

Product Data Sheet

Cromadex Liquid Coatings

Cromadex 902 Primer One Pack Etch Primer

Product Description

Cromadex 902 is a one pack etch primer that can be both air dried and stoved making it suitable for use in most paint shops.

The product has enhanced adhesion properties to mild steel ensuring the success of the coating system.

Cromadex 902 is available in white, grey and black.

Products and Ancillaries

902 Primer
No 1 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

Application Details

Thinning Ratio 5 parts 902 Primer
1 part No 1 Thinner
(dependent on application equipment)

Spraying Viscosity 30 – 40 seconds ISO Cup4 @ 20°C

Approved Thickness 15 – 20 microns DFT 75 – 100 microns WFT

Application Details

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>Airless</i>	9 – 15 thou	2500 psi (170 bar)
<i>Air Assisted Airless</i>	11 – 15 thou	1500 – 2000 psi (100-170 bar) fluid pressure 10 – 20 psi (0.7-1.4 bar) air assist
<i>Brush or Roller</i>	Suitable for small areas only. Ready for use	
<i>Heated Methods</i>	Reduce thinning ratios as required	

Drying and Overcoating

Substrate Temperature	Drying Times		Overcoating Times	
	Touch Dry	Through Dry	Minimum	Maximum
20°C	20 mins	4 hours	30 mins	16 hours
35°C	15 mins	3 hours	20 mins	16 hours

Note: If primer is not overcoated within 14 days then abrade with either P240 or P320 and clean with Cromadex 678 Spirit Wipe

Force Drying/Stoving Flash-off for 10-15 mins, then 60-80°C for 30 mins

Full Properties 7 days

902 Primer is overcoatable after the minimum drying time (above) with all Cromadex General Industrial Topcoats except 700, 740 & 742.

Cromadex 902 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	5 & 20 litres

Physical Properties

Volume Solids	18.0 % (dependent on colour)	
Colour	White, grey and black	
Coverage	10-13 m ² /l @ 15 microns, assuming 100% transfer efficiency (dependent on colour)	
VOC		Specific Gravity
902 Primer	710-750 g/l (dependent on colour)	1.21 (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.
