



Product information

4CR-Industry 73-135 EP 2K Topcoat glossy/90

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Version 1 / February 2020

Product description

EP 2K Topcoat with excellent resistance to chemical and mechanical strains, designed to coat steel, zinc-coated substrates, aluminium, GRP and mineral substrates.

Hardener

0451-355 EP Hardener fast, 0451-360 EP Hardener medium

Mixing ratio

Paint + hardener 2:1 by volume

Paint + hardener 2:1 by weight

Pot life

6 - 8 hours at 20 °C

Dilution

0530-440 EP Thinner, addition 5 - 45 %

Spraying viscosity 4 mm DIN

Gravity spray gun 20 - 30 s

Airless / Airmix 30 - 40 s

Application method	Thinner	Pressure	Nozzle
Roll and brush*	5 - 10 %	-	-
Gravity spray gun	40 - 45 %	1.9 - 2,0 bar	1,2 - 1,3 mm
Airless / Airmix	20 - 25 %	100 - 120 bar	0,23 - 0,28 mm

*suitable : lacquer roller ; unsuitable: lambskin roller

Processing conditions

Ensure an adequate supply and exhaust air ventilation. Working temperature must be at least +10 °C. Max. air humidity 80 %.

Recommendation: at temperatures between +10 and +15°C use 0451-355 EP Hardener fast, at temperatures above +15°C use 0451-360 EP Hardener medium.

Spraying operations	DFT	Consumption
Gravity spray gun 2 - 4	50 - 60 µm	8,2 - 9,8 m²/l
Airless / Airmix 1		7,3 - 8,8 m²/kg



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Drying

Object temperature 20 °C

Dust free after 50 - 60 minutes

Set to touch after 8 - 10 hours

Ready for assembly after 48 hours

Recoat after 1 hour

Object temperature 60 °C

Ready for assembly after 60 minutes

When drying for more than 24 h, intermediate sanding is necessary.

Characteristics

Binder base: epoxy resin

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

Solids content (% by volume): 43 - 45

Solids content (% by weight): 59 - 64

Delivery viscosity DIN 53211 4 mm (in s): 70 - 80

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

Short-term heat resistance: 180 °C

Permanent heat resistance: 150 °C

VOC regulation

EU limit value: Category A/j 500 g/l. This product, ready to use to roll and brush contains max. 500 g/l.

Features

excellent resistance to chemical and mechanical strains, highly abrasion resistant, adapted to fork lift traffic, electrostatic application possible, adhesion on steel, zinc substrates, aluminium, GRP and concrete

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

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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

GRP:
clean (remove completely any mould release agents), if necessary, sand slightly and degrease with Anti-Silicone

Proposed coating structure

single coat system
steel, zinc substrates, aluminium, GRP:
73-135 EP 2K Topcoat glossy with 80 - 100 µm dry film thickness

steel, zinc substrates:
priming coat: *45-110 EP 2K Primer HB with 50 - 60 µm dry film thickness
finishing coat: 73-135 EP 2K Topcoat 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: 73-135 EP 2K Topcoat 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.
In case of application by means of an Airmix/Airless device, it is recommended testing beforehand the equipment for its suitability.
Check colour prior to application.
Also suitable for coating floors in garages and warehouses. Learn more about application and product properties in technical data sheet 73-135 EP 2K Topcoat glossy Floorcoat.

Cleaning of tools

Clean tools immediately after use with 0530-440 EP Thinner.

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