



Product information

4CR-Industry 435-110 PVB 1K Etch Primer

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Version 1 / February 2020

Product description

PVB 1K Etch Primer who can be used as primer or as primer filler, with active corrosion protection and excellent adhesion on steel, zinc substrates and aluminium. Recoatable with solvent- and waterborne 4CR 1k and 2K paints.

Dilution

0540-460 Multi Thinner, 0505-2 AC Thinner fast, 0505-3 AC Thinner, 0505-4 AC Thinner slow, addition 5 - 50 %

Spraying viscosity 4 mm DIN

Gravity spray gun 20 - 25 s

Airless / Airmix 30 - 40 s

Application method

Application method	Thinner	Pressure	Nozzle
Gravity spray gun	40 - 50 %	2 - 2,5 bar	1,3 - 1,6 mm
Airless / Airmix	5 - 10 %	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

Gravity spray gun 2 - 3
Airless / Airmix 1

DFT

20 - 30 µm

Consumption

10,1 - 15,1 m²/l
9 - 13,4 m²/kg

Drying

Object temperature 20 °C

Dust free after 15 - 20 minutes
Set to touch after 45 - 60 minutes
Ready for assembly after 1 hour
Recoatable after 1 hour

Object temperature 60 °C

Ready for assembly after 30 minutes

Fully cured after 2 - 3 days (20 °C).

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Technical specifications

Binder base: polyvinyl butyrale

Density DIN EN ISO 2811 (kg/l): 1,1 - 1,3

Solids content (% by volume): 27 - 30

Solids content (% by weight): 45 - 50

Delivery viscosity DIN 53211 4 mm (in s): 100 - 120

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

Short-term heat resistance: 150 °C

Permanent heat resistance: 120 °C

VOC regulation

EU limit value: Category B/c 780 g/l. This product contains max. 710 g/l.

Features

short drying time, active corrosion protection (zinc phosphate), electrostatic application possible, short-term heat exposure 150 °C, permanent heat exposure 120 °C, adhesion on steel, zincd 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

zincd substrates:

clean the surface with ammonia solution

sweep blast

aluminium:

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

Anti-Silicone

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Proposed coating

steel, zincd substrates, aluminium:

priming coat: 435-110 PVB 1K Etch Primer with 20 - 30 µm dry film thickness

finishing coat: *AC 2K Topcoat RB semi-gloss with 50 - 60 µm dry film thickness

when used as adhesion promoter

steel, zincd substrates, aluminium:

priming coat: 1 x 435-110 PVB 1K Etch Primer with 15 - 20 µm dry film thickness

finishing coat: *AC 2K Topcoat RB semi-gloss 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.

With a dry film thickness of at least 50 µm, the primed objects can be stored outside up to 3 months without topcoat.

Do not apply on thermoplastic substrates.

Do not recoat with products containing polyester.

Not suitable as adhesion promoter on hard aluminium panels (use instead 439-115 2K Washprimer chromate-free yellow-green).

If necessary, 435-110 PVB 1K Etch Primer can be also applied in combination with hardener 0451-380 Hardener WP.

The mixing ratio is: 435-110 PVB 1K Etch Primer + 0451-380 Hardener WP 2:1 by volume

This mixture is ready for use and there is no need to add any thinner.

Pot life: 12 h at 20 °C

Important note: When using von 435-110 PVB 1K Etch Primer in combination with 0451-380 Hardener WP, it is not possible to overcoat this surface with epoxy-based or water-based paint systems or with polyester paint materials.

Cleaning of tools

Clean tools immediately after use with Nitro-Thinner.

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