



## Product information

# 4CR-Industry 439-115 2K Washprimer chromate-free yellow-green

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### Product description

Acid-curing, chromate-free 2K primer designed especially for aluminium substrates providing active corrosion protection and excellent adhesion on iron, steel and galvanized substrates. It can also be used in a three-layer-application (Active-primer/ filler/ topcoat). Recoatable with 4CR 1K and 2K paints (Note: except for waterborne basecoats and epoxy coating systems).

### Hardener

0451-380 Hardener WP

### Mixing ratio

Paint + hardener 2:1 by volume or 1:1 by volume (for large surfaces)

### Pot life

12 hours at 20 °C

### Dilution

Ready-to-use after addition of hardener.

### Spraying viscosity 4 mm DIN

Gravity spray gun 16 - 18 s

### Application method

Application method	Thinner	Pressure	Nozzle
Gravity spray gun	-	1.7 - 2,0 bar	1,3 - 1,4 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 1 - 1,5

### DFT

10 - 15 µm

### Consumption

12,7 - 19,1 m<sup>2</sup>/l

13,6 - 20,4 m<sup>2</sup>/kg

### Drying

#### Object temperature 20 °C

Dust free after 4 - 6 minutes

Set to touch after 20 - 25 hours

recoatable after 30 min up to max. 8 hours

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### Technical specifications

Binder base: Special resins

Density DIN EN ISO 2811 (kg/l): 1,4 - 1,5

Solids content (% by volume): 44 - 45

Solids content (% by weight): 65 - 68

Delivery viscosity DIN 53211 4 mm (in s): Thixotropic

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

Short-term heat resistance: 150 °C

Permanent heat resistance: 120 °C

### VOC regulation

EU limit value: Category B/c 780 g/l. This product ready to use contains max. 704 g/l.

### Features

Active protection against corrosion (zinc phosphate), very good flow, very fast recoatability, adhesion on steel, zinc coated substrates and aluminium.

### Storage

At least 2 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:

de-rust with hand and power tools to degree of cleanliness St 3

degrease with Anti-Silicone

zinc coated 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

2-coat system

steel, zinc substrates, aluminium:

priming coat: 4CR-Industry 439-115 2K Washprimer chromate-free yellow-green with 10 - 15 µm dry film thickness

finishing coat: \*72-166 AC 2K Topcoat RB glossy with 50 - 60 µm dry film thickness

3-coat system

Steel, zinc 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

steel zinc 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.

### Processing tips

For professional use only.

Do not apply on thermoplastic substrates.

Do not overcoat with polyester-based products.

The substrate must be clean, dry and free from grease.

Remove non cured old paint works and priming coats.

Test beforehand the adhesion on stainless steel and difficult metals.

439-115 2K Washprimer chromate-free yellow-green must be overcoated within 8 hours.

Protect parts primed with 439-115 2K Washprimer chromate-free yellow-green from humidity.

Do not apply directly alkaline materials such as e.g. waterborne basecoats, 45-110 EP 2K Primer HB, 73-130 EP 2K Topcoat semi-gloss or 73-135 EP 2K Topcoat glossy on 439-115 2K Washprimer chromate-free yellow-green.

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Do not keep rests in iron containers.

### Cleaning of tools

Clean tools immediately after use with Nitro-Thinner.