



Art.-No.: 6.4280.1000
6.4280.4000

4280

2K Premium HS-Filler 4:1

Characteristics

Quick drying sanding filler

can also be applied wet-on-wet.

Universal adhesion on iron, steel, aluminum, galvanized substrates and plastics (eg PP-EPDM (PP-EPDM test for adhesion!), ABS, PC, ABS-PC, PMMA, PU, PVC, GRP).

Excellent sandability.

V.O.C. Value

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

This product contains max. 533 g/l VOC [4,45 lbs/gal]

Tech Tip

Sand aluminium with P220, steel and galvanized surfaces with P120.

Preclean all surfaces with 4CR silicone remover (galvanized surfaces clean with alkaline cleaner).

Due to the many different plastics, an adhesion test in advance is always recommended.

Application

Working conditions from +10°C and up to 80% relative air humidity.

Air / Flowjar - Spray gun

Spraying pressure: 1,6 - 1,9 bar

Spraying nozzle: 1,2 - 1,8 mm

Spraying coats: 1 - 3

Wet'on'wet application

Spray pressure 1,7- 2,0 bar

Spray nozzle: 1,2- 1,3mm

Spraying: 1 thin closed coat, flash off time around 15min at 20°C

Flash-off time:

5 - 8 min. between the coats, 10 - 15 min. before oven drying.

Drying:

Metal temperature 20°C: sandable after approx 3 - 5 h

Metal temperature 60°C: sandable after 30 - 40 min.

Drying with wet-on-wet application:

Metal temperature 20°C: paintable after 15 - 20 min.





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Mixing ratio

4 : 1 by volume (with 4CR 0407)

6 : 1 by volume (with 4CR 0408)

Thinner

Addition as sanding filler: Nozzle 1.6-1.8mm

4:1 + 00% - 05% 4CR 0505 (with 4CR 0407)

6:1 + 05% - 10% 4CR 0505 (with 4CR 0408)

Addition as wet-on-wet filler: Nozzle 1.2-1.3mm

4:1 + 20% - 30% 4CR 0505 (with 4CR 0407)

6:1 + 25% - 30% 4CR 0505 (with 4CR 0408)

Addition as plastic filler: Nozzle 1.3mm

4:1 + 20% - 30% 4CR 0505 (with 4CR 0407)

6:1 + 25% - 30% 4CR 0505 (with 4CR 0408)

Spraying viscosity 20°C

Sanding filler: 25 - 35 s 4 mm DIN

Wet-on-wet filler: 15 - 20 s 4 mm DIN

Plastic filler: 15 - 20 s 4 mm DIN

Coat thickness / dry film

Sanding filler: 60 - 250 µm

Wet-on-wet filler: 30 - 60 µm

Plastic filler: 30 - 60 µm

Technical Data

Colour black

Pot life 1 h

Consumption 5 - 7 m²/l (at 45 microns coat thickness)

Storage and Transportation

Keep dry and frost-protected.

At least 3 years when stored in a tightly closed original container.