

Product Data Sheet

Cromadex Liquid Coatings

Cromadex V60 Topcoat Two Pack Rail Topcoat

Product Description

Cromadex V60 is a two pack polyurethane topcoat formulated for refurbishment programmes in the rail industry. When used as a system with Cromadex V39 Rail Primer (Refurbishment) it meets the following specifications:

BS 6853 1999 Annex B
BS 476 Part 6 : 1989 Class 0
BS 476 Part 7 : 1997 Class 1

Cromadex V60 is certified as a single coat application (mainly to plastics) for the following specifications:
BS 476 Parts 6 & 7 Fire Propagation and Surface Spread of Flame
BS 6853 Annex B, Clause B.2 Toxic Fume Emission
BS 6853 Annex D, Clause D.8.4 Methods for Measuring Smoke Density

Products and Ancillaries

V60 Topcoat
V60 Curing Agent
25-03 Thinner (Standard)
No 6 Thinner (Slow)

Suitable Substrates and Preparation

| | |
|----------------------------------|--|
| Mild Steel | Degrease and abrade steel with P180. If necessary blast clean to remove millscale, minimum surface preparation SA2. Apply Cromadex V39 primer |
| Sound existing paint work | Dry sand using P320-P240. Apply Cromadex V39 primer |
| Plastics | Direct adhesion to ABS, Noryl & PU Foam (Rigid), for other plastics consult your local Cromadex centre. Clean with a suitable anti-static cleaner prior to coating |

Application Details

| | | |
|---------------------------|--|-------------------------|
| Mixing Ratio | 5 parts V60 Topcoat 1 part V60 Curing Agent 1-2 parts Thinner (dependent on application equipment) | |
| Spraying Viscosity | 45 – 70 seconds ISO 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>Electrostatic</i> | Resistivity will require adjustment. Please inform your local Cromadex centre at time of purchase | |

Cromadex V60 Topcoat

| Drying and Overcoating | Substrate Temperature | Drying Times | | Overcoating Times | |
|--|--|---|---------------------------------------|--------------------------------|------------------------------------|
| | | Touch Dry | Through Dry | Minimum | Maximum |
| | 20°C | 45 mins | 8 hours | n/a | 7 days |
| | 35°C | 30 mins | 6 hours | n/a | 7 days |
| | Wet edge can be extended with use of No 6 Thinner | | | | |
| Force Drying | Flash-off for 10-15 mins, then 60-80°C for 30 mins Note: force drying may result in change of gloss level | | | | |
| Full Properties | 7 days @ 20°C Note: when fully cured, topcoat will need abrading 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 | 51 % mixed, dependent on colour and gloss | | | |
| | Colour | Full range available including BS, RAL, metallics, sparkles and special matches – all lead chromate free | | | |
| | Gloss | Full gloss (90% min) Eggshell (30%) Plus intermediates on request | | Semi gloss (60%) Matt (10%) | |
| | | Measured at 30-35 microns DFT & 60° reflectance A variance of +/-5% may be obtained dependent on application process | | | |
| | Coverage | 17 m ² /l @ 30 microns, assuming 100% transfer efficiency | | | |
| | | VOC | | | Specific Gravity |
| | | V60 Topcoat | 464 g/l (dependent on colour & gloss) | | 1.16 (dependent on colour & gloss) |
| | V60 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. | | | | |