



Art.-No.:6.2500.1500

2500

Spray Filler

Characteristics

4CR 2500 is a two-component spray-filler which is based on polyester resin. It is suited for new sheet steel or old sanded paintwork. This product is especially suitable for a single operation in the filling of irregularities, deep sanding traces as well as rough pre-worked repairs.

V.O.C. Value

EU limiting value for the product (cat. B/b): 250 g/l (2007)
This product contains max. 116 g/l VOC [0.97 lbs/gal]

Tech Tip

Fast drying and easy to sand. Excellent stability, even in thicker layers.
Not to be used on old thermoplastic paintwork, 1K-Primers and Primers containing acid. For the perfect build up of paint, an insulation with 1K-/2K-Filler is required. The galvanized supports should be primed first with 4CR 4510 EP Primer. The addition of an excessive amount of hardener can cause bleeding on the top coat.

Application

Processing conditions: from + 10°C and up to 80% relative air humidity.
Suitable substrates: bare steel, sanded painted surfaces, surfaces treated with 4CR Fibreglass Putty 2100.
Substrate features: clean, dry, sanded down and free of dust

Application process (Spraying, compressed air):
Viscosity: after hardener addition: ready for spraying
Nozzle: 2,0 - 2,5 mm
Pressure: 3 - 4 bar
Operations: 2 - 5
Film Thickness: 150 - 300 µm; max. 1000 µm

Drying:
Sandable at 20°C: after 2 – 3 h
at 60°C: after approx. 30 min.
Allow 10 min. cure time before force drying.

Sanding:
After drying (2 – 3 hours at 20°C)
Pre-sandable: dry P120 – P180
Re-sandable: dry P240 – P280
Polyester material should only be sanded when completely dried due to the fact that polyester reacts with water.

Processability:
4CR 2500 has to be insulated with 4CR 1K- or 2K-Filler before the top coat is applied.



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Technical Data

Mixing ratio	950 ml 2500 Spray Filler : 50 ml 2920 Hardner
Dilution	0520 PE-Thinner, max. 5%
Pot life	30 min. at 20°C
Viscosity	thixotrope
Consumption	4 - 6 m ² / l
Colour	grey
Gloss	mat
Specific weight	approx. 1,5 g/cm ³
Binder basis	unsaturated polyester resins

Storage and Transportation

At least 1 year, if stored in tightly closed original containers.