

# Product Data Sheet

## Cromadex Liquid Coatings Cromadex 400 Topcoat One Pack Polyurethane Topcoat

### Product Description

Cromadex 400 is a one pack topcoat using polyurethane resin technology with enhanced UV resisting properties, it provides an automotive quality finish resistant to colour fade, gloss reduction and chalking.

The product has a long wet edge making it easier to apply to large items with no dry spray.

Cromadex 400 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 7 years in a C3\* environment when used with a suitable Cromadex primer. See Extra Life brochure for full details.

\* as determined in ISO12944: 2018

### Products and Ancillaries

400 Topcoat  
05-46 Thinner (Standard)  
05-44 Thinner (Slow)

### Suitable Substrates and Preparation

<b>Mild 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

### Application Details

<b>Thinning Ratio</b>	5 parts 400 Topcoat 1 part Thinner (dependent on application equipment)	
<b>Spraying Viscosity</b>	45 – 65 seconds ISO Cup4 @ 20°C 25 – 30 seconds BS 4 Cup @ 20°C	
<b>Approved Thickness</b>	25 – 35 microns DFT	55 – 75 microns WFT
<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 Feed HVLP</i>	1.0 – 1.4 mm	0.7 bar (max)
<i>Air Assisted Airless</i>	11 – 13 thou	Air Assist pressure 20-30 psi
<b>Electrostatic</b>	Resistivity will require adjustment. Please inform your local Cromadex centre at time of purchase.	
<b>Brush/Roller</b>	Suitable	
<b>Heated Methods</b>	Reduce thinning ratios as required	

# Cromadex 400 Topcoat

## Drying and Overcoating

Substrate Temperature	Drying Times		Overcoating Times	
	Touch Dry	Through Dry	Minimum	Maximum
20°C	3 hours	12 hours	1 hour	7 days
35°C	2 hours	10 hours	45 mins	7 days

Note: If topcoat is not overcoated within 7 days then abrade with P240 – P320 and clean with Cromadex 678 Spirit Wipe

<b>Force Drying</b>	Flash-off for 10-15 mins, then 60-80°C for 30 mins
<b>Full Properties</b>	7 days

## 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 & 20 litres

## Physical Properties

<b>Volume Solids</b>	45 % 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) Eggshell (30%) Plus intermediates on request	Semi gloss (60%) Matt (10%)
<b>Coverage</b>	Measured at 30-35 microns DFT & 60° reflectance A variance of +/-5% may be obtained dependent on application process 18 m <sup>2</sup> /l @ 25 microns, assuming 100% transfer efficiency	
	<b>VOC</b>	<b>Specific Gravity</b>
<b>400 Topcoat</b>	450 g/l (dependent on colour & gloss)	1.07 (dependent on colour & gloss)
<b>05-44 Thinner</b>	769 g/l	0.77
<b>05-46 Thinner</b>	867 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.