

Product Data Sheet

Cromadex Liquid Coatings Cromadex 600 Topcoat Two Pack Polyurethane Topcoat

Product Description

Cromadex 600 is a two pack polyurethane topcoat with excellent exterior durability and chemical resistance. The product exhibits excellent colour and gloss retention adding value to the finished article.

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

Cromadex 600 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.

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

600 Topcoat	No 6 Thinner
600 Curing Agent	Pot Life Extender
25-03 Thinner	Rapidcure

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
GRP	Remove release coat, degrease and abrade with P280
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 600 Topcoat 1 part 600 Curing Agent 1-2 parts 25-03 Thinner (dependent on application equipment) Note: 600 clear lacquer mixing ratio is 4:1 (base:curing agent)
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) For extended life, add 150 mls of Cromadex Pot Life Extender per 5 litres of base (prior to mixing with curing agent)
Approved Thickness	25 – 35 microns DFT 50 – 70 microns WFT

Cromadex 600 Topcoat

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 – 11 thou				
	<i>Electrostatic</i>	Resistivity will require adjustment. Please inform your local Cromadex centre at time of purchase				
Drying and Overcoating	Substrate Temperature	Drying Times		Overcoating Times		
		Touch Dry	Through Dry	Minimum	Maximum	
	20°C	45 mins	8 hours	n/a	Indefinite	
	35°C	30 mins	6 hours	n/a	Indefinite	
	Note: If topcoat is not overcoated within 14 days then abrade with either P240 or P320 and clean with Cromadex 678 Spirit Wipe Wet edge can be extended with use of No 6 Thinner For information on 600 Rapidcure and Pot Life Extender please consult the data sheet					
	Force Drying	Flash-off for 10-15 mins, then 60-80°C for 30 mins Note: force drying may result in change of gloss level				
Full Properties	7 days @ 20°C Note: when fully cured, topcoat will need abrading with P280 prior to subsequent overcoating					
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	51 % mixed, dependent on colour and gloss				
	Colour	Full range available including BS, RAL, metallics, sparkles and special matches – all lead chromate free				
	Gloss	Full gloss (90% min)		Semi gloss (60%)		
		Eggshell (30%)		Matt (10%)		
		Plus intermediates on request				
	Coverage	Measured at 30-35 microns DFT & 60° reflectance A variance of +/-5% may be obtained dependent on application process				
		17 m ² /l @ 30 microns, assuming 100% transfer efficiency				
		VOC	Specific Gravity			
	<i>600 Topcoat</i>	464 g/l (dependent on colour & gloss)	1.16 (dependent on colour & gloss)			
	<i>600 Curing Agent</i>	314 g/l	1.05			
	<i>25-03 Thinner</i>	873 g/l	0.87			
	<i>No 6 Thinner</i>	870 g/l	0.87			
	<i>Pot Life Extender</i>	876 g/l	0.97			
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.					