

Product Data Sheet

Cromadex Liquid Coatings

Cromadex 213 Plus Primer Quick Drying Primer

Product Description

Cromadex 213 Plus is a one pack primer containing zinc phosphate giving added corrosion resistance for greater durability. It is quick drying helping to improve productivity.

The product is high build helping to cover the surface profile.

Cromadex 213 Plus is available in white, grey, red oxide, buff and yellow as standard.

Products and Ancillaries

213 Plus Primer
05-46 Thinner
85-72 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 Degrease and abrade with P240 to remove surface oxide layer. Apply Cromadex 903 Chromate-Free Etch Primer

Application Details

Thinning Ratio 5 parts 213 Plus Primer
1 part 05-46 Thinner (dependent on application equipment)

Spraying Viscosity 25 – 30 seconds ISO Cup4 @ 20°C

Approved Thickness 40 – 80 microns DFT 95 – 190 microns WFT

Application Details

Spray Gun	Fluid tip size	Working pressure
<i>Conventional</i>	1.6 – 1.8 mm	3.5 – 4.2 bar
<i>Suction Feed HVLP</i>	2.3 mm	0.7 bar (max)
<i>Pressure Pot HVLP</i>	1.4 mm	0.7 bar (max)
<i>Airless</i>	11 – 15 thou	2500 psi (170 bar)
<i>Air Assisted Airless</i>	13 thou	1500 – 2000 psi (100-170 bar) fluid pressure 10 – 20 psi (0.7-1.4 bar) air assist

Drying and Overcoating

Substrate Temperature	Drying Times		Overcoating Times	
	Touch Dry	Through Dry	Minimum	Maximum
20°C	15 mins	6 hours	25 mins	Unlimited
35°C	10 mins	5 hours	15 mins	Unlimited

Force Drying Flash-off for 10-15 mins, then 80°C for 30 mins

Full Properties 7 days

213 Plus Primer is overcoatable after the minimum drying time (above) with all Cromadex 222, 233 & 400 Topcoats ONLY.

Cromadex 213 Plus 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	6 & 25 kgs

Physical Properties

Volume Solids	45-47 % (dependent on colour)	
Colour	White (nr RAL 9016), light grey (nr RAL 7035), dark grey (nr RAL 7037), red oxide, buff (nr RAL 1001) & yellow	
Coverage	13 m ² /l @ 35 microns (dependent on colour), assuming 100% transfer efficiency	
	VOC	Specific Gravity
213 Plus Primer	458-464 g/l (dependent on colour)	1.45-1.49 (dependent on colour)
05-46 Thinner	867 g/l	0.87
85-72 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.