



## Product information

# 4CR-Industry 72-136 AC 2K Topcoat Wood glossy/80

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Version 2 / April 2020

### Product description

2K polyurethane paint with fast drying, designed for high-quality finishes on furniture (bathroom, kitchen and office furniture). Can be applied by spray gun and curtain coater. Excellent adhesion to veneer, foil surfaces and solid wood.

### Hardener

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

### Mixing ratio

Paint + hardener 10:1 by weight

### Pot life

8 hours at 20 °C

### Dilution

0505-2 AC Thinner fast, 0505-3 AC Thinner, 0505-4 AC Thinner slow, addition 10 - 15 %

### Spraying viscosity 4 mm DIN

Gravity spray gun 20 - 25 s

Application method	Thinner	Pressure	Nozzle
Gravity spray gun	10 - 15 %	1,9 - 2,0 bar	1,2 - 1,3 mm
curtain coater	10 - 10 %	-	-

### 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	4,4 - 5,2 m <sup>2</sup> /l 4,2 - 5,1 m <sup>2</sup> /kg

### Drying

#### Object temperature 20 °C

Dust free after 15 - 20 minutes

Sandable after 50 - 60 minutes



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**Object temperature 60 °C**

Sandable after 30 minutes

Stackable after 2 hours at 20°C or after 30 minutes at 60°C. Fully cured after 2 - 3 days (at 20 °C).

### Technical specifications

Binder base: polyurethane-CAB-system

Density DIN EN ISO 2811 (kg/l): 1,0 - 1,2

Solids content (% by volume): 20 - 25

Solids content (% by weight): 37 - 42

Delivery viscosity DIN 53211 4 mm (in s): 75 - 80

Gloss level ISO 2813 at 60° (GU): > 80 glossy

Short-term heat resistance: 120 °C

Permanent heat resistance: 80 °C

### VOC regulation

This product contains the following maximum VOC-values: undiluted: < 660 g/l of VOC

### Features

Short drying time, chemical resistance: stress group 1B, highly water-resistant, highly UV- and weather-resistant, adheres on veneer, foil surfaces and solid wood.

### Storage

At least 3 years in unopened original container

### Substrate preparation

veneer surfaces (stained, unstained), foil surface, solid wood:

Pre-sand with grit P 180 –P 280 and remove dust thoroughly

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.

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### Proposed coating structure

single coat system

glass:

72-136 AC 2K Topcoat Wood glossy incl. 0409-352 AC Hardener glass with 50 - 60 µm dry film thickness

### 2-Coat-System

veneer surfaces (stained, unstained), foil surface, solid wood:

priming coat: 72-136 AC 2K Topcoat Wood glossy with 50 - 60 µm dry film thickness

finishing coat: 72-136 AC 2K Topcoat Wood glossy with 50 - 60 µm dry film thickness

### Processing tips

For professional use only.

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 thinner. Furthermore, the film thickness should be kept as low as possible.

### Cleaning of tools

Clean tools immediately after use with Nitro-Thinner.