

# Product Data Sheet

## Cromadex Liquid Coatings Cromadex AQ58 Primer One Pack Waterbased Acrylic Primer

### Product Description

Cromadex AQ58 is a one pack waterbased acrylic primer for use over a wide range of substrates.

Cromadex AQ58 is available in grey and white as standard, it can also be tinted to ensure complete coverage even on difficult lead free colours.

### Products and Ancillaries

AQ58 Primer  
AQ Equipment Cleaner (CX1A01)  
AQ Conversion Cleaner (CG1A01)

### Suitable Substrates and Preparation

Surfaces should be clean, dry and free from contamination

<b>Steel</b>	Degrease with Cromadex 678 Spirit Wipe and abrade with P180. If necessary blast clean to remove millscale, minimum surface preparation SA2
<b>Aluminium &amp; Galvanised Steel</b>	Degrease with Cromadex 678 Spirit Wipe and abrade with P240 to remove surface oxide layer. For even greater system performance apply Cromadex 903 Chromate-Free Etch Primer
<b>Plastics (ABS)</b>	Substrate must be absolutely clean – dirt, stains, grease, moisture etc to be removed. A suitable antistatic cleaner should be used
<b>Stainless Steel</b>	Degrease with Cromadex 678 Spirit Wipe and abrade with P180
<b>Wood</b>	Suitable for seasoned softwood only
<b>MDF</b>	May be directly applied to medium density fibre board. Exterior grades may require abrasion to remove the surface wax coating
<b>Existing Finish</b>	Degrease with Cromadex 678 Spirit Wipe and abrade existing finishes with P280 – P320

### Application Details

<b>Thinning Ratio</b>	Approx 5 – 20% with water (dependent on application equipment)
<b>Spraying Viscosity</b>	45 – 55 seconds ISO Cup4 @ 20°C 19 – 23 seconds DIN 4 Cup @ 20°C 25 – 30 seconds BS 4 Cup @ 20°C
<b>Approved Thickness</b>	30 – 40 microns DFT                      55 – 70 microns WFT

Ensure all equipment is thoroughly flushed with potable water immediately before and after use. If using non-stainless steel equipment, please flush with CX1A01, the CG1A01 after use to prevent internal corrosion.

**Curing**                      Should not be applied below 10°C. For optimum performance, temperature should be 10-30°C, and 35-75% RH. Air movement over the applied coating speeds drying considerably

# Cromadex AQ58 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 (50-60 psi)		
	<i>Suction Feed HVLP</i>	1.4 – 1.8 mm	0.7 bar (max) (10 psi)		
	<i>Pressure Pot HVLP</i>	1.0 – 1.4 mm	0.7 bar (max) (10 psi)		
	<i>Air Assisted Airless</i>	11 – 13 thou	100-120 bar (1500-1800 psi) fluid pressure 0.7-2.0 bar (10-30 psi) air assist		
	<b>Brush and Roller</b>	Not recommended			
	<i>Electrostatic</i>	Automatic – Recommended Manual – Contact equipment supplier for detailed information			
<b>Drying and Overcoating</b>	<b>Substrate Temperature</b>	<b>Drying Times</b>		<b>Overcoating Times</b>	
	20°C	<b>Touch Dry</b>	<b>Through Dry</b>	<b>Minimum</b>	<b>Maximum</b>
		30 mins	6 hours	30 mins	7 days
	Note: Recoating without reaction can only be carried out when the primer surface is sufficiently cured. Times shown assume good air movement, acceptable humidity and at the recommended film thickness.				
	If primer is not overcoated within 7 days then prepare as existing finish				
	<b>Force Drying</b>	Flash-off for 20 mins, then 60-80°C for 30 mins			
	<b>Stoving</b>	Flash-off for 20 mins, then 120°C for 15 mins			
	<b>Full Properties</b>	7 days if air dried @ 20°C, or immediately following force drying/stoving			
	<b>Overcoatable with</b>	All one-pack and two-pack products			
<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>	58 % (dependent on colour)			
	<b>Colour</b>	Grey (nr RAL 7035), White Tinted pastel shades available – all lead chromate free			
	<b>Coverage</b>	16 m <sup>2</sup> /l @ 25 microns, assuming 100% transfer efficiency			
		<b>VOC</b>		<b>Specific Gravity</b>	
	<i>AQ58 Primer</i>	162 g/l (water removed)		1.38	
	<i>CX1A01</i>	42 g/l		1.00	
	<i>CG1A01</i>	880 g/l		0.88	
<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.				