

## **Product Data Sheet**

Cromadex Liquid Coatings Cromadex V39 Primer Rail Primer (Refurbishment)

Product Description	Cromadex V39 is an alkyd primer formulated for refurbishment programmes in the rail industry. When used as a system with Cromadex V60 Two Pack Rail Topcoat it meets the following specifications.					
	BS 6853 1999 Annex B BS 476 Part 6 : 1989 Class 0 BS 476 Part 7 : 1997 Class 1					
Products and Ancillaries	V39 Primer 85-72 Thinner	05-46 Thinner				
Suitable Substrates and Preparation	Degreasing with Cromadex 678 Spirit Wipe is recommended and should be carried out after any abrasion of the surface					
	Steel	Degrease and abrade with P180. If necessary blast clean to remove millscale, minimum surface preparation SA2				
	Sound existing paint work	Dry sand using P320-P240				
Application Details	Thinning Ratio	7 parts V39 Primer 1 part 05-46/85-72 Thinner (dependent on application equipment)				
	Spraying Viscosity	45 – 70 seconds ISO Cup4 @ 20°C				
	Approved Thickness	35 – 45 microns DFT 75 – 100 microns WFT				
Application Details	Spray Gun Conventional Suction Feed HVLP Pressure Pot HVLP Airless Air Assisted Airless		I.8 mm 50 – 60 n 10 psi ( n 10 psi ( 5 thou 2500 ps u 1500 –	max)		
	Electrostatic	Resistivity will require adjustment. Please inform your local Cromadex Centre at time of purchase				
	Heated Methods	Reduce thinning ratios as required				
Drying and Overcoating	Substrate Temperature	Drying Touch Dry	Times Through Dry	Overcoat Minimum	ing Times Maximum	
	20°C	30 mins	6 hours	30 mins	Indefinite	
	Note: If primer is not overcoated within 14 days then abrade with either P240 or P320 and clean with Cromadex 678 Spirit Wipe					
	Force Drying	Flash-off for 10-15 mins, then 60°C for 45 mins				
	Full Properties	7 days				
	V39 Primer is overcoatable after the minimum drying time (above) with Cromadex V60 Rail Topcoat only.					



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 unop Cromadex centre	12 months in an unopened, original container from date of mixing at Cromadex centre			
	Pack Size	5 & 20 litres				
Physical Properties	Volume Solids	45.8 %				
	Colour	Off-white (nr RAL 9002)				
	Coverage	13 m²/l @ 35 microns	13 m <sup>2</sup> /l @ 35 microns, assuming 100% transfer efficiency			
	V39 Primer 05-46 Thinner 85-72 Thinner	<b>VOC</b> 470 g/l 870 g/l 870 g/l	<b>Specific Gravity</b> 1.27 0.87 0.87			
Safety Precautions and Disclaimer						

## **Cromadex V39 Primer**

It is the user's responsibility to check that this data sheet is current prior to using the product.

