



## 800 TOPCOAT

## Two Pack Non-Isocyanate Acrylic

### PRODUCT DATA SHEET

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| <b>Chemically resistant</b>                | - <b>Suitable for tough environments</b>                             |
| <b>Unique resin and pigment technology</b> | - <b>Enables a wide variety of applications and a durable finish</b> |
| <b>Fast drying</b>                         | - <b>Improved productivity</b>                                       |
| <b>Formulated without isocyanate</b>       | - <b>Helps reduce health and safety concerns</b>                     |
| <b>Part of Extra Life system</b>           | - <b>Proven performance</b>  |

<b>Product &amp; Ancillaries</b>	800 Topcoat 800 Curing Agent 25-03 Thinner No.6 Thinner	
<b>Suitable Substrates</b>	Suitably primed mild steel, aluminium, galvanised steel and stainless steel GRP Plastics Powder Coating	
<b>Surface Preparation</b>	Mild steel	Degrease 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 if required to increase film build)
	Stainless Steel	Use of Cromadex 903, 585, 750 or 850 primer is required
	GRP	Remove release coat, degrease and abrade with P280
	Plastics	Direct adhesion to ABS, Noryl, PU Foam (Rigid), HIPS, Acrylic, Polycarbonate, PVC & PU Foam (flexible). Clean with a suitable anti-Static cleaner prior to coating
	Powder Coating	Degrease and abrade with P280
<b>Mixing ratio (by volume)</b>	5 parts 800 Topcoat 1 part 800 Curing Agent 1-2 parts 25-03 Thinners (dependent on application equipment) Note 800 Clear Lacquer mixing ratio is 4:1 (base:curing agent)	

<b>Spraying viscosity</b>	45 - 70 seconds ISO Cup4 @ 20°C 25 - 30 seconds BS Cup4 @ 20°C		
<b>Pot life</b>	8 hours @ 20°C (dependant on colour)		
<b>Spraying equipment</b>	<i>Spray Gun</i>	<i>Fluid tip size</i>	<i>Working pressure</i>
	Conventional	1.4 - 1.8mm	3.5 - 4.2 bar
	Suction feed HVLP	1.4 - 1.8mm	0.7 bar (max)
	Pressure pot HVLP	1.0 - 1.4mm	0.7 bar (max)
	Airless	11 - 18 thou	
	Electrostatic	Resistivity will require adjustment. Please inform your local Cromadex Centre at time of purchase	
<b>Approved thickness</b>	25 - 35 microns DFT	70 - 80 microns WFT	
<b>Volume Solids</b>	46.9% (mixed, dependent on colour & gloss)		
<b>Drying times</b>	<b><u>Drying Times</u></b>		<b><u>Overcoating Times</u></b>
<b>Substrate temp</b>	<b>Touch Dry</b>	<b>Through Dry</b>	<b>Minimum      Maximum</b>
20°C	15 mins	4 hours	wet-on-wet      Indefinite
35°C	10 mins	3 hours	wet-on-wet      Indefinite
	Note : wet edge can be extended with use of No.6 Thinner		
<b>Force drying</b>	Flash-off for 10 - 15 mins, then 60 - 80°C for 30 mins		
<b>Stoving</b>	Flash-off for 10 - 15 mins, then 120°C for 30 mins		
<b>Full properties</b>	7 days if air dried @ 20°C, or immediately after stoving.		
<b>Coverage</b>	16m <sup>2</sup> /l @ 30 microns, assuming 100% transfer efficiency.		
<b>Shelf Life</b>	12 months in an unopened, original container from date of mixing at Cromadex centre Storage should be in accordance with the instructions in Section 7 of the relevant Material Safety Data Sheet.		
<b>Colour</b>	Full range available including BS, RAL, metallics, sparkles & special matches, all with lead chromate-free options		
<b>Gloss</b>	4 standard gloss levels Full gloss: 90% minimum      Semi gloss: 60% Eggshell: 30%      Matt: 10% Measured at 30-35 microns DFT & 60° reflectance A variance of +/-5% may be obtained dependant on application process		
<b>Properties</b>	<b>VOC</b>	<b>Specific Gravity</b>	
<b>800 Topcoat</b>	466 g/l	1.14	
	(dependent on colour & gloss)	(dependent on colour & gloss)	
<b>800 Curing Agent</b>	491 g/l	1.00	
<b>25-03 Thinner</b>	873 g/l	0.87	
<b>No. 6 Thinner</b>	870 g/l	0.87	

**Before using this product please refer to the Cromadex Material Safety Data Sheet.**

**Disclaimer :** 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.