

Product Data Sheet

Cromadex Liquid Coatings

Cromadex 835 Topcoat

Two Pack Non-Isocyanate Acrylic Leatherette Topcoat

Product Description

Cromadex 835 is a two pack non-isocyanate acrylic leatherette topcoat with excellent exterior durability and chemical resistance. The product uses unique resin and pigment technology enable a wide variety of applications and a durable finish, whilst the leatherette effect can help differentiate your finish.

The product is formulated without isocyanate helping to reduce health and safety concerns.

Cromadex 835 is available in the full Cromadex range of colours and gloss levels, including BS, RAL and special matches all in a lead free finish.

Extra Life

Life expectancy of up to 15 years in a C3* environment when used with a suitable Cromadex primer. See Extra Life brochure for full details.

* as determined in ISO12944: 12944

Products and Ancillaries

800 Topcoat
800/835 Curing Agent
25-03 Thinner (Standard)
No 6 Thinner (Slow)

Suitable Substrates and Preparation

Mild Steel	Degrease with and abrade steel with P180. If necessary blast clean to remove millscale, minimum surface preparation SA2. Apply suitable Cromadex primer
Aluminium & Galvanised Steel	Apply Cromadex 903 Chromate-Free Etch Primer (then other Cromadex primer is required to increase film build)
Stainless Steel	Use of Cromadex 903, AQ58, 750 or 850 primer is required
GRP	Remove release coat, degrease and abrade with P280
Powder Coating	Degrease and abrade with P280
Plastics	Direct adhesion to ABS, Noryl & PU Foam (Rigid), HIPS, Acrylic, uPVC, Polycarbonate, PVC and PU Foam (flexible). Clean with a suitable anti-static cleaner prior to coating.

Application Details

Mixing Ratio	5 parts 835 Topcoat 1 part 800/835 Curing Agent	
	Note: Once mixed, topcoat is ready for use. If necessary a small quantity of thinners may be added to assist application	
Spraying Viscosity	As mixed	
Pot Life	8 hours @ 20°C (dependent on colour)	
Approved Thickness	60 – 100 microns DFT	125 – 210 microns WFT

Application Details

Spray Gun	Fluid tip size	Working pressure
<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 minutes between coats	

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Drying and Overcoating	Substrate Temperature	Drying Times		Overcoating Times	
		Touch Dry	Through Dry	Minimum	Maximum
	20°C	15 mins	4 hours	Not suitable for overcoating	
	35°C	10 mins	3 hours		
	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			
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	47 % mixed, dependent on colour and gloss			
	Colour	Full range available including BS, RAL and special matches – all lead chromate free			
	Gloss	Full gloss			
	Coverage	7.8 m ² /l @ 60 microns, assuming 100% transfer efficiency			
			VOC		Specific Gravity
	835 Topcoat	470 g/l (dependent on colour)		1.14 (dependent on colour)	
	800/835 Curing Agent	491 g/l		1.00	
	25-03 Thinner	873 g/l		0.87	
	No 6 Thinner	870 g/l		0.87	
Safety Precautions and Disclaimer	Before using this product please refer to the Cromadex Material Safety Data Sheet.				
	<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>				