



AUTOMOTIVE PAINTS CATALOGUE



ABOUT US

Encouraging innovation

With our worldwide development network through our partners of European raw materials suppliers and R&D centers and our own knowhow, we are able to develop innovative, ecological and economical products that help our customers to succeed in completion

Customer Satisfaction

The customer is at the forefront of our thinking. We adapt to your requirements. We offer you services with real added value. Our expert consultants will support you in all questions

Keeping our eye on quality

We are constantly setting new standards with our product developments. We have the right combination of experience, resources and expertise to meet the demands of a constantly evolving market now and in the future

Revealing colour and wood trends

Our color experts identify the trends of the future in cooperation with color experts from the worlds of fashion, architecture and design. You can use this knowledge in the development of your own designs



BODY FILLER

Characteristic properties

It is a hardened polyester putty that is used to fill gaps and irregular areas in car surfaces and is characterized by ease of sanding.

Viscosity

98± 2 ku at 25 °C

Solid content

88 ± 2%

Density

1.77 – 1.87am/cm³

Coverage

3 - 4 m²/Kgm

Bending

0.5 cm max

Flash

32 °C

Materials for application

Body filler
Hardener peroxide

Suitable substrate and surface preparation

- On metal surfaces.
- Over existing final paints.
- Over the bases (primers and servers) epoxy.

Mixing ratio

| | |
|-------------------|-----|
| Body filler | 100 |
| Hardener peroxide | 2-3 |

Pot life

5 minute at 20°C



Packaging

| | |
|----------|----------|
| 0.850kgm | 1.600kgm |
| 2.800kgm | 3.990kgm |

BODY FILLER

Drying times at 20 °C

20- 30 minutes

Drying times at 40 °C

10 minutes

Grade of sandpaper filter to use:
For dry mechanical sanding it is recommended to use sandpaper P80-P120

Color

Yellow – grey - white - Red

Expiry

body filler 1 year at 20°C
hardener peroxide 1 year at 20°C

Material safety data

When using these products it is required to comply with the national regulations for health and safety



PRIMER

Characteristic properties

A fast-drying one-component paint that is part of a complete system used to protect metal surfaces, and its most important features are that it is resistant to rust and is characterized by strength, High adhesion, good sanding, and high filling strength

Viscosity

130 ± 2 ku at 25 °C

Density

1.67 ± 0.02 g/cm³

Solid content

75 ± 2%

Coverage

6-8 m²/Kg

Bending

Good

Materials for application

Primer
White Spirit

Suitable substrate and surface preparation

The surface must be completely free of rust

The surface must be dry, smooth, free from dust and grease.

Suitable for coating all metal surfaces.

Mixing ratio

Thinner is used until the appropriate viscosity is applied, then it is applied using a spray gun

Packaging

1kgm

2.500kgm

4kgm

20kgm

PRIMER

Drying times at 20 °C

Temp 20°C

Touch Dry 4Hrs

Hard Dry 24Hrs

Color

White – grey – red – black

Expiry

2 years at 25 °C

Material safety data

When using these products it is required to comply with the national regulations for health and safety

1K FILLER

Characteristic properties

It is a quick-drying air filler to repair gaps and surfaces in the car body, suitable for dry sanding and sanding using water.

Viscosity

30 ± 2 sec / ford cup 4 at 25 °C

Solid content

73 ± 2%

Density

1.46 ± 0.02 gm/cm³

Materials for application

Filler 1k
Thinner 5025

Suitable substrate and surface preparation

this product can be applied directly to
Old paints
Metal surfaces
Polyester paste
Nitro-cellulose paste
The surface is sanded using sand-
paper
p600-p800 for sanding using water-
automatic or manually
p360-p400 for dry sanding (automatic-
(or manual

Mixing ratio

| | |
|--------------|-----|
| 1k Filler | 100 |
| Thinner 5025 | 100 |

Packaging

| | | |
|----------|----------|------|
| 1.250kgm | 1.400kgm | 3kgm |
| 3.600kgm | 3.800kgm | 5kgm |
| 15kgm | 25kgm | |


1K FILLER

1K FILLER

Spraying conditions

| Spray gun | Nozzle diameter | Spraying pressure |
|--------------|-----------------|-------------------|
| Gravity feed | 1.8 -1.5 mm | 2-4 bar |
| Suction feed | 2.2 -1.8 mm | 2-4 bar |

Drying times

| | |
|----------|-----------|
| At 20 °c | 30 minute |
| At 40 °c | 20 minute |
| At 60 °c | 15 minute |

Film thickness

micron per layer 12 - 10

Instructions for spraying viscosity

Spray (2-3) layers individually and leave to dry completely for (5-10) .minutes after each layer
sec / (Ford cup No. 4) - at (18-22) 20oc

Color

White – grey – red – black - yellow

Expiry

2 years at 25 °C

Material safety data

When using these products it is required to comply with the national regulations for health and safety

2K FILLER

Characteristic properties

It is a 2K acrylic filler developed for use under 2K acrylic paints and ready mix or with base coats. It is easy to apply and flat giving good final appearance.

