4CR

Art.-No.:6.7220.1000

7220

2K HS-Clearcoat mat

Characteristics

Degree of gloss 10% (gloss degree 15 - 20 units / 60°), used for matt finishing or used as additive in 4CR UHS Clearcoats. VOC compliant high solid two component acrylic coating recommended for high quality mat paintwork in the automotive sector. Compatible to solvent-borne or water-borne basecoats. Excellent chemical and mechanical resistance. Good protection against all weathering influences.

V.O.C. Value

Eu limiting value for the product (cat. B/e): 840 g/l
This product contains maximal 495 g/l VOC [4.13 lbs/gal]

Tech Tip

To assure a unitary, even gloss degree on larger areas it is recommended to apply 4CR 7220 at last at the end of the working day to allow a drying over night at room temperature.

Application

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

HVLP
Air pressure: 2.0 - 2.5 bar (nozzle internal pressure: 0,7 bar)
Spray gun: 1.3 - 1.4 mm
Coats: 1 dust coat + 1 full coat

Air / Flowjar
Air pressure: 3 - 5 bar
Spray gun: 1.3 - 1.5 mm
Coats: 1 dust coat + 1 full coat

Flash off time
5 - 10 min. between the spraying operations
30 - 45 min. before oven drying

Drying
Metal temperatur 20°C: dust dry after 30 min., set to touch after 12 h, full hardeness after 24 h
Metal temperatur 60°C: dust dry after 5 min., set to touch after 30 min., full hardeness after 2 h

Possible gloss levels

silk-mat:
4CR 7220 + 4CR UHS Clearcoat mixing ratio 7:1

silk-gloss:
4CR 7220 + 4CR UHS Clearcoat mixing ratio 4:1

...the professional choice.

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semi-gloss:

4CR 7220 + 4CR UHS Clearcoat mixing ratio 3:1

Technical Data

Consumption	10 - 12 m² / l
Coat thickness / dry film	50 - 60 µm
Pot life (20 °C)	1 h
Spraying viscosity 20° C	16 -17 s 4 mm DIN
Dilution	25 % 4CR 0505
Hardener / Mixing ratio	0407 (2:1) / 0408 (3:1) by volume
Colour shade	transparent

Storage and Transportation

Keep dry an frost-protected.

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

...the professional choice.