

Product Data Sheet

Cromadex Liquid Coatings Cromadex 640 Topcoat Two Pack Polyurethane Fine Texture Topcoat

Product Description

Cromadex 640 is a two pack polyurethane fine texture topcoat with excellent exterior durability and chemical resistance. The product offers a fine texture appearance for an aesthetic finish.

Cromadex 640 demonstrates good mar resistance, ideal if the end product is to be widely handled.

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

Cromadex 640 is available in the full Cromadex range of colours, including BS, RAL, metallic 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

640 Topcoat
600/640 Curing Agent
25-03 Thinner (Standard)
No 6 Thinner (Slow)
600 Rapidcure

Suitable Substrates and Preparation

Mild Steel	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
Aluminium & Galvanised Steel Stainless Steel	Apply Cromadex 903 Chromate-Free Etch Primer Use of Cromadex 903, AQ58, 750 or 850 primer is required
Powder Coating	Degrease and abrade with P280
Plastics	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

Mixing Ratio	5 parts 640 Topcoat 1 part 600/640 Curing Agent 1-2 parts Thinner (dependent on application equipment)	
Spraying Viscosity	45 – 70 seconds ISO Cup4 @ 20°C 25 – 30 seconds BS Cup4 @ 20°C	
Pot Life	4 hours @ 20°C (dependent on colour)	
Approved Thickness	25 – 35 microns DFT	50 – 70 microns WFT
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>	1.0 – 1.4 mm	0.7 bar (max)
<i>Other Methods</i>	Not suitable	

Cromadex 640 Topcoat

Drying and Overcoating

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

Note: Wet edge can be extended with use of No 6 Thinner
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
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	50 % mixed, dependent on colour	
Colour	Full range available including BS, RAL and special matches – all lead chromate free	
Gloss	Visual appearance will be affected by the fine texture additive	
Coverage	18.7 m ² /l @ 25 microns, assuming 100% transfer efficiency	
	VOC	Specific Gravity
640 Topcoat	484 g/l (dependent on colour)	1.17 (dependent on colour)
600/640 Curing Agent	314 g/l	1.05
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.

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.