



Product information

4CR-Industry 72-185 AC 2K Structure Paint silk-gloss/70

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Product description

2K acrylic polyurethane structure paint with high UV- and weather-resistance, designed for industrial coating of machines, components, constructions, steel lockers and tools.

Hardener

0409-351 2K Hardener structure

Mixing ratio

Paint + hardener 4:1 by volume

Paint + hardener 5:1 by weight

Pot life

1 - 2 hours at 20 °C

Dilution

Ready for use after adding hardener, if necessary thin with 0505-2 AC Thinner fast, 0505-3 AC Thinner, 0505-4 AC Thinner slow.

Spraying viscosity 4 mm DIN

Gravity spray gun thixotropic

Airless / Airmix thixotropic

Application method	Thinner	Pressure	Nozzle
Gravity spray gun	0 %	1,6 - 2,0 bar	1,8 - 3,0 mm
Airless / Airmix	0 %	100 - 120 bar	0,41 - 0,54 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	DFT	Consumption
Gravity spray gun 2 - 4	50 - 70 µm	7,8 - 10,9 m ² /l
Airless / Airmix 1		6,4 - 8,9 m ² /kg

Drying

Object temperature 20 °C

Dust free after 25 - 30 minutes

Set to touch after 5 - 6 hours

Ready for assembly after 24 hours

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Object temperature 60 °C

Ready for assembly after 30 minutes

Fully cured after 5 - 6 days (20 °C).

Characteristics

Binder base: polyurethane acrylic system

Density DIN EN ISO 2811 (kg/l): 11,2 - 1,4

Solids content (% by volume): 50 - 53

Solids content (% by weight): 56 - 71

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

Gloss level ISO 2813 at 60° (GU): 70 silk-gloss*

Short-term heat resistance: 180 °C

Permanent heat resistance: 150 °C

VOC regulation

EU limit value: Category A/j 500 g/l and B/e 840 g/l. This product ready to use contains max. 430 g/l.

Features

Free from silicone, electrostatic application possible, highly UV- and weather-resistant, very good resistance to water, highly resistant to solvents, fuels and oils, adhesion on steel, adhesion on zinc coated substrates: Gt 0 - 1, adhesion on aluminium: Gt 2.

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 coated substrates:

clean the surface with ammonia solution

sweep blast

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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, zincd substrates, aluminium:

72-185 AC 2K Structure Paint silk-gloss with 60 - 70 µm dry film thickness

2-coat system

steel, zincd substrates:

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

finishing coat: 72-185 AC 2K Structure Paint silk-gloss with 50 - 70 µm dry film thickness

aluminium:

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

finishing coat: 72-185 AC 2K Structure Paint silk-gloss with 50 - 70 µm dry film thickness

**Further 4CR priming coats are available. Please contact your Sales or our Technical staff.

Processing tips

*due to the special surface, a measurement according to DIN EN ISO 2813 is inappropriate!

For professional use only.

Especially UV-resistant pigmentations (e.g. pastel shades for facades) are available on demand.

Check colour prior to application.

Spray distance and pressure change the texture:

low pressure = rough texture

large distance = rough texture

high pressure = fine texture

small distance = fine texture

Cleaning of tools

Clean tools immediately after use with Nitro-Thinner.