

Product Data Sheet

Cromadex Liquid Coatings

Cromadex 750 Primer Two Pack Epoxy Primer

Product Description

Cromadex 750 is a two pack epoxy primer for use over a wide range of substrates. It contains zinc phosphate giving added corrosion resistance for greater durability.

The product can be air dried or stoved giving flexibility in your production line.

Cromadex 750 is available in white and grey as standard, it can also be tinted to ensure complete coverage even on difficult lead free colours.

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

750 Primer
750 Curing Agent
No 1 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
Aluminium & Galvanised Steel	Degrease and abrade with P240 to remove surface oxide layer. For even greater system performance apply Cromadex 903 Chromate-Free Etch Primer
Stainless Steel	Degrease and abrade with P180
GRP	Remove release coat, degrease and abrade with P280
Powder Coating	Degrease and abrade with P280
Concrete	Suitable for sound concrete aged for 3 months. For porous surfaces apply sealer coat thinned with 5% No 1 Thinner by brush or roller then one full un-thinned coat

Application Details

Mixing Ratio	5 parts 750 Primer 1 part 750 Curing Agent 1-2 parts No 1 Thinner (dependent on application equipment) Note: product should be mixed 10 minutes prior to application
Spraying Viscosity	45 – 70 seconds ISO Cup4 @ 20°C
Pot Life	When mixed 6 hours @ 20°C
Approved Thickness	25 – 35 microns DFT 40 – 60 microns WFT

Cromadex 750 Primer

Application Details	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>	11 – 15 thou	2,000 psi		
	<i>Air Assisted Airless</i>	11 – 13 thou			
	<i>Electrostatic</i>	Ready for use			
Drying and Overcoating	Substrate Temperature	Drying Times		Overcoating Times	
	20°C	Touch Dry	Through Dry	Minimum	Maximum
		60 mins	8 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 60-80°C for 30 mins			
	Stoving	Flash-off for 10-15 mins, then 120°C for 30 mins			
	Full Properties	14 days if air dried @ 20°C, or immediately after stoving			
	750 Primer is overcoatable after the minimum drying time of 30 minutes with all Cromadex General Industrial Topcoats.				
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 litres			
Physical Properties	Volume Solids	55 % mixed			
	Colour	White (nr RAL 9002), grey (nr RAL 7035) Tinted shades available – all lead chromate free			
	Coverage	18 m ² /l @ 30 microns (mixed), assuming 100% transfer efficiency			
		VOC	Specific Gravity		
		<i>750 Primer</i>	427 g/l	1.61	
	<i>750 Curing Agent</i>	269 g/l	0.94		
	<i>No 1 Thinner</i>	868 g/l	0.87		
Safety Precautions and Disclaimer	<p>Before using this product please refer to the Cromadex Material Safety Data Sheet.</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>				