat Two Pack Rail Topcoat

Product Description

Cromadex V60 is a two pack polyurethane topcoat formulated for refurbishment programmes in the rail industry. When used as a system with Cromadex V39 Rail Primer (Refurbishment) it meets the following specifications:

BS 6853 1999 Annex B
BS 476 Part 6 : 1989 Class 0
BS 476 Part 7 : 1997 Class 1

Products and Ancillaries

V60 Topcoat	25-03 Thinner
V60 Curing Agent	No 6 Thinner

Suitable Substrates and Preparation

Mild Steel	Degrease and abrade steel with P180. If necessary blast clean to remove millscale, minimum surface preparation SA2. Apply Cromadex V39 primer
Sound existing paint work	Dry sand using P320-P240. Apply Cromadex V39 primer

Application Details

Mixing Ratio	5 parts V60 Topcoat 1 part V60 Curing Agent 1-2 parts 25-03 Thinner (dependent on application equipment)	
Spraying Viscosity	45 – 70 seconds ISO Cup4 @ 20°C	
Pot Life	4 hours @ 20°C (dependent on colour)	
Approved Thickness	25 – 35 microns DFT	50 – 70 microns WFT

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>	11 – 18 thou	
<i>Electrostatic</i>	Resistivity will require adjustment. Please inform your local Cromadex centre at time of purchase	

Drying and Overcoating

Substrate Temperature	Drying Times		Overcoating Times	
	Touch Dry	Through Dry	Minimum	Maximum
20°C	45 mins	8 hours	n/a	Indefinite
35°C	30 mins	6 hours	n/a	Indefinite

Note: If topcoat 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

Force Drying Flash-off for 10-15 mins, then 60-80°C for 30 mins
Note: force drying may result in change of gloss level

Full Properties 7 days @ 20°C
Note: when fully cured, topcoat will need abrading with P280 prior to subsequent overcoating

Cromadex V60 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	51 % mixed, dependent on colour and gloss	
Colour	Full range available including BS, RAL, metallics, sparkles and special matches – all lead chromate free	
Gloss	Full gloss (90% min) Eggshell (30%) Plus intermediates on request	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 17 m ² /l @ 30 microns, assuming 100% transfer efficiency	
	VOC	Specific Gravity
V60 Topcoat	464 g/l (dependent on colour & gloss)	1.16 (dependent on colour & gloss)
V60 Curing Agent	314 g/l	1.05
25-03 Thinner	873 g/l	0.87
No 6 Thinner	870 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.