

Product Data Sheet

Cromadex Liquid Coatings

Cromadex 903 Primer

Two Pack Chromate-Free Etch Primer

Product Description

Cromadex 903 is a two pack chromate-free etch primer designed for use over a wide range of substrates. It is formulated without the use of zinc tetroxy-chromate helping to reduce health and safety concerns

The product can be overcoated with both wet paint and powder coatings helping to reduce stockholding

Cromadex 903 should be used to improve adhesion and corrosion resistance of all systems used over metal substrates. The product is available in buff.

Extra Life

Life expectancy of up to 15 years in a C3* external environment when used with a suitable Cromadex wet paint or Interpon powder system. See Extra Life brochure for full details.

* as determined in ISO12944

Products and Ancillaries

903 Primer
903 Acid Reducer
No 1 Thinner

Suitable Substrates and Preparation

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

Steel	Degrease and abrade with P180. If necessary blast clean to remove millscale, minimum surface preparation SA2
Aluminium, Galvanised Steel & Stainless Steel	Thoroughly abrade or peen blast to remove surface oxide layer, degrease and apply the primer within 6 hours to prevent reoxidation. We advise that an adhesion test should be carried out prior to full production

Application Details

Mixing Ratio	1 part 903 Primer 1 part 903 Acid Reducer	
Spraying Viscosity	30 – 40 seconds ISO Cup4 @ 20°C	
Pot Life	6 hours @ 20°C	
Approved Thickness	15 – 20 microns DFT	
Spray Gun	Fluid tip size	Working pressure
<i>Conventional</i>	1.0 – 1.8 mm	3.5 – 4.2 bar
<i>Suction Feed HVLP</i>	1.0 – 1.8 mm	0.7 bar (max)
<i>Pressure Pot HVLP</i>	1.0 – 1.8 mm	0.7 bar (max)
<i>Other Methods</i>	Not suitable due to excessive film build	

Drying and Overcoating

Substrate Temperature	Drying Times		Overcoating Times	
	Touch Dry	Through Dry	Minimum	Maximum
20°C	10 mins	2 hours	15 mins	10 hours
35°C	5 mins	1 hour	10 mins	10 hours

Note: This primer must be overcoated within the recommended interval. If this interval is exceeded than adhesion failure may occur.

903 Primer is overcoatable with all Cromadex General Industrial Primers and Topcoat except 902. Can also be overcoated with Interpon® Powder Coatings. Please contact your local Cromadex centre for advice.

Cromadex 903 Primer

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 litres

Physical Properties

Volume Solids	15 % mixed	
Colour	Buff (nr BS630)	
Coverage	10 m ² /l @ 15 microns (mixed), assuming 100% transfer efficiency	
	VOC	Specific Gravity
903 Primer	595 g/l	1.19
903 Acid Reducer	806 g/l	0.83
No 1 Thinner	868 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.
