

Product Data Sheet

Cromadex Liquid Coatings

Cromadex 395 Primer Anti-Corrosive Primer

Product Description

Cromadex 395 is an anti-corrosive primer containing zinc phosphate giving added corrosion resistance for greater durability. It is higher in solids giving superb opacity and coverage.

The product has superb flow and levelling giving excellent topcoat appearance and can be used over sound existing paintwork, making it ideal for refurbishment work.

Cromadex 395 is available in off-white (nr RAL 9002) and black as standard, it can also be tinted to ensure complete coverage even on difficult lead free colours.

Extra Life

Life expectancy of up to 7 years in a C3* environment when used with a suitable Cromadex topcoat. See Extra Life brochure for full details.

* as determined in ISO12944: 2018

Products and Ancillaries

395 Primer
05-46 Thinner (Standard)
85-72 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. Apply Cromadex 903 Chromate-Free Etch Primer
Sound existing paint work	Dry sand using P240-P320

Application Details

Thinning Ratio	7 parts 395 Primer 1 part Thinner (dependent on application equipment)	
Spraying Viscosity	45 – 70 seconds ISO Cup4 @ 20°C	
Approved Thickness	35 – 45 microns DFT	75 – 100 microns WFT

Application Details

Spray Gun	Fluid tip size	Working pressure
<i>Conventional</i>	1.6 – 1.8 mm	50 – 60 psi
<i>Suction Feed HVLP</i>	1.6 – 1.8 mm	10 psi (max)
<i>Pressure Pot HVLP</i>	1.2 - 1.4 mm	10 psi (max)
<i>Air Assisted Airless</i>	11 - 13 thou	1500 – 2000 psi (100-170 bar) fluid pressure 10 – 30 psi (0.7-1.4 bar) air assist
Heated Methods	Reduce thinning ratios as required	

Cromadex 395 Primer

Drying and Overcoating

Substrate Temperature	Drying Times		Overcoating Times	
	Touch Dry	Through Dry	Minimum	Maximum
20°C	30 mins	6 hours	30 mins	7 days

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

Force Drying Flash-off for 10-15 mins, then 60°C for 45 mins

Full Properties 7 days

395 Primer is overcoatable after the minimum drying time (above) with all Cromadex General Industrial Topcoats except 700, 740 & 742.

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 46 %

Colour Off-white (nr RAL 9002) & black
Tinted pastel shades available – all lead chromate free

Coverage 13 m²/l @ 35 microns, assuming 100% transfer efficiency

	VOC	Specific Gravity
395 Primer	470 g/l	1.27
05-46 Thinner	870 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.