



Art.-No.: 6.4185.1001
6.4185.4001

4185

2K Compact- filler New Formula 4:1 grey

Characteristics

4CR 4185 New Formula is a fast drying and easy sanding two component filler with corrosion protection and good adhesion for the car repair.

High filling power and no shrinking.

Also Spot-repairs can be carried out without any inconvenience.

Note on bare substrates, 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 can be directly overcoated.

Application

Air / Flowjar - Spray gun

Spraying pressure: 1,7 - 2,0 bar

Spraying nozzle: 1,3 - 1,9 mm

Spraying operations: 1 - 3

Drying

Metal temperature 20°C: after approx. 3 - 4 h

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

IR 20 min.

Sanding

Recommended with P 400 dry on one component top coats; with P 500 dry on two component top coats.



Processing Details:

From +10°C and up to 80% relative air humidity. Ensure of a adequate air ventilation

Correct way of Processing

The substrate must be clean, dry and free from grease.

In case of one- layer paint systems use P400 dry sanding,
Two layer paint systems we recommend P500/600

Substrate preparation:

The substrate must be clean, dry and free from grease, then sand the surface.
Remove non adhering old painted surfaces and primers.

Then pre- clean again all the surfaces with 4CR 0610 Silicone Remover.

Aluminium Surfaces sand with P220, Steel with P120

After preparation and sanding, clean again thoroughly with 4CR 0610 Silicone Remover.



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Technical Data

VOC Regulation:	EU limit value for this product (category B/c): 540 g/l This product contains max. 520 g/l of VOC.
Theoretical consumption	3,8 - 5,4 m ² / l(for 60µm DTF)
Colour	Grey
Mixing ratio	4:1 by volume
Hardener	0407
Thinner	0 - 20 % 4CR 0505
Spraying viscosity 20°C	25 - 30 s 4 mm DIN
Pot life	0,5 - 1 h
Coat thickness / dry film	60 - 250µm
Curing time/ Flash off time	10 min.

Storage and Transportation

In tightly closed original containers at least 3 years shelf life.