



Product information

4CR-Industry 41-100 AC 2K Primer

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Product description

High-quality 2K acrylic primer with active protection against corrosion, can be used as adhesion promoter, primer, filler and wet on wet filler. Excellent adhesion to steel, zinc substrates and aluminium. Recoatable with 4CR 1K and 2K paints.

Hardener

0407-2 AC Universal Hardener fast, 0407-3 AC Universal Hardener medium

Mixing ratio

Paint + hardener 7:1 by volume

Paint + hardener 10:1 by weight

Pot life

8 - 9 hours at 20 °C

Dilution

0505-2 AC Thinner fast, 0505-3 AC Thinner, 0505-4 AC Thinner slow, addition 5 - 15 %

Spraying viscosity 4 mm DIN

Gravity spray gun	20 - 30 s	Airless / Airmix	50 - 60 s
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Application method

Application method	Thinner	Pressure	Nozzle
Gravity spray gun	15 %	2 - 2,5 bar	1,5 - 1,8 mm
Airless / Airmix	5 %	100 - 120 bar	0,28 - 0,33 mm

Processing conditions

Ensure an adequate supply and exhaust air ventilation. Working temperature must be at least +10 °C. Max. air humidity 80 %.

Spraying operations

Spraying operations	DFT	Consumption
Gravity spray gun 2 - 3	80 - 100 µm	4,4 - 5,5 m ² /l
Airless / Airmix 1 - 2		3,4 - 4,2 m ² /kg

Drying

Object temperature 20 °C

Dust free after 25 - 30 minutes

Set to touch after 50 - 60 minutes

ready for assembly after 5 - 6 hours

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recoatable after 50 - 60 minutes

Object temperature 60 °C

ready for assembly after 30 minutes

recoatable after 30 minutes

Fully cured after 8 - 10 days (20 °C).

Technical specifications

Binder base: polyurethane acrylic system

Density DIN EN ISO 2811 (kg/l): 1,2 - 1,4

Solids content (% by volume): 46 - 47

Solids content (% by weight): 62 - 66

Delivery viscosity DIN 53211 4 mm (in s): 170 - 190

Gloss level ISO 2813 at 60° (GU): < 20 mat

Short-term heat resistance: 180 °C

Permanent heat resistance: 150 °C

VOC regulation

EU limit value: Category B/c 540 g/l. This product ready to use contains max. 540 g/l.

Features

Short drying time, excellent filling properties. electrostatic application possible, active corrosion protection (zinc-phosphate), adhesion to steel, zined substrates and aluminium.

Storage

At least 3 years in unopened original container

Substrate preparation

Remove oil, grease, rust, mill scale, rolling skins, as well as other substances impairing the function of the coating!

Attention: A direct adhesion cannot be taken as granted due to most different kinds of metals, alloys, metallic and conversion coatings and so on. The adhesion must therefore be tested on the original metal substrate.

steel:

blast to cleaning degree Sa 2½, remove blast residues and overcoat promptly

de-rust with hand and power tools to degree of cleanliness St 3

degrease with Anti-Silicone

zined substrates:

clean the surface with ammonia solution

sweep blast

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aluminium:

degrease with 4CR AC Thinner, sand thoroughly with sandpaper P 360/400 and clean subsequently with Anti-Silicone

Proposed coating structure

steel, zincd substrates:

priming coat: 41-100 AC 2K Primer with 40 - 50 µm dry film thickness

finishing coat: *72-166 AC 2K Topcoat RB glossy with 50 - 60 µm dry film thickness

steel, zincd substrates (to comply with a higher corrosivity categorie):

priming coat: 41-100 AC 2K Primer with 80 - 100 µm dry film thickness

finishing coat: *72-166 AC 2K Topcoat RB glossy with 50 - 60 µm dry film thickness

aluminium:

priming coat: 41-100 AC 2K Primer with 20 - 25 µm dry film thickness

finishing coat: *72-166 AC 2K Topcoat RB glossy with 50 - 60 µm dry film thickness

*Further 4CR finishing coats are available. Please contact your technical adviser or our application technicians.

Processing tips

For professional use only.

When using this product as adhesion promoter on hard aluminium, observe dry film thickness of 20 - 25 µm. In order to apply thicker layers (used as filler with a coat thickness of more than 60 µm), reduce the mentioned data referring to the addition of thinner by 5 % and use a larger nozzle (up to 2 mm). When using it as adhesion promoter (coat thickness 20 - 25 µm), increase the mentioned data referring to thinner addition by 10% and use a smaller nozzle (1,3 - 1,5 mm).

Coat thickness of more than 60 µm extent the drying time.

Cleaning of tools

Clean tools immediately after use with Nitro-Thinner.