



Product information

4CR-Industry 41-105 AC 2K Filler wet-on-wet

Site 2 / 4

Version 2 / April 2020

Object temperature 60 °C

0407-1 AC Universal Hardener fast
Ready for assembly after 20 minutes
Recoat after 5-10 minutes

0407-3 AC Universal Hardener medium
Ready for assembly after 30 minutes
Recoat after 10 - 15 minutes

Technical specifications

Binder base: polyurethane acrylic system
Density DIN EN ISO 2811 (kg/l): 1,4 - 1,6
Solids content (% by volume): 56 - 60
Solids content (% by weight): 72 - 77
Delivery viscosity DIN 53211 4 mm (in s): thixotropic
Gloss level ISO 2813 at 60° (GU): 20 - 30 silk-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

Electrostatic application possible, can quickly be overcoated, very good flow, excellent spray mist absorption, very good edge coverage and vertical stability, adhesion to steel and GRP.

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

zinc 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

GRP:

Clean (remove completely any mould release agents), if necessary, sand slightly and degrease with Anti-Silicone

Proposed coating structure

2-coat system

steel, GRP:

wet-in-wet filler: 41-105 AC 2K Filler wet-on-wet with 20 - 30 µm dry film thickness

finishing coat: *72-170 AC 2K HS Topcoat VOC glossy with 50 - 60 µm dry film thickness

3-coat system

steel, GRP:

wet-in-wet filler: 41-105 AC 2K Filler wet-on-wet with 20 - 30 µm dry film thickness

finishing coat: **74-120 BC Base Coat with 15 - 20 µm dry film thickness

clear coat: *720-210 2K HS Clearcoat 2:1 with 50 - 60 µm dry film thickness

zincd substrates, aluminium:

adhesion promoter: 439-115 2K Washprimer chromate-free yellow-green with 10 - 15 µm dry film thickness

wet-in-wet filler: 41-105 AC 2K Filler wet-on-wet with 20 - 30 µm dry film thickness

finishing coat: *72-170 AC 2K HS Topcoat VOC glossy with 50 - 60 µm dry film thickness

4-coat system

zincd substrates, aluminium:

adhesion promoter: 439-115 2K Washprimer chromate-free yellow-green with 10 - 15 µm dry film thickness

wet-in-wet filler: 41-105 AC 2K Filler wet-on-wet with 20 - 30 µm dry film thickness

finishing coat: **74-120 BC Base Coat with 15 - 20 µm dry film thickness

clear coat: *720-210 2K HS Clearcoat 2:1 with 50 - 60 µm dry film thickness

*Further 4CR finishing coats are available. Please contact your Sales or our Technical staff.

**When using 74-120 BC Base Coat as topcoat, allow 41-105 AC 2K Filler wet-on-wet to dry at least 30 - 45 minutes at 60 - 80 °C. After cooling, it's possible to apply the basecoat.

Processing tips

For professional use only.

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If required we also offer hardeners and cleaning agents that are suitable for 2-component mixing and dosing units. Please contact your Sales adviser or our application technicians.

Cleaning of tools

Clean tools immediately after use with Nitro-Thinner.