

# Product Data Sheet

## Cromadex Liquid Coatings

### Cromadex 635 Topcoat

### Two Pack Polyurethane Leatherette Topcoat

#### Product Description

Cromadex 635 is a two pack polyurethane leatherette topcoat with excellent exterior durability and chemical resistance. The product exhibits excellent colour retention adding value to the finished article, whilst the leatherette effect can help differentiate your finish.

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

Cromadex 635 is available in the full Cromadex range of colours, including BS, RAL and special matches all in a lead free finish.

#### Extra Life

Life expectancy of up to 25 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

635 Topcoat  
600/635 Curing Agent  
25-03 Thinner  
600 Rapidcure

#### 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
<b>GRP</b>	Remove release coat, degrease and abrade with P280
<b>Powder Coating</b>	Degrease and abrade with P280
<b>Plastics</b>	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

<b>Mixing Ratio</b>	5 parts 635 Topcoat 1 part 600/635 Curing Agent <b>Note:</b> Once mixed, topcoat is ready for use. If necessary a small quantity of thinners may be added to assist application	
<b>Spraying Viscosity</b>	As mixed	
<b>Pot Life</b>	4 hours @ 20°C (dependent on colour)	
<b>Approved Thickness</b>	60 – 100 microns DFT 120 – 190 microns WFT	
<b>Spray Gun</b>	<b>Fluid tip size</b>	<b>Working pressure</b>
<i>Gravity 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)

For best results it is recommended that a light coat followed by a full wet-coat be applied with a short flash-off period of 5-10 mins between coats.

# Cromadex 635 Topcoat

## Drying and Overcoating

Substrate Temperature	Drying Times		Overcoating Times	
	Touch Dry	Through Dry	Minimum	Maximum
20°C	45 mins	8 hours	Not suitable for overcoating	
35°C	30 mins	6 hours		

Note: For information on 600 Rapidcure 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

## 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

**Colour** Full range available including BS, RAL and special matches – all lead chromate free

**Gloss** Full gloss, other gloss levels available on request

**Coverage** 8.5 m<sup>2</sup>/l @ 60 microns, assuming 100% transfer efficiency

	VOC	Specific Gravity
<b>635 Topcoat</b>	467 g/l (dependent on colour)	1.16 (dependent on colour)
<b>600/635 Curing Agent</b>	314 g/l	1.05
<b>25-03 Thinner</b>	873 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.