Product information
4CR-Industry 72-110 AC 2K Topcoat semi-gloss/50

 Version 2 / April 2020

Product description

2K polyurethane acrylic paint with fast drying, for industrial coating of machines, components, constructions, agricultural machinery and construction vehicles which are made of steel, zinced steel and aluminium. For interior and exterior use.

Hardener

0407-3 AC Universal Hardener medium, 0407-1 AC Universal Hardener fast, 0409-352 AC Hardener glass

Mixing ratio

Paint + hardener 5:1 by volume
Paint + hardener 5:1 by weight

Pot life

6 - 8 hours at 20 °C

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 20 - 25 s		Airless / Airmix	25 - 35 s

Application method

Application method	Thinner	Pressure	Nozzle
Gravity spray gun	10 - 15 %	1,9 - 2,0 bar	1,2 - 1,3 mm
Airless / Airmix	0 - 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	DFT	Consumption
Gravity spray gun 2 - 4	50 - 60 µm	7,0 - 8,4 m²/l
Airless / Airmix 1		6,1 - 7,3 m²/kg

Drying

Object temperature 20 °C

Dust free after 20 - 25 minutes
Set to touch after 2 - 3 hours
Ready for assembly after 6 - 8 hours

Product information
4CR-Industry 72-110 AC 2K Topcoat semi-gloss/50

Object temperature 60 °C

Ready for assembly after 30 minutes

Fully cured after 5 - 6 days (20 °C).

Technical specifications

Binder base: polyurethane acrylic system
Density DIN EN ISO 2811 (kg/l): 1,2 - 1,4
Solids content (% by volume): 43 - 45
Solids content (% by weight): 59 - 64
Delivery viscosity DIN 53211 4 mm (in s): 150 - 160
Gloss level ISO 2813 at 60° (GU): 50 - 60 semi-gloss
Short-term heat resistance: 180 °C
Permanent heat resistance: 150 °C

VOC regulation

This product contains the following maximum VOC-values: undiluted: < 520 g/l of VOC

Features

Short drying time, electrostatic application possible, highly water-resistant, highly UV- and weather-resistant, adhesion to steel and zinced substrates, adhesion to aluminium: Gt 1

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

Product information
4CR-Industry 72-110 AC 2K Topcoat semi-gloss/50

aluminium:
degrease with 4CR AC Thinner, sand thoroughly with sandpaper P 360/400 and clean subsequently with Anti-Silicone

glass:
Before coating, it is indispensable to determine definitely the recoatable glass surface (e.g. by means of an appropriate measure device to determine the tin side of float glass) because it is generally impossible to coat the side which came in contact with the tin bath. We recommend testing the product beforehand on the original substrates and under real coating conditions.
Degrease with Anti-Silicone.

Proposed coating structure

single coat system
steel, zinced substrates, aluminium:
72-110 AC 2K Topcoat semi-gloss with 50 - 70 µm dry film thickness

glass:
72-110 AC 2K Topcoat semi-gloss incl. 0409-352 AC Hardener glass with 50 - 60 µm dry film thickness

2-Coat-System
steel, zinced substrates:
priming coat: *45-110 EP 2K Primer HB with 50 - 60 µm dry film thickness
finishing coat: 72-110 AC 2K Topcoat semi-gloss with 50 - 60 µm dry film thickness

aluminium:
priming coat: *45-110 EP 2K Primer HB with 25 - 30 µm dry film thickness
finishing coat: 72-110 AC 2K Topcoat semi-gloss with 50 - 60 µm dry film thickness

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

Processing tips

For professional use only.
Especially UV-resistant pigmentations (e.g. pastel shades for facades) are available on demand.
Check colour prior to application.
In case of application by means of an Airmix/Airless device, it is recommended testing beforehand the equipment for its suitability. If micro foam or blistering emerge during the application with an Airmix/Airless device, it is recommended adding more thinner. Furthermore, the film thickness should be kept as low as possible.

Cleaning of tools

Clean tools immediately after use with Nitro-Thinner.