

# Product Data Sheet

## Cromadex Liquid Coatings

### Cromadex 850 Primer

### Two Pack Non-Isocyanate Acrylic Primer

#### Product Description

Cromadex 850 is a two pack non-isocyanate acrylic primer for use over a wide range of substrates. It contains zinc phosphate giving added corrosion resistance for greater durability.

The product is formulated without isocyanate helping to reduce health and safety concerns. Cromadex 850 can be applied wet-on-wet giving improved productivity.

Cromadex 850 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 15 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

850 Primer  
850 Curing Agent  
25-03 Thinner (Standard)  
No 6 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

##### Aluminium & Galvanised Steel

Degrease and abrade with P240 to remove surface oxide layer. For even greater system performance apply Cromadex 903 Chromate-Free Etch Primer

##### Stainless Steel

Degrease and abrade with P180

##### GRP

Remove release coat, degrease and abrade with P280

##### Plastics

Direct adhesion to ABS, Noryl & PU Foam (Rigid), HIPS, Acrylic, Polycarbonate, PVC and PU Foam (flexible). Clean with a suitable anti-static cleaner prior to coating

##### MDF

May be applied directly to medium density fibreboard. Exterior grades may require abrasion and degreasing to remove the surface wax coating

##### Hard & Soft Wood

To get the best results, ensure surfaces to be painted are sound, clean and dry. Abrade with P240. First coat may need additional thinners added to aid absorption.

#### Application Details

##### Mixing Ratio

5 parts 850 Primer  
1 part 850 Curing Agent  
1-2 parts Thinner (dependent on application equipment)

##### Spraying Viscosity

45 – 70 seconds ISO Cup4 @ 20°C

##### Pot Life

When mixed 8 hours @ 20°C

##### Approved Thickness

30 – 40 microns DFT

85 – 110 microns WFT

# Cromadex 850 Primer

<b>Application Details</b>	<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	1800 – 2000 psi fluid pressure 10-30 psi air-assist		
	<i>Electrostatic</i>	Ready for use			
<b>Drying and Overcoating</b>	<b>Substrate Temperature</b>	<b>Drying Times</b>		<b>Overcoating Times</b>	
		<b>Touch Dry</b>	<b>Through Dry</b>	<b>Minimum</b>	<b>Maximum</b>
	20°C	15 mins	3 hours	wet-on-wet	7 days
	35°C	10 mins	2 hours	wet-on-wet	7 days
	Note: If primer is not overcoated within 7 days then abrade with either P240 – P320 and clean with Cromadex 678 Spirit Wipe Wet edge can be extended with use of No 6 Thinner				
	<b>Force Drying</b>	Flash-off for 10-15 mins, then 60-80°C for 30 mins			
	<b>Full Properties</b>	7 days if air dried @ 20°C, or immediately after stoving			
<b>Storage and Handling</b>	<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			
<b>Physical Properties</b>	<b>Volume Solids</b>	35 % mixed			
	<b>Colour</b>	White Tinted pastel shades available – all lead chromate free			
	<b>Coverage</b>	12 m <sup>2</sup> /l @ 30 microns (mixed), assuming 100% transfer efficiency			
		<b>VOC</b>	<b>Specific Gravity</b>		
	<i>850 Primer</i>	570 g/l	1.28		
	<i>850 Curing Agent</i>	579 g/l	0.97		
	<i>25-03 Thinner</i>	870 g/l	0.87		
	<i>No 6 Thinner</i>	870 g/l	0.87		
<b>Safety Precautions and Disclaimer</b>	<b>Before using this product please refer to the Cromadex Material Safety Data Sheet.</b>				
	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.				