

Product Data Sheet

Cromadex Liquid Coatings

Cromadex V39 Primer Rail Primer (Refurbishment)

Product Description

Cromadex V39 is an alkyd primer formulated for refurbishment programmes in the rail industry. When used as a system with Cromadex V60 Two Pack Rail Topcoat it meets the following specifications.

BS 6853 1999 Annex B
BS 476 Part 6 : 1989 Class 0
BS 476 Part 7 : 1997 Class 1

Products and Ancillaries

V39 Primer
85-72 Thinner (Standard)
05-46 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

Steel Degrease and abrade with P180. If necessary blast clean to remove millscale, minimum surface preparation SA2

Sound existing paint work Dry sand using P240 – P320

Application Details

Thinning Ratio 7 parts V39 Primer
1 part Thinner (dependent on application equipment)

Spraying Viscosity 45 – 70 seconds ISO Cup4 @ 20°C

Approved Thickness 35 – 45 microns DFT 75 – 100 microns WFT

Spray Gun	Fluid tip size	Working pressure
<i>Conventional</i>	1.6 – 1.8 mm	50 – 60 psi
<i>Suction Feed HVLP</i>	2.3 mm	10 psi (max)
<i>Pressure Pot HVLP</i>	1.4 mm	10 psi (max)
<i>Air Assisted Airless</i>	13 thou	1500 – 2000 psi (100-170 bar) fluid pressure 10 – 30 psi (0.7-1.4 bar) air assist

Electrostatic Resistivity will require adjustment. Please inform your local Cromadex Centre at time of purchase

Heated Methods Reduce thinning ratios as required

Drying and Overcoating

Substrate Temperature	Drying Times		Overcoating Times	
	Touch Dry	Through Dry	Minimum	Maximum
20°C	30 mins	6 hours	30 mins	7 days

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

Force Drying Flash-off for 10-15 mins, then 60°C for 45 mins

Full Properties 7 days

V39 Primer is overcoatable after the minimum drying time (above) with Cromadex V60 Rail Topcoat only.

Cromadex V39 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	46 %	
Colour	Off-white (nr RAL 9002)	
Coverage	13 m ² /l @ 35 microns, assuming 100% transfer efficiency	
	VOC	Specific Gravity
<i>V39 Primer</i>	470 g/l	1.27
<i>05-46 Thinner</i>	870 g/l	0.87
<i>85-72 Thinner</i>	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.
