

Product Data Sheet

Cromadex Liquid Coatings

Cromadex 750 Primer Two Pack Epoxy Primer

Product Description

Cromadex 750 is a two pack epoxy primer for use over a wide range of substrates. It contains zinc phosphate giving added corrosion resistance for greater durability.

The product can be air dried or stoved giving flexibility in your production line.

Cromadex 750 is available in white and grey as standard, it can also be tinted to ensure complete coverage even on difficult lead free colours.

Extra Life

Life expectancy of up to 25 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

750 Primer
750 Curing Agent
No 1 Thinner

Suitable Substrates and Preparation

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

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| 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 |
| Powder Coating | Degrease and abrade with P280 |
| Concrete | Suitable for sound concrete aged for 3 months. For porous surfaces apply sealer coat thinned with 5% No 1 Thinner by brush or roller then one full un-thinned coat |

Application Details

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|---------------------------|--|
| Mixing Ratio | 5 parts 750 Primer 1 part 750 Curing Agent 1-2 parts No 1 Thinner (dependent on application equipment) Note: product should be mixed 10 minutes prior to application |
| Spraying Viscosity | 45 – 70 seconds ISO Cup4 @ 20°C |
| Pot Life | When mixed 6 hours @ 20°C |
| Approved Thickness | 25 – 35 microns DFT 40 – 60 microns WFT |

Cromadex 750 Primer

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| Application Details | Spray Gun | Fluid tip size | Working pressure | | |
| | <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> | 1.2 – 1.4 mm | 0.7 bar (max) | | |
| | <i>Air Assisted Airless</i> | 9 – 11 thou | 1800 – 2000 psi fluid pressure 10 – 30 psi air assist | | |
| | <i>Electrostatic</i> | Ready for use | | | |
| Drying and Overcoating | Substrate Temperature | Drying Times | | Overcoating Times | |
| | 20°C | Touch Dry | Through Dry | Minimum | Maximum |
| | | 60 mins | 8 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 60-80°C for 30 mins | | | |
| | Stoving | Flash-off for 10-15 mins, then 120°C for 30 mins | | | |
| | Full Properties | 7 days if air dried @ 20°C, or immediately after stoving | | | |
| | 750 Primer is overcoatable after the minimum drying time of 30 minutes with all Cromadex General Industrial Topcoats. | | | | |
| 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 litres | | | |
| Physical Properties | Volume Solids | 55 % mixed | | | |
| | Colour | White (nr RAL 9002), grey (nr RAL 7035) Tinted pastel shades available – all lead chromate free | | | |
| | Coverage | 18 m ² /l @ 30 microns (mixed), assuming 100% transfer efficiency | | | |
| | | VOC | Specific Gravity | | |
| | <i>750 Primer</i> | 427 g/l | 1.61 | | |
| | <i>750 Curing Agent</i> | 269 g/l | 0.94 | | |
| | <i>No 1 Thinner</i> | 868 g/l | 0.87 | | |
| Safety Precautions and Disclaimer | <p>Before using this product please refer to the Cromadex Material Safety Data Sheet.</p> <p>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.</p> <p>It is the user's responsibility to check that this data sheet is current prior to using the product.</p> | | | | |