Viscosity

00:20 - 00:25 sec Cup#4 dill 2:1 by B.Ac at 25 °C

Solid content

72 ± 2%

Density

1.70-1.74 g/cm³

Materials for application

2K Filler
2K Filler Hardener
Thinner 9006, Super Thinner

Suitable substrate and surface preparation

4M 2K filler can be applied over PE putties/body fillers, 2K Epoxy Primers, 2K Wash Primers, 1K Etch Primers, original OEM primers, GRP, and over well sanded old finishes in solid conditions. To reach optimum performance, the surface should be properly cleaned and degreased

Mixing ratio

| | |
|--------------------|-----|
| 2K Filler 4M | 100 |
| 2K Filler Hardener | 25 |
| Thinner | 25 |

Packaging

1kgm



2K FILLER

Spraying conditions



Spray gun tips:

Compliant: 1.7-1.8mm; Air pressure: 2bar (26-29psi) at the air inlet
HVL: 1.7-1.8mm; Air pressure: 0.6-0.7 bar (8-10psi) at the tip
Conventional: 1.7-1.8mm; Air pressure 3.0-3.5 bar (45-50psi) inlet
For best overall results, refer to the spray gun manufacturer's recommendation.



Numbers of coats:

Apply 2 normal coats, Total dry film thickness 80-100



Manual wet sanding:

P800 or P1000



Drying time:

3.5-4h 20°C
30min at 60°C



IR Drying:

Short wave*: 10-15min
*Guideline for IR equipment.
Refer to the equipment Manufacturer's instruction for sets-up.



Flash off time:

Between coats: 5-7 minutes at 20°C
Before baking: 20min at 20°C



Machine dry sanding:

P320-P400/P500

Color Grey, White, Red, Black.

Pot Life 4 hours at 20 °C

Overcoating 2K filler can be overcoated after sanding. It is overcoated with 2K topcoats, and with basecoat colors

Other tips 1. For optimum application ensure that both spray booth temperature and paint temperature are between 20°C and 25°C.
2. Clean the spray gun thoroughly immediately after the use of 2K products.

Expiry 2 years at 20°C

Material safety data

1. For full Health and Safety information refer to Material Safety Data Sheet (MSDS).
2. Observe the precautionary notices displayed on the container.
3. Goggles and suitable protective equipment must be worn while using these products.
4. Good ventilation must be provided in the working environment.

DUCO BASE COLORS

Characteristic properties

A quick-drying glossy nitro-cellulosic coating that gives a surface that has a high adhesion force after complete drying. It gives a hard surface that is resistant to cracking.

With the flexibility in the paint layer as it is non-porous, which helps in maintaining the car body from corrosion

Viscosity

43+/-2 sec/ ford cup 8 at 25 °C

Density

10.1-0.97gm/cm³

Coverage

4-6 m²/Kgm

Bending

Good

Materials for application

Duco base
Thinner 5025

Suitable substrate and surface preparation

The surface should be dry, smooth, free from dust and grease. Previously painted surfaces after removing scales and pimples. Suitable for painting metal and wood.

: The following sandpaper is used to make the surface smooth

P400: Sanding with water, mechanically or manually

P280: For dry sanding mechanically or manually

Mixing ratio

Dilute with Thinner 5025 to the right viscosity, then apply using a spray gun or brush

Thickness of paint layer

12-17 micron per layer



Packaging

2.500kgm

23kgm

WWW.4MCOATINGS.COM

DUCO BASE COLORS

Spray viscosity

18 -22 ford cup 4 at 20 °C

Spraying instructions

Spray 3-2 different layers
Wait 10-5 minutes for complete drying between layers

Color

White - silver - red - yellow oxide

Expiry

2 years at 20°C

Material safety data

When using these products it is required to comply with the national regulations for health and safety

Spray conditions

Spray gun Gravity feed

Spray gun aperture diameter 1.2 - 1.5

Air pressure required for spraying 3-4

Drying times at 20 °C

Initial dryness 20 minutes

Final dry 6-8 Hours

Drying times at 60 °C

Initial dryness 10 minutes

Final dry 1 Hour

BASE COAT

Characteristic properties

4M base coat gives the effect of the final paints for cars is a two-layer system that contains the base coat as a base coat and then sprayed with C2020 Varnish over it

It is characterized by a distinctive vision effect and high gloss

Viscosity

0:50 – 1:00 ford cup 8 at 25 °C

Solid content

50.00 – 55.00 %

Density

0.95 – 0.97am/cm³

Coverage

7-8 m²/Kg

Materials for application

4m base coat
Varnish c2020
Hardener 851
Thinner 9006

Suitable substrate and surface preparation

Over the old paints
Filler dry by hardener -
Air dry filler
The types of fillers are sanded using
:sandpaper
P1000-p800 for sanding using water
P400 - p360 for dry sanding

