



Product information

4CR-Industry 720-210 2K HS Clearcoat 2:1

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Product description

Clear coat based on high quality acrylic resins designed to give good protection to ultra-violet light.

Hardener

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

Mixing ratio

Paint + hardener 2:1 by volume

Pot life

1 - 2 hours at 20 °C

Dilution

0505-3 AC Thinner, 0505-4 AC Thinner slow, addition 10 %

Spraying viscosity 4 mm DIN

Gravity spray gun 18 - 20 s

Application method

Application method	Thinner	Pressure	Nozzle
Gravity spray gun	10 %	1.9 - 2,0 bar	1,2 - 1,3 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

DFT

40 - 50 µm

Consumption

7,3 - 9,2 m²/l

7,4 - 9,3 m²/kg

Drying

Object temperature 20 °C

Dust free after 25 - 30 minutes

Set to touch after 10 - 12 hours

Ready for assembly after 24 hours

Object temperature 60 °C

Dust free after 3 - 5 minutes

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Set to touch after 20 - 30 minutes

Ready for assembly after 1 hour

Fully cured after 5 - 6 days (20 °C).

Technical specifications

Binder base: acrylic system

Density DIN EN ISO 2811 (kg/l): 0,9 - 1,1

Solids content (% by volume): 41 - 43

Solids content (% by weight): 48 - 50

Delivery viscosity DIN 53211 4 mm (in s): 90 - 100

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 UV- and weather-resistant, highly resistant to chemicals. highly resistant to solvents, 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:

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

zincd 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

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

single coat system

glass:

720-210 2K HS Clearcoat 2:1 incl. 0409-352 AC Hardener glass with 40 - 50 µm dry film thickness

3-coat system

steel, zincd substrates:

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

basecoat: 74-120 BC Base Coat COB with 15 - 20 µm dry film thickness

clearcoat: 720-210 2K HS Clearcoat 2:1 with 40 - 50 µm dry film thickness

aluminium:

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

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

Processing tips

For professional use only.

Cleaning of tools

Clean tools immediately after use with Nitro-Thinner.

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