



891 TOPCOAT *High Solids Two Pack Acrylic*

PRODUCT DATA SHEET

- High Solids Topcoat** = **Can be used as part of a VOC reduction programme**
- Part of Extra Life system** = **Proven performance**
- Superb level of full gloss** = **Enhances value of finished article**
- Large choice of colour** = **Can differentiate finish**
- Excellent UV resistance** = **Prolonged decorative performance**

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|----------------------------------|--|--|-------------------------|
| Product & Ancillaries | 891 Topcoat 891 Curing Agent 891 Thinner | | |
| Suitable Substrates | Suitably primed mild steel, aluminium, galvanised steel & stainless steel | | |
| Surface Preparation | 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 | Degrease and abrade with P240 to remove surface oxide layer. Apply Cromadex 903 chromate-free etch primer | |
| | Stainless steel | Use of Cromadex 903, 585, 750 or 850 primer is required | |
| Mixing ratio (by volume) | 5 parts 891 Topcoat 2 parts 891 Curing Agent 2 parts 891 Thinner (dependent on application equipment) | | |
| Spraying viscosity | 45 - 70 seconds ISO Cup4 @ 20°C 25 - 30 seconds BS Cup4 @ 20°C | | |
| Pot life | 1 - 2 hours @ 20°C | | |
| Spraying equipment | <i>Spray Gun</i> | <i>Fluid tip size</i> | <i>Working pressure</i> |
| | Conventional | 1.6 - 1.8mm | 50 - 60 psi |
| | Suction feed HVLP | 1.6mm | 10 psi (max) |
| | Pressure pot HVLP | 1.0 - 1.4mm | 10 psi (max) |
| | Airless | 9 - 13 thou | 2000 - 3000 psi |
| | Electrostatic | Resistivity will require adjustment. Please inform your local Cromadex Centre at time of purchase | |

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FOR PROFESSIONAL USE ONLY
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| Approved thickness | 40 - 60 microns DFT | 70 - 100 microns WFT |
| Volume Solids | 66.9% (mixed, dependent on colour) | |
| Drying times | <u>Drying Times</u> | |
| Substrate temp | Touch Dry | Through Dry |
| 20°C | 30 mins | 16 hours |
| Force drying | Flash-off for 10 - 20 mins, then 60°C for 45 mins | |
| Full properties | 7 days | |
| Overcoating Times | Minimum | Maximum |
| | 1 hour | Flat after 16 hours, overcoat after 24 hours |
| Coverage | 14m ² /l @ 40 microns, assuming 100% transfer efficiency. | |
| Shelf Life | 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. | |
| Colour | Full range available including BS, RAL, metallics, sparkles & special matches, all with lead chromate-free options | |
| Gloss | Full gloss: 90% minimum Measured at 30-35 microns DFT & 60° reflectance | |
| Properties | VOC | Specific Gravity |
| 891 Topcoat | 415 g/l | 1.22 |
| 891 Curing Agent | 207 g/l | 1.09 |
| 891 Thinner | 861 g/l | 0.88 |

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.