

# Product Data Sheet

## Cromadex Liquid Coatings Cromadex 891 Topcoat High Solids Two Pack Acrylic Topcoat

### Product Description

Cromadex 891 is a high solids two pack acrylic topcoat with excellent exterior durability. The product has excellent UV resistance giving it prolonged decorative performance.

The product is high in solids enabling it to be used as part of a VOC reduction programme.

Cromadex 891 is available in the full Cromadex range of colours and gloss levels, including BS, RAL, metallic, sparkles and special matches all in a lead free finish.

### Extra Life

Life expectancy of up to 15 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

891 Topcoat  
891 Curing Agent  
891 Thinner or 891 Rapid Thinner

### Suitable Substrates and Preparation

<b>Mild Steel</b>	Degrease and abrade with P180. If necessary blast clean to remove millscale, minimum surface preparation SA2. Apply suitable Cromadex primer
<b>Aluminium &amp; Galvanised Steel</b>	Degrease and abrade with P240 to remove surface oxide layer. Apply Cromadex 903 Chromate-Free Etch Primer
<b>Stainless Steel</b>	Use of Cromadex 903, AQ58, 750 or 850 primer is required

### Application Details

<b>Mixing Ratio</b>	5 parts 891 Topcoat 2 parts 891 Curing Agent 1 or 2 parts 891 or 891 Rapid Thinner (dependent on application equipment) <b>Note:</b> 891 clear laquer mixing ratio is 2:1:1 (base:curing agent:rapid thinner)	
<b>Spraying Viscosity</b>	30 – 70 seconds ISO Cup4 @ 20°C 25 – 40 seconds BS Cup4 @ 20°C	
<b>Pot Life</b>	1-2 hours @ 20°C (dependent on thinner)	
<b>Approved Thickness</b>	35 – 60 microns DFT	60 – 90 microns WFT

### Application Details

Spray Gun	Fluid tip size	Working pressure
<b>Conventional</b>	1.6 – 1.8 mm	50 – 60 psi
<b>Suction Feed HVLP</b>	1.6 mm	10 psi (max)
<b>Pressure Pot HVLP</b>	1.0 – 1.4 mm	10 psi (max)
<b>Airless</b>	9 – 13 thou	2000 – 3000 psi
<b>Electrostatic</b>	Resistivity will require adjustment. Please inform your local Cromadex centre at time of purchase	

## Cromadex 891 Topcoat

Drying and Overcoating	Substrate Temperature	Drying Times		Overcoating Times	
		Touch Dry	Through Dry	Minimum	Maximum
	20°C with 891 Thinner	40 mins	16 hours	1 hour	Flat after 16 hours, overcoat after 24 hours
	20°C with 891 Rapid Thinner	20 mins	8 hours	1 hour	Flat after 16 hours, overcoat after 24 hours
	<b>Force Drying</b>	Flash-off for 10-20 mins, then 60°C for 45 mins			
	<b>Full Properties</b>	7 days			
Storage and Handling	<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 & 20 litres			
Physical Properties	<b>Volume Solids</b>	64 % mixed, dependent on colour			
	<b>Colour</b>	Full range available including BS, RAL, metallics, sparkles and special matches – all lead chromate free			
	<b>Gloss</b>	Full gloss (90% min) Measured at 30-35 microns DFT & 60° reflectance			
	<b>Coverage</b>	16.8 m <sup>2</sup> /l @ 40 microns, assuming 100% transfer efficiency			
			<b>VOC</b>		<b>Specific Gravity</b>
	<b>891 Topcoat</b>	284 g/l (dependent on colour)		1.10 (dependent on colour)	
	<b>891 Curing Agent</b>	360 g/l		1.04	
	<b>891 Thinner</b>	861 g/l		0.88	
	<b>891 Rapid Thinner</b>	880 g/l		0.88	
Safety Precautions and Disclaimer	<p><b>Before using this product please refer to the Cromadex Material Safety Data Sheet.</b></p> <p>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.</p> <p>It is the user's responsibility to check that this data sheet is current prior to using the product.</p>				