

# Product Data Sheet

## Cromadex Liquid Coatings Cromadex 683 Primer Finish Two Pack Polyurethane Eggshell Primer Finish

**Product Description** Cromadex 683 is a two pack eggshell primer finish for application direct to metal (DTM). It is a high build finish making it suitable for blasted steel.

The product contains zinc phosphate giving added corrosion resistance for greater durability.

Cromadex 683 is available in full Cromadex range of colours, including BS, RAL, and special matches all in a lead free finish.

**Extra Life** Life expectancy of up to 7 years in a C3\* environment. See Extra Life brochure for full details.

\* as determined in ISO12944: 2018

**Products and Ancillaries**  
683 Primer Finish  
690 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

<b>Steel</b>	Degrease and abrade with P180. If necessary blast clean to remove millscale, minimum surface preparation SA2
<b>Aluminium &amp; Galvanised Steel</b>	Degrease and abrade with P240 to remove surface oxide layer. For even greater system performance apply Cromadex 903 Chromate-Free Etch Primer (then other Cromadex primer if required to increase film build)
<b>Stainless Steel</b>	Use of Cromadex 903, AQ58, 750 or 850 primer is required.
<b>GRP</b>	Remove release coat, degrease and abrade with P280. Primer with Cromadex 750 primer.
<b>Powder Coating</b>	Degrease and abrade with P280. Prime as necessary with Cromadex 750 or 850 primer.

**Application Details**

<b>Mixing Ratio</b>	8 parts 683 Primer Finish 1 part 690 Curing Agent Thinning not normally required, dependent on application equipment	
<b>Pot Life</b>	4 hours @ 20°C (dependent on colour)	
<b>Approved Thickness</b>	70 – 90 microns DFT	125 – 155 microns WFT
<b>Spray Gun</b>	<b>Fluid tip size</b>	<b>Working pressure</b>
<i>Pressure Pot HVLP</i>	1.0 – 1.4 mm	0.7 bar (10 psi)
<i>Airless</i>	11 – 13 thou	2,200 – 2,700 psi
<i>Air Assisted Airless</i>	11 – 13 thou	1,800 – 2,200 psi fluid pressure 10 – 30 psi air pressure

# Cromadex 683 Primer Finish

Drying and Overcoating	Substrate Temperature	Drying Times		Overcoating Times	
		Touch Dry	Through Dry	Minimum	Maximum
	20°C	30 mins	6 hours	6 hours	7 days
	35°C	25 mins	5 hours	4 hours	7 days
<p>Note: Wet edge can be extended with use on No 6 Thinner If not overcoated within 7 days then abrade with either P240 or P320 and clean with Cromadex 678 Spirit Wipe.</p>					
	<b>Force drying</b>	Flash off for 20 mins, then 60 – 80°C for 30 mins Note: force drying may result in change of gloss level			
	<b>Full Properties</b>	7 days			
<p><b>683 Primer Finish</b> is overcoatable after the minimum drying time (above) with itself and all Cromadex Topcoats (for cosmetic purposes only).</p>					
Storage and Handling	<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>	4 & 16 litres			
Physical Properties	<b>Volume Solids</b>	59 % (mixed, dependent on colour)			
	<b>Colour</b>	Full range available including BS, RAL and special matches – all lead chromate free			
	<b>Gloss</b>	Eggshell (30%) Measured at 70-75 microns DFT & 60° reflectance <small>A variance of +/-5% may be obtained dependent on application process</small>			
	<b>Coverage</b>	7.9 m <sup>2</sup> /l @ 75 microns (dependent on colour), assuming 100% transfer efficiency			
			<b>VOC</b>		<b>Specific Gravity</b>
	<b>683 Primer Finish</b>	363 g/l <small>(dependent on colour)</small>		1.60 <small>(dependent on colour)</small>	
	<b>690 Curing Agent</b>	207 g/l		1.09	
	<b>25-03 Thinner</b>	873 g/l		0.87	
	<b>No 6 Thinner</b>	870 g/l		0.87	
Safety Precautions and Disclaimer	<p><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.</p> <p>It is the user's responsibility to check that this data sheet is current prior to using the product.</p>				