

Product Data Sheet

Cromadex Liquid Coatings Cromadex 290 Primer Finish One Pack Gloss Primer Finish

Product Description

Cromadex 290 is a one pack gloss primer finish for application direct to metal (DTM), it is suitable for both interior and exterior use.

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

Cromadex 290 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

290 Primer Finish
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
Aged Coatings	Loose or flaking coatings should be removed back to a firm edge. Dry sand using P240-P320

Application Details

Thinning Ratio	Not normally required, dependent on application equipment		
Approved Thickness	75 – 100 microns DFT	150 – 200 microns WFT	
Spray Gun	Fluid tip size	Working pressure	
<i>Pressure Pot HVLP</i>	1.0 – 1.4 mm	0.7 bar (max)	
<i>Airless</i>	11 – 13 thou	2500 psi	
<i>Air Assisted Airless</i>	11 – 13 thou	1800 – 2000 psi fluid pressure	
		10-30 psi air-assist	
Brush/Roller	Suitable for small areas and touch-up only		

Drying and Overcoating

Substrate Temperature	Drying Times		Overcoating Times	
	Touch Dry	Through Dry	Minimum	Maximum
20°C	15 mins	9 hours	6 hours	7 days
35°C	10 mins	6 hours	4 hours	7 days

Full Properties 7 days

If not covercoated within 7 days then abrade with P240 – P320 and clean with Cromadex 678 Spirit Wipe.

290 Primer Finish is overcoatable after the minimum drying time (above) with itself and Cromadex 222, 233 & 400 Topcoats (for cosmetic purposes only).

Cromadex 290 Primer Finish

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	47 % (dependent on colour)	
Colour	Full range available including BS, RAL and special matches – all lead chromate free	
Gloss	Gloss (80%) A variance of +/-5% may be obtained dependent on application process	
Coverage	6.3 m ² /l @ 75 microns (dependent on colour), assuming 100% transfer efficiency	
	VOC	Specific Gravity
290 Primer	448 g/l (dependent on colour)	1.11 (dependent on colour)
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.