



## Product information

# 4CR-Industry 72-150 AC 2K Topcoat High Coverage glossy/90

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### Product description

2K polyurethane acrylic paint optimal settings for Airmix and with excellent hiding power as well chemical and mechanical resistance, designed to coat commercial vehicles, façade elements as well as machines and constructions.

### 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

### 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 0408-3 AC HS Hardener medium

Paint + hardener 3:1 by volume

Paint + hardener 4:1 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 10 - 15 %

### Spraying viscosity 4 mm DIN

Gravity spray gun 20 - 25 s

Airless / Airmix 20 - 25 s

### Application method

Gravity spray gun

Airless / Airmix

### Thinner

10 - 15 %

10 - 15 %

### Pressure

1,9 - 2,0 bar

100 - 120 bar

### Nozzle

1,2 - 1,3 mm

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

Gravity spray gun 2 - 4

Airless / Airmix 1

### DFT

50 - 60 µm

### Consumption

6,5 - 7,8 m<sup>2</sup>/l

6,1 - 7,4 m<sup>2</sup>/kg

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### 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): 1,1 - 1,4

Solids content (% by volume): 44 - 45

Solids content (% by weight): 56 - 63

Delivery viscosity DIN 53211 4 mm (in s): 140 - 160

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

Short-term heat resistance: 180 °C

Permanent heat resistance: 150 °C

### VOC regulation

This product contains the following maximum VOC-values: undiluted: < 550 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.

### 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:

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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

## Proposed coating

steel, zinc substrates:

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

finishing coat: 72-150 AC 2K Topcoat High Coverage glossy 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: 72-150 AC 2K Topcoat High Coverage glossy 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. 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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