

# Product Data Sheet

## Cromadex Liquid Coatings

### Cromadex 840 Topcoat

### Two Pack Non-Isocyanate Acrylic Fine Texture Topcoat

#### Product Description

Cromadex 840 is a two pack non-isocyanate acrylic fine texture topcoat with excellent exterior durability and chemical resistance. The product uses unique resin and pigment technology enable a wide variety of applications and a durable finish, whilst the fine texture appearance offers an aesthetic finish.

The product is formulated without isocyanate helping to reduce health and safety concerns.

Cromadex 840 is available in the full Cromadex range of colours and gloss levels, including BS, RAL and special matches all in a lead free finish.

#### Extra Life

Life expectancy of up to 15 years in a C3\* environment when used with a suitable Cromadex primer. See Extra Life brochure for full details.

\* as determined in ISO12944: 2018

#### Products and Ancillaries

840 Topcoat  
800/840 Curing Agent  
25-03 Thinner (Standard)  
No 6 Thinner (Slow)

#### Suitable Substrates and Preparation

<b>Mild Steel</b>	Degrease with and abrade steel with P180. If necessary blast clean to remove millscale, minimum surface preparation SA2. Apply suitable Cromadex primer
<b>Aluminium &amp; Galvanised Steel</b>	Apply Cromadex 903 Chromate-Free Etch Primer (then other Cromadex primer is required to increase film build)
<b>Stainless Steel</b>	Use of Cromadex 903, AQ58, 750 or 850 primer is required
<b>GRP</b>	Remove release coat, degrease and abrade with P280
<b>Powder Coating</b>	Degrease and abrade with P280
<b>Plastics</b>	Direct adhesion to ABS, Noryl & PU Foam (Rigid), HIPS, Acrylic, uPVC, Polycarbonate, PVC and PU Foam (flexible). Clean with a suitable anti-static cleaner prior to coating.

#### Application Details

<b>Mixing Ratio</b>	5 parts 840 Topcoat 1 part 800/840 Curing Agent 1-2 parts Thinner (dependent on application equipment)	
<b>Spraying Viscosity</b>	45 – 70 seconds ISO Cup4 @ 20°C 25 – 30 seconds BS Cup4 @ 20°C	
<b>Pot Life</b>	8 hours @ 20°C (dependent on colour)	
<b>Approved Thickness</b>	25 – 35 microns DFT	70 – 80 microns WFT
<b>Spray Gun</b>	<b>Fluid tip size</b>	<b>Working pressure</b>
<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>Other Methods</i>	Not suitable	

# Cromadex 840 Topcoat

Drying and Overcoating	Substrate Temperature	Drying Times		Overcoating Times	
		Touch Dry	Through Dry	Minimum	Maximum
	20°C	15 mins	4 hours	Not recommended	
	35°C	10 mins	3 hours		
Note: Wet edge can be extended with use of No 6 Thinner					
	<b>Force Drying</b>	Flash-off for 10-15 mins, then 60-80°C for 30 mins			
	<b>Stoving</b>	Flash-off for 10-15 mins, then 120°C for 30 mins			
	<b>Full Properties</b>	7 days if air dried @ 20°C or immediately after stoving			
Storage and Handling	<b>Storage</b>	Storage should be in accordance with the instructions in Section 7 of the relevant material safety data sheet			
	<b>Shelf Life</b>	12 months in an unopened, original container from date of mixing at Cromadex centre			
	<b>Pack Size</b>	5 & 20 litres			
Physical Properties	<b>Volume Solids</b>	46 % mixed, dependent on colour			
	<b>Colour</b>	Full range available including BS, RAL and special matches – all lead chromate free			
	<b>Gloss</b>	Visual appearance will be affected by the fine texture additive			
	<b>Coverage</b>	15.4 m <sup>2</sup> /l @ 30 microns, assuming 100% transfer efficiency			
		<b>VOC</b>			<b>Specific Gravity</b>
	<b>840 Topcoat</b>	470 g/l	(dependent on colour)	1.13	(dependent on colour)
	<b>800/840 Curing Agent</b>	491 g/l		1.00	
	<b>25-03 Thinner</b>	873 g/l		0.87	
	<b>No 6 Thinner</b>	870 g/l		0.87	
Safety Precautions and Disclaimer	<p><b>Before using this product please refer to the Cromadex Material Safety Data Sheet.</b></p> <p>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.</p> <p>It is the user's responsibility to check that this data sheet is current prior to using the product.</p>				