



Product information

4CR-Industry 74-120 BC Base Coat COB

Site 1 / 3

Version 1 / February 2020

Product description

Solvent-based base coat which can overcoated with 4CR 2K-clearcoat generates a high-gloss weather-resistant finish, especially developed for industrial use.

Dilution

0510-3 BC Thinner, addition 50 %

Spraying viscosity 4 mm DIN

Gravity spray gun 16 - 18 s

Application method

Application method	Thinner	Pressure	Nozzle
Gravity spray gun	50 %	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	DFT	Consumption
Gravity spray gun 2 - 3	15 - 20 µm	10,4 - 13,9 m ² /l 10 - 13,7 m ² /kg

Drying

Object temperature 20 °C

Recoat after 10 - 15 minutes

Technical specifications

Binder base: physically drying, special resins
Density DIN EN ISO 2811 (kg/l): 1,0 - 1,2
Solids content (% by volume): 15 - 20
Solids content (% by weight): 31 - 37
Delivery viscosity DIN 53211 4 mm (in s): 110 - 140
Gloss level ISO 2813 at 60° (GU): -
Short-term heat resistance: 180 °C
Permanent heat resistance: 150 °C

VOC regulation

This product contains the following maximum VOC-values: undiluted: < 680 g/l of VOC

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Features

Short drying time, excellent covering power, brilliant effects, electrostatic application possible, high UV and weather resistance in combination with 4CR 2K clearcoats.

Storage

At least 2 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

3-coat system

steel, zinc substrates:

priming coat: *45-110 EP 2K Primer HB with 50 - 60 µm dry film thickness
basecoat: 74-120 BC Base Coat COB with 15 - 20 µm dry film thickness
clearcoat: *710-200 2K MS Clearcoat 2:1 with 50 - 60 µm dry film thickness

aluminium:

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: *710-200 2K MS Clearcoat 2:1 with 50 - 60 µm dry film thickness

*Further 4CR priming and clear coats are available. Please contact your technical adviser or our application technicians.

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Processing tips

For professional use only.

74-120 BC Base Coat COB must be stirred thoroughly (at least for 2 minutes), immediately after tinting and before applying. In doing so, it's recommended mixing mechanically by means of a stirrer or shaker.

Apply 74-120 BC Base Coat COB evenly and thin, levelling layers. Don't apply too wet.

Flash-off time between coats is about 3-5 minutes.

Special substrate colours are prescribed in formulations of 4CR Mix System.

Note: 74-120 BC Base Coat COB is NOT meant for car refinishing according to Directive 2004/42/EC.

Check colour shade prior to application.

Cleaning of tools

Clean tools immediately after use with Nitro-Thinner.