



## Product information

# 4CR-Industry 72-144 AC 2K Topcoat High resistance silk-mat/30

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### Product description

2K polyurethane acrylic paint with excellent chemical and mechanical resistance, designed to coat commercial vehicles, façade elements as well as machines and constructions exposed to high strain.

### Hardener

0407-3 AC Universal Hardener medium, 0407-1 AC Universal Hardener fast, 0409-352 AC Hardener glass  
0408-3 AC HS Hardener medium, 0408-1 AC HS Hardener fast

0409-350 AC Hardener R+B

### Mixing ratio

With 0407-3 AC Universal Hardener medium, 0409-352 AC Hardener glass

Paint + hardener 2:1 by volume

Paint + hardener 3:1 by weight

With 0408-1 AC HS Hardener fast

Paint + hardener 3:1 by volume

Paint + hardener 4:1 by weight

With 0409-350 AC Hardener R+B

Paint + hardener 4:1 by volume

Paint + hardener 5:1 by weight

### Pot life

1 - 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 20 - 25 s

### Application method

Application method	Thinner	Pressure	Nozzle
Roll* and brush	0 - 5 %	-	-
Gravity spray gun	10 - 15 %	1,9 - 2,0 bar	1,2 - 1,3 mm
Airless / Airmix	10 - 15 %	100 - 120 bar	0,23 - 0,28 mm

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\* e.g. mohair, Supren, velour, Glattfilt, Roll sponge

### 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 2 - 4  
Airless / Airmix 1

#### DFT

50 - 60 µm

#### Consumption

6,2 - 7,5 m<sup>2</sup>/l  
5,6 - 6,7 m<sup>2</sup>/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

#### 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): 42 - 43  
Solids content (% by weight): 58 - 64  
Delivery viscosity DIN 53211 4 mm (in s): 140 - 160  
Gloss level ISO 2813 at 60° (GU): 20 - 30 silk-mat  
Short-term heat resistance: 180 °C  
Permanent heat resistance: 150 °C

### VOC regulation

This product contains the following maximum VOC-values: undiluted: < 560 g/l of VOC

### Features

Electrostatic application possible, highly water-resistant, highly UV- and weather-resistant, highly resistant to chemicals. highly resistant to solvents, scratch-resistant, excellent chemical and mechanical resistance.

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### 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

zinc 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

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

glass:

72-144 AC 2K Topcoat High resistance silk-mat incl. 0409-352 AC Hardener glass with 50 - 60 µm dry film thickness

2-Coat-System

steel, zinc substrates:

priming coat: \*45-110 EP 2K Primer HB with 50 - 60 µm dry film thickness

finishing coat: 72-144 AC 2K Topcoat High resistance silk-mat with 50 - 60 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: 72-144 AC 2K Topcoat High resistance silk-mat 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 thinner. Furthermore, the film thickness should be kept as low as possible.

For roller application, please consider generally the following hints:

- Before use, roll a new roller over the sticky side of a tape to remove fluff, hairs and so on.
- Soak new roller completely with paint before starting the application and roll out to the air out of the roller.
- Do not apply at direct sunlight or on heated substrates. Object and processing temperature should be between +10 °C and max. +25 °C.
- Apply only under dry weather conditions: no rain, dew or fog
- Move roller uniformly and not too fast, get rid of stubborn bubbles by slow rolling with low contact pressure.
- Avoid applying too thick layers in one pass
- Due to the system, this product is not suitable for application on large surfaces.

Depending on the hardener in use and on the processing condition, the gloss level may prove to be higher or lower. The mentioned data refer to the hardener 0407-3 AC Universal Hardener medium, 0409-352 AC Hardener glass.

### Cleaning of tools

Clean tools immediately after use with Nitro-Thinner.

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