

Product Data Sheet

Cromadex Liquid Coatings Cromadex 258 Topcoat Air Drying Hammer Topcoat

Product Description

Cromadex 258 is an air drying hammer topcoat that gives a substrate-hiding, special effect finish.

Cromadex 258 is available in a wide range of colours all in a lead free finish.

Extra Life

Life expectancy of up to 7 years in a C2* external environment when used with a suitable Cromadex primer. See Extra Life brochure for full details.

* as determined in ISO12944: 2018

Products and Ancillaries

258 Topcoat
No 1 Thinner

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 | Up to 10% by volume with Cromadex No 1 Thinner when sprayed Ready for use when applied by brush or roller | |
| Spraying Viscosity | 55 – 65 seconds ISO Cup6 @ 25°C | |
| Approved Thickness | 90 – 110 microns DFT | 180 – 220 microns WFT |
| Spray Gun | Fluid tip size | Working pressure |
| <i>Conventional</i> | 1.4 – 1.8 mm | 3.5 – 4.2 bar |
| <i>HVLP Gravity</i> | 1.8 – 2.0 mm | 2.0 bar (approx) |
| <i>Brush and Roller</i> | Suitable | |

Drying and Overcoating

| Substrate Temperature | Drying Times | | Overcoating Times | |
|------------------------|---|-------------|-------------------|---------|
| | Touch Dry | Through Dry | Minimum | Maximum |
| 20°C | 90 mins | 24 hours | After 4 hours | |
| Force Drying | Flash-off for 15-20 mins, then 80°C for 30 mins | | | |
| Stoving | Flash-off for 15-20 mins, then stove at 100°C for 30 mins | | | |
| Full Properties | 7 days | | | |

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 |

Cromadex 258 Topcoat

Physical Properties

| | | |
|----------------------|--|----------------------------|
| Volume Solids | 50 % mixed, dependent on colour | |
| Colour | Full range available including special matches – all lead chromate free | |
| Gloss | Semi gloss appearance Visual appearance will be affected due to the nature of the product | |
| Coverage | 5 m ² /l @ 100 microns, assuming 100% transfer efficiency | |
| | VOC | Specific Gravity |
| 258 Topcoat | 500 g/l (dependent on colour) | 1.00 (dependent on colour) |
| No 1 Thinner | 868 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.
