Art.-No.: 6.4200.1000
6.4200.3500
6.4200.4000

4200

2K HS-Primer 4:1 light-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 4370) is essential.
Steel or iron areas smaller as the palm of the hand may be directly overcoated.

Air / Flowjar - Spray gun:
Spraying pressure: 2 - 2.5 bar
Spraying nozzle: 1.5 - 1.8 mm
Spraying operations: 2 - 3

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. 20°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)

Technical Data

www.4CR.com

4CR

Art.-No.: 6.4200.1000
6.4200.3500
6.4200.4000

4200

Colour	light-grey (approx. RAL 7035)
Consumption	5 - 6 m²/l
Mixing ratio	4 : 1 by volume
Hardener	0407
Spraying viscosity 20°C	a) 25 - 30 s 4 mm DIN, b) no thinner
Pot life	approx. 1 h with 0407 extra fast, approx. 2 h with 0407 fast
Coat thickness / dry film	a) 50 - 80 µm b) - 300 µm
Curing time / Flash off time	approx. 10 - 15 min. before stoving
Thinner	0505, a) approx. 5% b) without dilution

Storage and Transportation

Keep dry an frost-protected.

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

www.4CR.com