



943 TOPCOAT

Acrylic Stoving

PRODUCT DATA SHEET

- Direct to metal adhesion** - **Can help to cut application costs**
- Good exterior durability** - **Suitable for many applications**
- Differing gloss levels** - **Choice of decorative finish**
- Wide choice of colours** - **Can differentiate finish**

Product & Ancillaries	943 Topcoat 05-46 Thinner No. 3 Thinner Electrostatic Thinner		
Suitable Substrates	Suitably primed mild steel, aluminium, galvanised steel & stainless steel		
Surface Preparation	Mild steel	Degrease with 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 to increase film build)	
	Stainless steel	Use of 903, 585, 750 or 850 primer is required	
Thinning ratio (by volume)	5 parts 943 Topcoat 1 part 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	1.4 - 1.8mm	0.7 bar (max)
	Pressure feed HVLP	1.0 - 1.4mm	0.7 bar (max)
	Airless	11 - 21 thou	
	Electrostatic	Thin to equipment manufacturers recommended resistivity using Cromadex Electrostatic Thinner	
	Disc or Bell	Resistivity will require adjustment. Please inform your local Cromadex Centre at time of purchase	
	Heated Methods	Reduce thinning ratios as required	

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Approved thickness	25-35 microns DFT	50 - 70 microns WFT															
Volume Solids	46.5% (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>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 colspan="2" style="text-align: center;">STOVING ONLY</td> <td colspan="2" style="text-align: center;">Not recommended</td> </tr> </table>			<u>Drying Times</u>		<u>Overcoating Times</u>		Substrate temp	Touch Dry	Through Dry	Minimum	Maximum	20°C	STOVING ONLY		Not recommended	
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20°C	STOVING ONLY		Not recommended														
Stoving	Flash-off for 10 - 15 mins, then stove at 120°C for 30 minutes - minimum 140°C for 30 minutes - optimum 160°C for 30 minutes - maximum																
Full properties	After stoving																
Coverage	19m 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 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															
943 Topcoat	475 g/l	1.12															
	(dependent on colour & gloss)	(dependent on colour & gloss)															
05-46 Thinner	867 g/l	0.87															
No. 3 Thinner	930 g/l	0.93															
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.