



222 TOPCOAT

Fast Air Drying Alkyd

PRODUCT DATA SHEET

- Fast touch dry time** - **Helps to improve productivity**
- Wide choice of colours** - **Can differentiate finish**
- Differing gloss levels** - **Choice of decorative appearance**
- Excellent covering power** - **Reduces application costs**
- Unique resin and pigment technology** - **Enables a wide variety of applications and a durable finish**

Product & Ancillaries	222 Topcoat 05-46 Thinner 85-72 Thinner Electrostatic Thinner		
Suitable Substrates	Suitably primed mild steel, aluminium, galvanised steel & stainless steel		
Surface Preparation	Mild steel	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	
	Aluminium & Galvanised steel	Apply Cromadex 903 chromate-free etch primer (then other Cromadex primer if required)	
	Stainless steel	Use of 903, 585, 750 or 850 primer is required	
Thinning ratio (by volume)	10 parts 222 Topcoat 1 part 05-46/85-72 Thinner (dependent on application equipment)		
Spraying viscosity	45 - 55 seconds ISO Cup4 @ 20°C 25 - 30 seconds BS Cup4 @ 20°C		
Spraying equipment	<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	1.8mm	0.7 bar (max)
	Pressure pot HVLP	1.0 - 1.4mm	0.7 bar (max)
	Airless	11 - 21 thou	
	Air Assisted Airless	11 - 15 thou	
	Electrostatic	Thin to equipment manufacturers recommended resistivity using Cromadex Electrostatic Thinner	
	Heated Methods	Reduce thinning ratios as required	

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Approved thickness	25 - 35 microns DFT	60 - 80 microns WFT																				
Volume Solids	40.1% (dependent on colour & gloss)																					
Drying times	<table border="0"> <tr> <td></td> <td colspan="2" style="text-align: center;"><u>Drying Times</u></td> <td colspan="2" style="text-align: center;"><u>Overcoating Times</u></td> </tr> <tr> <td style="text-align: center;">Substrate temp</td> <td style="text-align: center;">Touch Dry</td> <td style="text-align: center;">Through Dry</td> <td style="text-align: center;">Minimum</td> <td style="text-align: center;">Maximum</td> </tr> <tr> <td style="text-align: center;">20°C</td> <td style="text-align: center;">25 mins</td> <td style="text-align: center;">16 hours</td> <td style="text-align: center;">60 mins</td> <td style="text-align: center;">Indefinite</td> </tr> <tr> <td style="text-align: center;">35°C</td> <td style="text-align: center;">15 mins</td> <td style="text-align: center;">12 hours</td> <td style="text-align: center;">40 mins</td> <td style="text-align: center;">Indefinite</td> </tr> </table>			<u>Drying Times</u>		<u>Overcoating Times</u>		Substrate temp	Touch Dry	Through Dry	Minimum	Maximum	20°C	25 mins	16 hours	60 mins	Indefinite	35°C	15 mins	12 hours	40 mins	Indefinite
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	<p>Note: If topcoat is not overcoated within 14 days then abrade with either P240 or P320 and clean with Cromadex 678 Spirit Wipe</p>																					
Force drying	Flash-off for 10 - 15 mins, then 60 - 80°C for 30 mins Gloss levels will vary when force dried or if the recommended film thickness is not obtained																					
Stoving	Not recommended																					
Full properties	7 days																					
Coverage	16m ² /l @ 25 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	4 standard gloss levels plus intermediate gloss levels may be obtained on request 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																					
Properties	VOC	Specific Gravity																				
222 Topcoat	521 g/l (dependent on colour & gloss)	1.12 (dependent on colour & gloss)																				
05-46 Thinner	867 g/l	0.87																				
85-72 Thinner	870 g/l	0.87																				
Electrostatic Thinner	781 g/l	0.85																				

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.