

# Product information 4CR-Industry 43-110 KH Zincphosphate HB Primer

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### **Product description**

Synthetic high-build primer for steel substrates, with active corrosion protection (zinc-phosphate) and fastdrying. For interior and exterior use. Recoatable with 4CR 1K and 2K paints.

### Dilution

0540-460 Multi Thinner, 0451-375 Hardener/Thinner for synthetic resin paints, addition 0 - 15 %

### Pot life

2 days with 0451-375 Hardener/Thinner for synthetic resin paints

### Spraying viscosity 4 mm DIN

Gravity spray gun 30 - 35 s	Airless / Airmix	40 - 50 s
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### Application method

Application method	Thinner	Pressure	Nozzle
Roll and brush	0 %	-	-
Gravity spray gun	10 - 15 %	1.9 - 2,0 bar	1,3 - 1,8 mm
Airless / Airmix	0 - 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	DFT	Consumption
Gravity spray gun 2 - 3 Airless / Airmix 1 - 2	50 - 60 μm	9,1 - 10,9 m²/l 5,7 - 6,9 m²/kg

## Drying

### **Object temperature 20 °C**

Dust free after 15 - 20 minutes Set to touch after 45 - 60 minutes Ready for assembly after 4 - 5 hours Recoatable after 1 hour for 1K paints, 2 hours for 2K paints

### **Object temperature 60 °C**

Ready for assembly after 30 minutes



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## **Technical specifications**

Binder base: alkyd resin Density DIN EN ISO 2811 (kg/l): 1,5 - 1,6 Solids content (% by volume): 52 - 54 Solids content (% by weight): 72 - 75 Delivery viscosity DIN 53211 4 mm (in s): thixotropic Gloss level ISO 2813 at 60° (GU): 10 - 20 matt Short-term heat resistance: 150 °C Permanent heat resistance: 120 °C

# VOC regulation

EU limit value: Category B/c 500 g/l. This product contains max. 490 g/l.

## Features

short drying time, active corrosion protection (zinc phosphate), electrostatic application possible, high-build, excellent filling properties, high vertical stability, adhesion on steel.

## 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

## Proposed coating structure

steel:

priming coat: 43-110 KH Zincphosphate HB Primer with 50 - 60  $\mu$ m dry film thickness



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finishing coat: \*70-135 KH Topcoat Premium with 50 - 60 µm dry film thickness \*Further 4CR finishing coats are available. Please contact your Sales or our technical staff.

### **Processing tips**

For professional use only. Do not overcoat with high-solid 4CR 2K topcoats. Without top coating, the primed objects can be stored outside for approx. 5 days.

### **Cleaning of tools**

Clean tools immediately after use with Nitro-Thinner.