

# Product Data Sheet

## Cromadex Liquid Coatings

### Cromadex 700 Topcoat Two Pack Epoxy Topcoat

#### Product Description

Cromadex 700 is a two pack epoxy topcoat with excellent chemical resistance. The product offers a high level of full gloss enhancing the value of the finished article.

The product can be air dried or stoved enabling flexibility in production.

Cromadex 700 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.

In common with all epoxies, Cromadex 700 will chalk and discolour on exterior exposure. However, this will have no adverse effect on anti-corrosion properties.

#### Extra Life

Life expectancy of up to 12 years in a C3\* internal environment when used with a suitable Cromadex primer. See Extra Life brochure for full details.

\* as determined in ISO12944

#### Products and Ancillaries

700 Topcoat  
700 Curing Agent  
No 1 Thinner

#### Suitable Substrates and Preparation

<b>Sheet Steel</b>	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
<b>Aluminium &amp; Galvanised Steel</b>	Apply Cromadex 903 Chromate-Free Etch Primer (then other Cromadex primer is required to increase film build)
<b>Stainless Steel</b>	Use of Cromadex 903, AQ58, 750 or 850 primer is required
<b>GRP</b>	Remove release coat, degrease and abrade with P280
<b>Powder Coating</b>	Degrease and abrade with P280

#### Application Details

<b>Mixing Ratio</b>	<table border="0"> <tr> <td style="text-align: center;">Full Gloss</td> <td style="text-align: center;">Semi Gloss/Eggshell/Matt</td> </tr> <tr> <td style="text-align: center;">2 parts 700 Topcoat</td> <td style="text-align: center;">5 parts 700 Topcoat</td> </tr> <tr> <td style="text-align: center;">1 part 700 Curing Agent</td> <td style="text-align: center;">2 parts 700 Curing Agent</td> </tr> <tr> <td style="text-align: center;">1-2 parts No 1 Thinner</td> <td style="text-align: center;">1-2 parts No 1 Thinner</td> </tr> </table>	Full Gloss	Semi Gloss/Eggshell/Matt	2 parts 700 Topcoat	5 parts 700 Topcoat	1 part 700 Curing Agent	2 parts 700 Curing Agent	1-2 parts No 1 Thinner	1-2 parts No 1 Thinner
Full Gloss	Semi Gloss/Eggshell/Matt								
2 parts 700 Topcoat	5 parts 700 Topcoat								
1 part 700 Curing Agent	2 parts 700 Curing Agent								
1-2 parts No 1 Thinner	1-2 parts No 1 Thinner								
	Dependent on application equipment <b>Note:</b> products should be mixed 10 minutes prior to application								
<b>Spraying Viscosity</b>	45 – 70 seconds ISO Cup4 @ 20°C 25 – 30 seconds BS Cup4 @ 20°C								
<b>Pot Life</b>	8 hours @ 20°C (dependent on colour)								
<b>Approved Thickness</b>	30 – 35 microns DFT <span style="float: right;">55 – 65 microns WFT</span>								

## Cromadex 700 Topcoat

<b>Application Details</b>	<b>Spray Gun</b>	<b>Fluid tip size</b>	<b>Working pressure</b>		
	<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>	Ready for use			
<b>Drying and Overcoating</b>	<b>Substrate Temperature</b>	<b>Drying Times</b>		<b>Overcoating Times</b>	
		<b>Touch Dry</b>	<b>Through Dry</b>	<b>Minimum</b>	<b>Maximum</b>
	20°C	1 hour	12 hours	2 hours	Indefinite
	35°C	45 mins	9 hours	1 hour	Indefinite
	<b>Force Drying</b>	Flash-off for 10-15 mins, then 60-80°C for 30 mins			
	<b>Stoving</b>	Flash-off for 10-15 mins, then 120°C for 30 mins Note: This product may yellow if stoved in a gas fired oven			
	<b>Full Properties</b>	14 days if air dried @ 20°C or immediately after stoving <b>Note:</b> when fully cured, topcoat will need abrading with P280 prior to subsequent overcoating			
<b>Storage and Handling</b>	<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			
<b>Physical Properties</b>	<b>Volume Solids</b>	54 % mixed, dependent on colour and gloss			
	<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)		Semi gloss (60%)	
		Eggshell (30%)		Matt (10%)	
		Plus intermediates on request			
	<b>Coverage</b>	Measured at 30-35 microns DFT & 60° reflectance A variance of +/-5% may be obtained dependent on application process			
		16 m <sup>2</sup> /l @ 30 microns, assuming 100% transfer efficiency			
		<b>VOC</b>	<b>Specific Gravity</b>		
	<b>700 Topcoat</b>	386 g/l (dependent on colour & gloss)	1.23 (dependent on colour & gloss)		
	<b>700 Curing Agent</b>	449 g/l	0.92		
	<b>No 1 Thinner</b>	868 g/l	0.87		
<b>Safety Precautions and Disclaimer</b>	<b>Before using this product please refer to the Cromadex Material Safety Data Sheet.</b>				
	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.				