



## Product information

# 4CR-Industry 760-220 2K UHS Clearcoat VOC 2:1

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### Product description

VOC-compliant High-Solid acrylic clearcoat with brilliant finish and optimal flow on solvent-based or water-based basecoats. Can be polished immediately after forced drying. Also suitable as protective coating for neon colours (fluorescent colours). Excellent drying properties. Just add a small quantity of thinner and the clearcoat is ready to be applied.

### Hardener

0408-3 AC HS Hardener Standard  
0408-1 AC HS Hardener fast  
0409-352 AC Hardener glass

### Mixing ratio

With 0408-1 AC HS Hardener fast  
Paint + hardener 2:1 by volume

0408-3 AC HS Hardener medium

With 0409-352 AC Hardener glass  
Paint + hardener 2:1,5 by volume

### Pot life

1 - 2,5 hours at 20 °C

### Dilution

0505-3 AC Thinner, 0505-4 AC Thinner slow, addition 0 - 5 %

### Spraying viscosity 4 mm DIN

Gravity spray gun 18 - 20 s

### Application method

Application method	Thinner	Pressure	Nozzle
Gravity spray gun	0 - 5 %	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

Spraying operations	DFT	Consumption
Gravity spray gun 1,5	50 - 60 µm	10,3 - 12,4 m <sup>2</sup> /l 10,2 - 12,2 m <sup>2</sup> /kg

Apply a light continuous spray coat (½) followed by 1 full spray coat.

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### Drying

#### Object temperature 20 °C

Dust free after 25 - 35 minutes  
Set to touch after 12 hours  
Ready for assembly after 24 hours

#### Object temperature 60 °C

Dust free after 5 - 7 minutes  
Set to touch after 20- 30 minutes  
Ready for assembly after 2 hours

Fully cured after 6 - 7 days (20 °C).

### Technical specifications

Binder base: acrylic system  
Density DIN EN ISO 2811 (kg/l): 0,9 - 1,1  
Solids content (% by volume): 68 - 70  
Solids content (% by weight): 73 - 75  
Delivery viscosity DIN 53211 4 mm (in s): 33 - 38  
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 for this product (category B/d): 420 g/l. This product contains max. 420 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!

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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

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 structure

single coat system

glass:

760-220 2K UHS Clearcoat VOC 2:1 incl. 0409-352 AC Hardener glass with 50 - 60 µm dry film thickness

3-coat system

steel, zincd substrates:

priming coat: \*45-110 EP 2K Primer HB with 25 - 40 µm dry film thickness

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

clearcoat: 760-220 2K UHS Clearcoat VOC 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: 760-220 2K UHS Clearcoat VOC 2:1 with 50 - 60 µm dry film thickness

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

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### Processing tips

For professional use only.

In order to assure a perfect curing we recommend forced drying.

### Cleaning of tools

Clean tools immediately after use with Nitro-Thinner.