

# Product Data Sheet

## Cromadex Liquid Coatings Cromadex AQ40 Topcoat One Pack Waterbased Air Drying Topcoat

**Product Description** Cromadex AQ40 is a one pack water based air drying topcoat with excellent gloss and colour retention adding value to the finished article.

Cromadex AQ40 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 3 years in a C2\* external environment when used with a suitable Cromadex primer. See Extra Life brochure for full details.

\* as determined in ISO12944

**Products and Ancillaries**  
AQ40 Topcoat  
AQ Equipment Cleaner (CX1A01)  
AQ Conversion Cleaner (CG1A01)

**Suitable Substrates and Preparation** Surfaces should be clean, dry and free from contamination.

<b>Steel</b>	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
<b>Aluminium &amp; Galvanised Steel</b>	Degrease with Cromadex 678 Spirit Wipe and abrade with P240 to remove surface oxide layer. 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>Plastics</b>	Direct adhesion to ABS & PVC. Other plastic substrates will require a suitable primer; consult your local Cromadex centre for appropriate primer. Clean with a suitable anti-static cleaner prior to coating.
<b>Existing Finish</b>	Degrease with Cromadex 678 Spirit Wipe and abrade existing finishes with P280.

**Application Details**

<b>Thinning Ratio</b>	Approx 5-10% with water (dependent on application equipment)	
<b>Spraying Viscosity</b>	45 – 70 seconds ISO Cup4 @ 20°C 19 – 23 seconds DIN 4 @ 20°C 25 – 30 seconds BS 4 Cup @ 20°C	
<b>Approved Thickness</b>	30 – 35 microns DFT	75 – 90 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 (50-60 psi)
<i>Suction Feed HVLP</i>	1.4 – 1.8 mm	0.7 bar (max) (10 psi)
<i>Pressure Pot HVLP</i>	1.0 – 1.4 mm	0.7 bar (max) (10 psi)
<i>Airless</i>	9 – 11 thou	120-140 bar (1800-2000 psi)
<i>Air Assisted Airless</i>	9 – 11 thou	100-120 bar (1500-1800 psi) 1 bar (15 psi) air
<b>Brush/Roller</b>	Not recommended	
<b>Electrostatic</b>	Automatic – Recommended Manual – Possible, contact equipment supplier for detailed information	

## Cromadex AQ40 Topcoat

Drying and Overcoating	Substrate Temperature	Drying Times		Overcoating Times	
		Touch Dry	Through Dry	Minimum	Maximum
	20°C	30 mins	4 hours	30 mins	7 days
	Note: Recoating without reaction can only be carried out when the surface is sufficiently cured. Times shown assume good air movement, acceptable humidity and at the recommended film thickness. If not overcoated within 7 days then prepare as existing finish.				
	<b>Force Drying</b>	Flash-off for 20 mins, then 60-80°C for 30 mins			
	<b>Stoving</b>	Not suitable			
	<b>Full Properties</b>	7 days if air dried at 20°C, or immediately following force drying			
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>	6 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>	40 % dependent on colour and gloss			
	<b>Colour</b>	Full range available including BS, RAL and special matches – all lead chromate free			
	<b>Gloss</b>	Full gloss (90% min) Eggshell (30%)	Semi gloss (60%) Matt (10%)		
	<b>Coverage</b>	13 m <sup>2</sup> /l @ 30 microns, assuming 100% transfer efficiency			
		<b>VOC</b>	<b>Specific Gravity</b>		
		<b>AQ40 Topcoat</b>	82.2 g/l (water removed) <small>(dependent on colour &amp; gloss)</small>	1.10 <small>(dependent on colour &amp; gloss)</small>	
	<b>CX1A01</b>	932 g/l	1.00		
	<b>CG1A01</b>	880 g/l	0.88		
Safety Precautions and Disclaimer	<b>Before using this product please refer to the Cromadex Material Safety Data Sheet.</b>				
	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.				