Product information
4CR-Industry 42-140 2K HS Filler light-grey

 Version 2 / April 2020

Product description

42-140 2K HS Filler light-grey has very good filling properties and is very easy to sand. This filler can be used as high-build as well as compact filler. It is also suitable to fill partial areas without sinkage or visible marks in the outer rim.

Hardener

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

Mixing ratio

0407-1 AC Universal Hardener fast
Filler + hardener 4:1 by volume

Pot life

1 hour at 20 °C with 0407-2 AC Universal Hardener fast
1,5 - 2 hours at 20 °C with 0407-3 AC Universal Hardener medium

Dilution

0505-3 AC Thinner, addition 10 - 20 %

Spraying viscosity 4 mm DIN

As high-build filler 25 - 30 s as compact filler 18 - 22 s

Application method

Application method	Thinner	Pressure	Nozzle
As high-build filler			
Gravity spray gun	10 %	1.7 – 1.9 bar	1,6 - 1,8 mm
As compact filler			
Gravity spray gun	20 %	1.7 – 1.9 bar	1,3 - 1,6 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
As high-build filler 4 - 5	up to 300 µm	4,2 - 8,5 m²/l at 50 - 100 µm
As compact filler 2 - 3	50 - 100 µm	2,8 - 5,7 m²/kg at 50 - 100 µm

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Drying

Object temperature 20 °C

Sandable after 3 - 5 hours

Object temperature 60 °C

Sandable after 20 - 40 minutes

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

Technical specifications

Binder base: polyurethane acrylic system
Density DIN EN ISO 2811 (kg/l): 1,5 - 1,7
Solids content (% by volume): 49 - 52
Solids content (% by weight): 72 - 75
Delivery viscosity DIN 53211 4 mm (in s): Thixotropic
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. 500 g/l.

Features

Short drying time, excellent filling properties. very easy to sand.

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

Proposed coating

steel, aluminium, zinced substrates:
priming coat: *439-115 2K Washprimer chromate-free yellow-green with 10 - 15 µm dry film thickness
Filling coat: 42-140 2K HS Filler light-grey with 50 - 300 µm dry film thickness
finishing coat: *72-166 AC 2K Topcoat RB glossy with 50 - 60 µm dry film thickness

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

Processing tips

For professional use only.
Do not apply on thermoplastic substrates.
Remove not cured old paintworks and priming coats.
In case of one-layer topcoat use sanding paper P 400 for dry sanding. In case of a two-layer topcoat we recommend to use the sanding paper P 500/ 600 for dry sanding.
If required we also offer hardeners and cleaning agents that are suitable for 2-component mixing and dosing units. Please contact your Sales or our technical staff.

Cleaning of tools

Clean tools immediately after use with Nitro-Thinner.