



## Product information

# 4CR-Industry 72-180 AC 2K HS Chassis Paint semi-gloss/50

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### Product description

AC 2K HS high-build chassis paint with active corrosion protection, designed for high-quality coating of chassis of commercial vehicles and trucks which are made of steel, zined steel and aluminium.

### 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 | 60 - 100 µm | 5 - 8,3 m <sup>2</sup> /l    |
| Airless / Airmix 1      |             | 3,7 - 6,2 m <sup>2</sup> /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 - 1,6

Solids content (% by volume): 54 - 59

Solids content (% by weight): 71 - 77

Delivery viscosity DIN 53211 4 mm (in s): Thixotropic

Gloss level ISO 2813 at 60° (GU): 50 - 60 semi-gloss

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.

This product with 0408-1 AC HS Hardener fast, ready to use to spray contains max. 420 g/l.

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### Features

High-build application, active corrosion protection (zinc phosphate), electrostatic application possible, highly water-resistant, highly UV- and weather-resistant, adhesion on steel, zined substrates and aluminium.

### 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

zined 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

single coat system

steel, zined substrates, aluminium:

72-180 AC 2K HS Chassis Paint semi-gloss with 60 - 100 µm dry film thickness

2-coat system

steel, zined substrates:

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

finishing coat: 72-180 AC 2K HS Chassis Paint semi-gloss with 50 - 60 µm dry film thickness

aluminium:

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

finishing coat: 72-180 AC 2K HS Chassis Paint 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.

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 0408-2 AC HS Hardener fast.

### Cleaning of tools

Clean tools immediately after use with Nitro-Thinner.