

# Product Data Sheet

## Cromadex Liquid Coatings

### Cromadex 230 Primer Stoving Primer Filler

#### Product Description

Cromadex 230 is a stoving primer filler giving improved durability.

The product can be overcoated wet-on-wet enabling rapid application.

Cromadex 230 is available in white as standard, it can also be tinted to ensure complete coverage even on difficult lead free colours.

#### Extra Life

Life expectancy of up to 7 years in a C3\* environment when used with a suitable Cromadex topcoat. See Extra Life brochure for full details.

\* as determined in ISO12944: 2018

#### Products and Ancillaries

230 Primer  
05-46 Thinner (Standard)  
85-72 Thinner (Slow)

#### Suitable Substrates and Preparation

Degreasing with Cromadex 678 Spirit Wipe is recommended and should be carried out after any abrasion of the surface

<b>Steel</b>	Degrease and abrade with P180. If necessary blast clean to remove millscale, minimum surface preparation SA2
<b>Aluminium &amp; Galvanised Steel</b>	Degrease and abrade with P240 to remove surface oxide layer. Apply Cromadex 903 Chromate-Free Etch Primer

#### Application Details

<b>Thinning Ratio</b>	5 parts 230 Primer 1 part Thinner (dependent on application equipment)	
<b>Spraying Viscosity</b>	45 – 70 seconds ISO Cup4 @ 20°C	
<b>Approved Thickness</b>	25 – 50 microns DFT	55 – 115 microns WFT

#### Application Details

<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>Air Assisted Airless</i>	11 – 13 thou	1500 – 2000 psi (100-170 bar) fluid pressure 10 – 30 psi (0.7-2.0 bar) air assist
<b>Disc/Bell</b>	Please inform your local Cromadex Centre at time of purchase	
<b>Heated Methods</b>	Reduce thinning ratios as required	

# Cromadex 230 Primer

## Drying and Overcoating

Substrate Temperature	Drying Times		Overcoating Times	
	Touch Dry	Through Dry	Minimum	Maximum
20°C		STOVING ONLY	wet-on-wet	N/A

Note: If primer is not overcoated wet-on-wet then abrade with P240 – P320 and clean with Cromadex 678 Spirit Wipe

**Stoving** Flash-off for 10-15 mins, then 120°C for 30 mins

**Full Properties** Achieved after recommended stoving schedule

**230 Primer** is overcoatable after the minimum drying time (above) with Cromadex 310 & 943 Topcoats.

## Storage and Handling

<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 litres

## Physical Properties

<b>Volume Solids</b>	44 %	
<b>Colour</b>	White Tinted pastel shades available – all lead chromate free	
<b>Coverage</b>	18 m <sup>2</sup> /l @ 25 microns, assuming 100% transfer efficiency	
	<b>VOC</b>	<b>Specific Gravity</b>
<b>230 Primer</b>	481 g/l	1.41
<b>05-46 Thinner</b>	867 g/l	0.87
<b>85-72 Thinner</b>	870 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.