

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

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Product description

Especially for commercial vehicle construction developed wet-on-wet filler. This wet-on-wet filler can be overcoated already after approx. 15 minutes without loss of gloss. Can be used on truck box bodies, side panels, tank lorries, and so on.

Hardener

0407-1 AC Universal Hardener fast, 0407-3 AC Universal Hardener medium

Mixing ratio

Paint + hardener 4:1 by volume Paint + hardener 5:1 by weight

Pot life

4 - 5 hours at 20 °C with 0407-3 AC Universal Hardener medium

Dilution

0505-4 AC Thinner slow, addition 10 - 25 %

Spraying viscosity 4 mm DIN

Gravity spray gun 18 - 22 s Airless / Airmix 30 - 40 s

Application method

| Application method | Thinner | Pressure | Nozzle |
|--------------------|-----------|---------------|----------------|
| Gravity spray gun | 20 - 25 % | 1.7 - 2,0 bar | 1,2 - 1,5 mm |
| Airless / Airmix | 10 - 15 % | 100 - 120 bar | 0.23 - 0.28 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 | DFT | Consumption |
|-------------------------|------------|-------------------|
| Gravity spray gun 2 - 3 | 20 - 30 μm | 16,8 - 25,1 m²/l |
| Airless / Airmix 1 | | 12,5 - 18,7 m²/kg |

Drying

Object temperature 20 °C

0407-1 AC Universal Hardener fast Dust free after 5 - 10 minutes Set to touch after 1.5 - 2 h Recoatable after 20 - 30 minutes 0407-3 AC Universal Hardener medium Dust free after 10 - 15 minutes Set to touch after 3 - 4 hours Recoatable after 30 - 40 minutes



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Object temperature 60 °C

0407-1 AC Universal Hardener fast Ready for assembly after 20 minutes Recoatable after 5-10 minutes 0407-3 AC Universal Hardener medium Ready for assembly after 30 minutes Recoatable 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

zinced 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

zinced 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

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

Processing tips

For professional use only.

^{*}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.



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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.