

Product Data Sheet

Cromadex Liquid Coatings

Cromadex AQ75 Primer

Two Pack Waterbased Epoxy Primer

Product Description	Cromadex AQ75 is a two pack waterbased epoxy primer for use over a wide range of substrates. Cromadex AQ75 is an anti-corrosive primer containing zinc phosphate giving added corrosion resistance for greater durability. Cromadex AQ75 is available in buff as standard.		
Extra Life	Life expectancy of up to 15 years in a C3* external environment when used with a suitable Cromadex topcoat. See Extra Life brochure for full details.		
	* as determined in ISO12944		
Products and Ancillaries	AQ75 Primer AQ75 Curing Agent	AQ Equipment Cleaner (CX1A01) AQ Conversion Cleaner (CG1A01)	
Suitable Substrates and Preparation	Surfaces should be clean, dry and free from contamination		
	Steel & Aluminium	Degrease with Cromadex 678 Spirit Wipe and abrade with P180. If necessary blast clean to remove millscale, minimum surface preparation SA2	
	Galvanised & Stainless Steel	Degrease with Cromadex 678 Spirit Wipe and abrade with P240. Then apply, if necessary, Cromadex 903 Chromate-Free Etch Primer	
	Plastics (Acrylic, Noryl, ABS & Polycarbonate) MDF	Not suitable	
	Existing finish	May be directly applied to medium density fibre board. Exterior grades may require abrasion to remove the surface wax coating	
		Degrease with Cromadex 678 Spirit Wipe and abrade existing finishes with P240	
Application Details	Mixing Ratio	5 parts AQ75 Primer 1 part AQ75 Curing Agent 5 – 10% with water (dependent on application equipment)	
	Spraying Viscosity	45 – 55 seconds ISO Cup4 @ 20°C 19 – 23 seconds DIN 4 Cup @ 20°C 25 – 30 seconds BS 4 Cup @ 20°C	
	Pot Life	8 hours @ 20°C	
	Approved Thickness	30 – 40 microns DFT	70 – 100 microns WFT
	Ensure all equipment is thoroughly flushed with potable water immediately before and after use. If using non-stainless steel equipment, please flush with CX1A01, the CG1A01 after use to prevent internal corrosion.		
	Curing	Should not be applied below 10°C. For optimum performance, temperature should be 10-30°C, and 35-75% RH. Air movement over the applied coating speeds drying considerably	
	Spray Gun Conventional	Fluid tip size 1.4 – 1.8 mm	Working pressure 3.5 – 4.2 bar (50-60 psi)

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	Suction Feed HVLP	1.4 – 1.8 mm	0.7 bar (max) (10 psi)
	Pressure Pot HVLP	1.0 – 1.4 mm	0.7 bar (max) (10 psi)
	Airless	11 – 13 thou	120-140 bar (1800-2000 psi)
	Air Assisted Airless	11 – 13 thou	100-120 bar (1500-1800 psi)
			1 bar (15 psi) air
	Brush and Roller	Suitable	
	Electrostatic	Contact equipment supplier for information	

Drying and Overcoating	Substrate Temperature	Drying Times		Overcoating Times	
		Touch Dry	Through Dry	Minimum	Maximum
	20°C	30 mins	6 hours	60 mins	7 days
Note: Recoating without reaction can only be carried out when the primer surface is sufficiently cured. Times shown assume good air movement, acceptable humidity and at the recommended film thickness.					
If primer is not overcoated within 7 days then prepare as existing finish					
	Force Drying	Flash-off for 20 mins, then 60-80°C for 30 mins			
	Stoving	Not suitable			
	Full Properties	7 days if air dried @ 20°C, or immediately following force drying			
AQ75 Primer is overcoatable after the minimum drying time of 60 minutes with all Cromadex one and two pack products (both water and solvent based)					

Storage and Handling	Storage	Storage should be in accordance with the instructions in Section 7 of the relevant material safety data sheet	
	Shelf Life	6 months in an unopened, original container from date of mixing at Cromadex centre	
	Pack Size	5 litres	

Physical Properties	Volume Solids	46 % mixed	
	Colour	Buff Tinted shades available – all lead chromate free	
	Coverage	13 m ² /l @ 35 microns, assuming 100% transfer efficiency	
		VOC	Specific Gravity
	AQ75 Primer	291 g/l (water removed)	1.45
	AQ75 Curing Agent	0 g/l	1.08
	CX1A01	42 g/l	1.00
	CG1A01	880 g/l	0.88

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.		