



Art.-No.: 6.4205.3500

4205

2K HS-Primer 4:1 dark-grey

Characteristics

4CR 2K HS-Primer can be used as

- a) Compact filler or
 - b) For high thickness coatings
- Spot-repairs can be carried out without any inconvenience.

- high filling power
- fast drying
- excellent sanding ability
- high solid content (HS quality!)

V.O.C. Value

EC limiting value for the product (cat. B/c): 540 g/l (2007)

This product contains max. 500 g/l VOC [4,17 lbs/gal]

Tech Tip

When used as a pre-paint, up to 25% 4CR 7050 2K UHS-AC-Top Coat can be mixed into the filler.

Thin to about 15 s 4 mm DIN viscosity and after approx. 15 min. wet-in-wet overcoating.

Application

Working conditions from +10°C and up to 75% relative air humidity.

On bare substrate, the preliminary application of an adhesion promoter (for ex. 4CR 4100 or 4CR 4400) is essential. Steel or iron areas smaller as the palm of the hand may be directly overcoated.

Air / Flowjar - Spray gun:

Spraying pressure: 1,7 - 1,9 bar

Spraying nozzle: 1.3 - 1.9 mm

Spraying operations: 1 - 3

wet'on'wet application: 4:1 + 25% Thinner

Air / Flowjar - Spray gun:

Spraying pressure: 1,7 - 2,0 bar

Spraying nozzle: 1.2 - 1.3 mm

Spraying operations: 1 Thin closed coat

Airless / Airmix:

Spraying pressure: 120 - 150 bar

Spraying nozzle: 0,33 mm

Spraying operations: 1 - 2

Drying:

Metal temp. 20°C: after approx. 3 - 5 h

Metal temp. 60°C: after approx. 30 - 40 min.

sandable (dry flat with sanding paper P 400 by 1-coat finishing coating. When using for two pack top coats, sanding with sanding paper P 500 dry is recommended)





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Technical Data

Coat thickness / dry film	a) 50 - 80 µm b) - 300 µm
Pot life	approx. 1 h with 0407 extra fast, approx. 2 h with 0407 fast
Spraying viscosity 20°C	a) 25 - 30 s 4 mm DIN, b) no thinner
Hardener	0407
Mixing ratio	4 : 1 by volume
Consumption	5 - 6 m ² /l
Colour	dark grey (approx. RAL 7011)
Curing time / Flash off time	approx. 10 - 15 min. before force drying
Thinner	0505, a) approx. 5- 25% b) without dilution

Storage and Transportation

Keep dry an frost-protected.
At least 3 years when stored in a tightly closed original container.