



## 4CR-Industry 70-120 KH One-coat lacquer HB silk-mat/30

Version 1 / February 2020

Synthetic high-build one-coat paint with active protection against corrosion to apply thick coatings on steel parts, cast parts, containers, machines, chassis, switchboards and so on, which are made of steel. For interior and exterior use.

0540-460 Multi Thinner, 0451-375 Hardener/Thinner for synthetic resin paints, addition 0 - 20 %

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

Gravity spray gun 20 - 30 s	Airless / Airmix	50 - 60 s
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## Application method

Application method	Thinner	Pressure	Nozzle
Roll and brush	0 - 5 %	-	-
Gravity spray gun	15 - 20 %	1.9 - 2,0 bar	1,3 - 1,5 mm
Airless / Airmix	0 - 5 %	100 - 120 bar	0,28 - 0,4 mm

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	80 - 100 µm	4,9 - 6,1 m²/l
Airless / Airmix 1 - 2		3,8 - 4,7 m²/kg

## Drying

**Object temperature 20 °C**

Dust free after 50 - 60 minutes  
Set to touch after 3 - 4 hours  
Ready for assembly after 24 hours  
Recoat after 24 hours

**Object temperature 60 °C**

Ready for assembly after 90 minutes



## Product information

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

### Technical specifications

Binder base: alkyd resin

Density DIN EN ISO 2811 (kg/l): 1,2 - 1,4

Solids content (% by volume): 47 - 49

Solids content (% by weight): 63 - 68

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

Gloss level ISO 2813 at 60° (GU): 30 - 45 silk-mat

Short-term heat resistance: 150 °C

Permanent heat resistance: 120 °C

### VOC regulation

EU limit value: Category A/i 500 g/l. This product ready to use for roll and brush 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

single-coat system

steel

70-120 KH One-coat lacquer HB silk-mat with 80 - 100 µm dry film thickness

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## Product information

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two-coat system

steel:

priming coat: \*43-110 KH Zincphosphate HB Primer with 50 - 60 µm dry film thickness

finishing coat: 70-120 KH One-coat lacquer HB silk-mat with 80 - 100 µm dry film thickness

\*Further 4CR priming coats are available. Please contact your Sales or our Technical staff.

#### Processing tips

For professional use only.

Applying too thick layers may extend considerably the drying time.

Check colour before use.

#### Cleaning of tools

Clean tools immediately after use with Nitro-Thinner.