

Product Data Sheet

Cromadex Liquid Coatings Cromadex 680 Primer Finish Two Pack Polyurethane Matt Primer Finish

Product Description

Cromadex 680 is a two pack matt 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 680 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

680 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

Steel	Degrease and abrade with P180. If necessary blast clean to remove millscale, minimum surface preparation SA2
Aluminium & Galvanised Steel	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)
Stainless Steel	Use of Cromadex 903, AQ58, 750 or 850 primer is required.
GRP	Remove release coat, degrease and abrade with P280. Primer with Cromadex 750 primer.
Powder Coating	Degrease and abrade with P280. Prime as necessary with Cromadex 750 or 850 primer.

Application Details

Mixing Ratio	8 parts 680 Primer Finish 1 part 690 Curing Agent Thinning not normally required, dependent on application equipment	
Pot Life	4 hours @ 20°C (dependent on colour)	
Approved Thickness	75 – 90 microns DFT	130 – 160 microns WFT
Spray Gun	Fluid tip size	Working pressure
<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 680 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

Note: If not overcoated within 7 days then abrade with P240 – P320 and clean with Cromadex 678 Spirit Wipe

Force drying Flash off for 20 mins, then 60 – 80°C for 30 mins

Full Properties 7 days

680 Primer Finish is overcoatable after the minimum drying time (above) with itself and all Cromadex Topcoats (for cosmetic purposes only).

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	4 litres

Physical Properties

Volume Solids	55 % (mixed, dependent on colour)	
Colour	Full range available including BS, RAL and special matches – all lead chromate free	
Gloss	Matt Measured at 70-75 microns DFT & 60° reflectance <small>A variance of +/-5% may be obtained dependent on application process</small>	
Coverage	7.3 m ² /l @ 75 microns (dependent on colour), assuming 100% transfer efficiency	
	VOC	Specific Gravity
680 Primer Finish	400 g/l (dependent on colour)	1.62 (dependent on colour)
690 Curing Agent	207 g/l	1.09
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.