

Product Data Sheet

Cromadex Liquid Coatings

Cromadex 640 Topcoat

Two Pack Polyurethane Fine Texture Topcoat

Product Description

Cromadex 640 is a two pack polyurethane fine texture topcoat with excellent exterior durability and chemical resistance. The product offers a fine texture appearance for an aesthetic finish.

Cromadex 640 demonstrates good mar resistance, ideal if the end product is to be widely handled.

The addition of Rapidcure can speed up the drying time helping improve productivity in your factory.

Cromadex 640 is available in the full Cromadex range of colours, including BS, RAL, metallic 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

| | |
|----------------------|---------------|
| 640 Topcoat | No 6 Thinner |
| 600/640 Curing Agent | 25-03 Thinner |
| Rapidcure | |

Suitable Substrates and Preparation

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|---|--|
| 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 |
| Stainless Steel | Use of Cromadex 903, AQ58, 750 or 850 primer is required |
| Powder Coating | Degrease and abrade with P280 |
| Plastics | Direct adhesion to ABS, Noryl & PU Foam (Rigid), for HIPS, Acrylic, Polycarbonate, PVC and PU Foam (flexible) consult your local Cromadex centre. Clean with a suitable anti-static cleaner prior to coating |

Application Details

| | | |
|---------------------------|---|-------------------------|
| Mixing Ratio | 5 parts 640 Topcoat 1 part 600/640 Curing Agent 1-2 parts 25-03/No 6 Thinner (dependent on application equipment) | |
| Spraying Viscosity | 45 – 70 seconds ISO Cup4 @ 20°C 25 – 30 seconds BS Cup4 @ 20°C | |
| Pot Life | 4 hours @ 20°C (dependent on colour) | |
| Approved Thickness | 25 – 35 microns DFT | 50 – 70 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 Pot HVLP</i> | 1.0 – 1.4 mm | 0.7 bar (max) |
| <i>Other Methods</i> | Not suitable | |

Cromadex 640 Topcoat

| Drying and Overcoating | Substrate Temperature | Drying Times | | Overcoating Times | |
|---|---|---|-------------|----------------------------|---------|
| | | Touch Dry | Through Dry | Minimum | Maximum |
| | 20°C | 45 mins | 8 hours | Not recommended | |
| | 35°C | 30 mins | 6 hours | Not recommended | |
| Note: 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 | | | |
| | Full Properties | 7 days @ 20°C | | | |
| 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 | 50 % mixed, dependent on colour | | | |
| | Colour | Full range available including BS, RAL and special matches – all lead chromate free | | | |
| | Gloss | Visual appearance will be affected by the fine texture additive | | | |
| | Coverage | 18.7 m ² /l @ 25 microns, assuming 100% transfer efficiency | | | |
| | | VOC | | Specific Gravity | |
| | 640 Topcoat | 484 g/l (dependent on colour) | | 1.17 (dependent on colour) | |
| | 600/640 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. | | | | |
| | <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> | | | | |