

Product Data Sheet

Cromadex Liquid Coatings

Cromadex 310 Topcoat

Low Bake Stoving Topcoat

Product Description

Cromadex 310 is a low bake stoving topcoat that contains melamine to give it a tough durable finish. The lower stoving schedule of the product can help in reducing overall heating costs.

The unique resin and pigment technology used enables both a wide variety of applications and a durable finish.

Cromadex 310 is available in the full Cromadex range of colours including BS, RAL, metallic, sparkles and special matches all in a lead free finish. It is available in a full gloss, semi-gloss and satin gloss finish.

Products and Ancillaries

310 Topcoat
05-46 Thinner (Standard)
85-72 Thinner (Slow)

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	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

Application Details

Thinning Ratio	10 parts 310 Topcoat 1 part Thinner (dependent on application equipment)	
Spraying Viscosity	45 – 55 seconds ISO Cup4 @ 20°C 25 – 30 seconds BS 4 Cup @ 20°C	
Approved Thickness	25 – 50 microns DFT	75 – 100 microns WFT
Spray Gun	Fluid tip size	Working pressure
<i>Conventional</i>	1.4 – 1.8 mm	3.1 – 4.2 bar
<i>Suction Feed HVLP</i>	1.4 – 1.8 mm	0.7 bar (max)
<i>Pressure Feed HVLP</i>	1.0 – 1.4 mm	0.7 bar (max)
Electrostatic	Resistivity will require adjustment. Please inform your local Cromadex centre at time of purchase.	
Heated Methods	Reduce thinning ratios as required	

Cromadex 310 Topcoat

Drying and Overcoating	Substrate Temperature	Drying Times	
		Touch Dry	Through Dry
STOVING ONLY			
	Stoving	Flash-off for 10 – 15 mins, then stove at 100°C for 30 minutes – minimum 115°C for 15 minutes – optimum 140°C for 5 minutes – maximum	
	Full Properties	Gloss levels will vary if the recommended film thickness is not obtained After stoving. Abrade with P240 – P320 prior to subsequent overcoating	
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	43 % mixed, dependent on colour and gloss	
	Colour	Full range available including BS, RAL and special matches – all lead chromate free	
	Gloss	Full gloss (90% min) Satin (40%) Plus intermediates on request	Semi gloss (60%)
		Measured at 30-35 microns DFT & 60° reflectance A variance of +/-5% may be obtained dependent on application process	
	Coverage	17 m ² /l @ 25 microns, assuming 100% transfer efficiency	
		VOC	Specific Gravity
	310 Topcoat	495 g/l (dependent on colour & gloss)	1.14 (dependent on colour & gloss)
	05-46 Thinner	867 g/l	0.87
	85-72 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.		