

Product Data Sheet

Cromadex Liquid Coatings Cromadex 622 Topcoat Two Pack Polyurethane Topcoat

Product Description

Cromadex 622 is a two pack polyurethane topcoat with excellent chemical resistance. The product offers a high level of full gloss enhancing the value of the finished article.

The product can be air dried or force dried enabling flexibility in production.

Cromadex 622 is available in the full Cromadex range of colours including BS, RAL, metallic, sparkles and special matches all in a lead free finish.

Products and Ancillaries

622 Topcoat
622 Curing Agent
25-03 Thinner

Suitable Substrates and Preparation

Sheet 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
GRP	Remove release coat, degrease and abrade with P280
Powder Coating	Degrease and abrade with P280

Application Details

Mixing Ratio	5 parts 622 Topcoat 1 part 622 Curing Agent 1-2 parts 25-03 Thinner as required	
Spraying Viscosity	45 – 70 seconds ISO Cup4 @ 20°C 25 – 30 seconds BS Cup4 @ 20°C	
Pot Life	6 hours @ 20°C (dependent on colour)	
Approved Thickness	25 – 35 microns DFT	50 – 70 microns WFT
Spray Gun	Fluid tip size	Working pressure
<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>Airless</i>	9 – 11 thou	
<i>Electrostatic</i>	Resistivity will require adjustment. Please inform your local Cromadex centre at time of purchase	

Cromadex 622 Topcoat

Drying and Overcoating	Substrate Temperature	Drying Times		Overcoating Times	
		Touch Dry	Through Dry	Minimum	Maximum
	20°C	1 hour	6 hours	2 hours	Indefinite
	35°C	45 mins	4 hours	1 hour	Indefinite
	Force Drying	Flash-off for 10-15 mins, then 60-80°C for 30 mins			
	Full Properties	7 days @ 20°C			
		Note: when fully cured, topcoat will need abrading with P280 prior to subsequent overcoating			
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	35 % mixed, dependent on colour and gloss			
	Colour	Full range available including BS, RAL, metallics, sparkles and special matches – all lead chromate free			
	Gloss	Full gloss (90% min)		Semi gloss (60%)	
		Eggshell (30%)			
		Plus intermediates on request			
		Measured at 30-35 microns DFT & 60° reflectance A variance of +/-5% may be obtained dependent on application process			
	Coverage	14 m ² /l @ 25 microns, assuming 100% transfer efficiency			
		VOC		Specific Gravity	
	622 Topcoat	520 g/l (dependent on colour & gloss)		1.12 (dependent on colour & gloss)	
	622 Curing Agent	710 g/l		0.98	
	25-03 Thinner	873 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.				