



Product information

4CR-Industry 72-160 AC 2K Topcoat RB silk-mat/30

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Version 2 / April 2020

Product description

2K polyurethane acrylic paint with long open time for the top-quality coating of facades, machines and constructions which are made of steel, zinc-coated steel and aluminium. Suitable for roller and brush application.

Hardener

0407-3 AC Universal Hardener medium, 0407-1 AC Universal Hardener fast
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
Paint + hardener 4:1 by volume
Paint + hardener 5:1 by weight

With 0408-1 AC HS Hardener fast
Paint + hardener 6:1 by volume
Paint + hardener 8:1 by weight

With 0409-350 AC Hardener R+B
Paint + hardener 8:1 by volume
Paint + hardener 10:1 by weight

Pot life

1,5 - 8 hours at 20 °C

Dilution

0505-2 AC Thinner fast, 0505-3 AC Thinner, 0505-4 AC Thinner slow, addition 0 - 20 %

Spraying viscosity 4 mm DIN

Gravity spray gun 20 - 25 s

Airless / Airmix 30 - 40 s

Application method

Application method	Thinner	Pressure	Nozzle
With 0409-350 AC Hardener R+B			
Roll* and brush	0 - 5 %	-	-
With 0407-3 AC Universal Hardener medium, 0408-1 AC HS Hardener fast			
Gravity spray gun	15 - 20 %	1,9 - 2,0 bar	1,2 - 1,3 mm
Airless / Airmix	0 - 10 %	100 - 120 bar	0,23 - 0,28 mm

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With 0408-1 AC HS Hardener fast (as fine structure paint)

Gravity spray gun	0 - 5 %	2 - 2,2 bar	1,5 - 2,0 mm
Airless / Airmix	0 - 5 %	100 - 120 bar	0,23 - 0,28 mm

* e.g. mohair, nap, velour, Glattfilt, Rolloplan, foam paint roller;

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	8,2 - 9,8 m ² /l
Airless / Airmix 1		6,1 - 7,3 m ² /kg

Drying

Object temperature 20 °C

With 0409-350 AC Hardener R+B

Dust free after 1,5 - 2 hours
Set to touch after 8 - 10 hours
Ready for assembly after 24 hours

With 0407-3 AC Universal Hardener medium,
0408-1 AC HS Hardener fast
Dust free after 15 - 45 minutes
Set to touch after 2 - 4 hours
Ready for assembly after 12 - 16 hours

Object temperature 60 °C

Ready for assembly after 1 hour

Ready for assembly after 30 - 45 minutes

Fully cured after 5 - 6 days (20 °C).

Technical specifications

Binder base: polyurethane acrylic system
Density DIN EN ISO 2811 (kg/l): 1,4 - 1,5
Solids content (% by volume): 54 - 59
Solids content (% by weight): 71 - 76
Delivery viscosity DIN 53211 4 mm (in s): Thixotropic
Gloss level ISO 2813 at 60° (GU): 20 - 30 silk-mat
Short-term heat resistance: 180 °C
Permanent heat resistance: 150 °C

VOC regulation

EU limit value: Category A/j 500 g/l

This product with 0409-350 AC Hardener R+B, ready to use to roll and brush contains max. 400 g/l.

This product with 0407-3 AC Universal Hardener medium, ready to use to spray contains max. 500 g/l.

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This product with 0408-2 AC HS Hardener fast, ready to use to spray contains max. 420 g/l.

Features

Long open time, high-build coating, electrostatic application possible, highly resistant to water, highly UV- and weather-resistant, adhesion on steel and zinc substrates, adhesion on 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

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 structure

single coat system

steel, zinc substrates, aluminium:

72-160 AC 2K Topcoat RB silk-mat with 60 - 70 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: 72-160 AC 2K Topcoat RB silk-mat with 50 - 60 µm dry film thickness

aluminium:

priming coat: *45-110 EP 2K Primer HB with 25 - 30 µm dry film thickness

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finishing coat: 72-160 AC 2K Topcoat RB 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 more thinner. Furthermore, the film thickness should be kept as low as possible.

72-160 AC 2K Topcoat RB silk-mat can also be applied on mineral substrates. Please observe technical data sheet 72-160 AC 2K Topcoat RB silk-mat Floorcoat to get more information about application and properties. 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.

Cleaning of tools

Clean tools immediately after use with Nitro-Thinner.

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