

Product Data Sheet

Cromadex Liquid Coatings Cromadex 258 Topcoat Air Drying Hammer Topcoat

Product Description

Cromadex 258 is an air drying hammer topcoat that gives a substrate-hiding, special effect finish.
Cromadex 258 is available in a wide range of colours all in a lead free finish.

Products and Ancillaries

258 Topcoat
No 1 Thinner

Suitable Substrates and Preparation

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 (then other Cromadex primer is required to increase film build)
Stainless Steel	Use of Cromadex 903, AQ58, 750 or 850 primer is required

Application Details

Thinning Ratio	Up to 10% by volume with Cromadex No 1 Thinner when sprayed Ready for use when applied by brush or roller	
Spraying Viscosity	55 – 65 seconds ISO Cup6 @ 25°C	
Approved Thickness	90 – 110 microns DFT	180 – 220 microns WFT
Spray Gun	Fluid tip size	Working pressure
<i>Conventional</i>	1.4 – 1.8 mm	3.5 – 4.2 bar
<i>HVLP Gravity</i>	1.8 – 2.0 mm	2.0 bar (approx)
<i>Airless</i>	375 – 500 microns	170 bar (approx)
<i>Brush and Roller</i>	Suitable	

Drying and Overcoating

Substrate Temperature	Drying Times		Overcoating Times	
	Touch Dry	Through Dry	Minimum	Maximum
20°C	90 mins	24 hours	After 4 hours	
Force Drying	Flash-off for 15-20 mins, then 80°C for 30 mins			
Stoving	Flash-off for 15-20 mins, then stove at 100°C for 30 mins			
Full Properties	7 days			

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

Cromadex 258 Topcoat

Physical Properties

Volume Solids	50 % mixed, dependent on colour	
Colour	Full range available including special matches – all lead chromate free	
Gloss	Semi gloss appearance Visual appearance will be affected due to the nature of the product	
Coverage	5 m ² /l @ 100 microns, assuming 100% transfer efficiency	
	VOC	Specific Gravity
258 Topcoat	500 g/l (dependent on colour)	1.00 (dependent on colour)
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.
