



Art.-No.: 6.4270.1000  
6.4270.4000

**4270**

## 2K Premium HS-Filler 4:1

### Characteristics

Quick drying sanding filler, which also can 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: 2,0 - 2,5 bar

Spraying nozzle: 1,2 - 1,8 mm

Spraying coats: 1 - 3

Flash-off time:

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

Drying

Metal temperature 20°C: paintable after 15 - 20 min., sandable after approx 4 - 5 h

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

### Mixing ratio

4 : 1 by volume (with 4CR 0407 fast)

6 : 1 by volume (with 4CR 0408 fast)



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Thinner

Addition as sanding filler:

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

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

Addition as wet-on-wet filler:

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

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

Addition as plastic filler:

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

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

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 - 180 µm

Wet-on-wet filler: 30 - 60 µm

Plastic filler: 20 - 30 µm

Technical Data

Colour light-grey

Pot life 1 h

Consumption 5 - 7 m<sup>2</sup>/l (at 45 microns coat thickness)

Storage and Transportation

Keep dry an frost-protected.

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