Product information
4CR-Industry 70-125 KH One-coat lacquer HB Premium silk-gloss/70

 Version 1 / February 2020

Product description

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, zinced steel and aluminium. For interior and exterior use. Also suitable for wood substrates. Low solvent content.

Dilution

0505-2 AC Thinner fast, 0505-3 AC Thinner, 0505-4 AC Thinner slow, addition 0 - 15 %

Spraying viscosity 4 mm DIN

Gravity spray gun 30 - 40 s Airless / Airmix 50 - 60 s

Application method	Thinner	Pressure	Nozzle
Roll and brush	0 - 5 %	-	-
Gravity spray gun	10 - 15 %	1.9 - 2,0 bar	1,7 - 2,5 mm
Airless / Airmix	0 - 5 %	100 - 120 bar	0,36 - 0,54 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	80 - 100 µm	6,4 - 8,0 m²/l
Airless / Airmix 1		4,4 - 5,5 m²/kg

Drying

Object temperature 20 °C

Dust free after 25 - 30 minutes
Set to touch after 3 - 4 hours
Fully cured after 8 - 10 days (20 °C).

Technical specifications

Binder base: modified alkyd resins
Density DIN EN ISO 2811 (kg/l): 1,3 - 1,5
Solids content (% by volume): 59 - 64
Solids content (% by weight): 73 - 79
Delivery viscosity DIN 53211 4 mm (in s): thixotropic
Gloss level ISO 2813 at 60° (GU): 60 - 80 silk-gloss
Short-term heat resistance: 150 °C

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Permanent heat resistance: 120 °C

VOC regulation

EU limit value: Category A/i 500 g/l. This product ready to use contains max. 490 g/l.

Features

Highly UV- and weather-resistant, can be applied in thick layers, active corrosion protection (zinc phosphate), resistant to patrol and diesel if exposed temporarily, adhesion on steel, zinced 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

zinced 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

Proposed coating

single-coat system
steel, zinced substrates, aluminium:
70-125 KH One-coat lacquer HB Premium silk-gloss with 80 - 100 µm dry film thickness

two-coat system
steel, zinced substrates:
priming coat: *45-110 EP 2K Primer HB with 50 - 60 µm dry film thickness
finishing coat: 70-125 KH One-coat lacquer HB Premium silk-gloss with 80 - 100 µm dry film thickness

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aluminium:
priming coat: *45-110 EP 2K Primer HB with 25 - 30 µm dry film thickness
finishing coat: 70-125 KH One-coat lacquer HB Premium silk-gloss 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.