Mixing ratio

| | |
|--------------|-----|
| 4m base coat | 100 |
| Thinner 9006 | 100 |



Packaging

3.7le

BASE COAT

Drying times at 20 °c

Initial dryness 45 minute

internal dryness 3 Hours

Final dry 16 Hours

Spray viscosity

14-15 ford cup 4 at 20 °C

Spraying instructions

Spray 3-2 different layers
Wait 10-5 minutes for complete drying between layers
Base coat is sprayed and then c2020 varnish - is sprayed after drying

Spray conditions

| | |
|------------------------------------|--------------|
| Spray gun | Gravity feed |
| Spray gun aperture diameter | 1.2 – 1.5 |
| Air pressure required for spraying | 3-5 |

Drying times at 60 °c

Initial dryness 5 minute

internal dryness 15 Hours

Final dry 2 Hours

Color

According to the color catalog 4m

Expiry

2 years at 25 °C

Material safety data

When using these products it is required to comply with the national regulations for health and safety

DUCO PAINT GLOSSY COLORS

Characteristic properties

A quick-drying glossy nitrocellulose paint that gives a high glossy surface. It has a high adhesion force after complete drying. It gives a hard surface that is resistant to cracking, with flexibility in the paint layer as it is non-porous, which helps in preserving the car body from corrosion.

Viscosity

1:30 – 1:50 / ford cup 8 at 25 °C

Density

0.95 – 0.97gm/cm³

Solid content

33+/- 2%

Coverage

5-7 m²/Kgm

Bending

Good

Materials for application

4M Duco Paints
Thinner 5025

Suitable substrate and surface preparation

The surface should be dry, smooth, free from dust and grease. Previously painted surfaces after removing scales and pimples. Suitable for painting metal and wood.
The following sandpaper is used to make the surface smooth
P400: Sanding with water, mechanically or manually
P280: For dry sanding mechanically or manually

Mixing ratio

Dilute with Thinner 5025 to the right viscosity, then apply using a spray gun or brush



Thickness of paint layer

12-17micron per layer

Packaging

0.950kgm

3kgm

25kgm

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DUCO PAINT GLOSSY COLORS

Spray viscosity

18 -22 ford cup 4 at 20 °C

Spraying instructions

Spray 3-2 different layers
Wait 10-5minutes for complete drying between layers

Color

According to the color catalog 4m

Expiry

2 years at 20°C

Material safety data

When using these products it is required to comply with the national regulations for health and safety

Spray conditions

Spray gun Gravity feed

Spray gun aperture diameter 1.2 – 1.5

Air pressure required for spraying 3-4

Drying times at 20 °C

Initial dryness 20 minutes

Final dry 6-8 Hours

Drying times at 60 °C

Initial dryness 10 minutes

Final dry 1 Hour

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METALLIC PAINT COLORS

Characteristic properties

A quick-drying glossy nitrocellulose paint that gives a Metallic effect to the surface. It has a high adhesion force after complete drying. It gives a hard surface that is resistant to cracking, with flexibility in the paint layer as it is non-porous, which helps in preserving the car body from corrosion.

Viscosity

1:30 – 1:50 / ford cup 8 at 25 °C

Density

0.92 – 0.98gm/cm³

Solid content

33+/- 2%

Coverage

10 - 12m²/Kgm

Bending

Good

Materials for application

4M Metallic Paint
Thinner 5025

Suitable substrate and surface preparation

The surface should be dry, smooth, free from dust and grease. Previously painted surfaces after removing scales and pimples. Suitable for painting metal and wood.

: The following sandpaper is used to make the surface smooth

P400: Sanding with water, mechanically or manually

P280: For dry sanding mechanically or manually

Mixing ratio

Dilute with Thinner 5025 to the right viscosity, then apply using a spray gun or brush



Thickness of paint layer

12-17micron per layer

Packaging

| | | | |
|----------|------|-------|-------|
| 0.950kgm | 3kgm | 25kgm | 50kgm |
|----------|------|-------|-------|

METALLIC PAINT COLORS

Drying times at 20 °C

| | |
|-----------------|------------|
| Initial dryness | 20 minutes |
|-----------------|------------|

| | |
|-----------|-----------|
| Final dry | 6-8 Hours |
|-----------|-----------|

Spray viscosity

18-22 ford cup 4 at 20 °C

Spraying instructions

Spray 3-2 different layers
Wait 5-10 minutes for complete drying between layers

Spray conditions

| | |
|-----------|--------------|
| Spray gun | Gravity feed |
|-----------|--------------|

| | |
|-----------------------------|-----------|
| Spray gun aperture diameter | 1.2 – 1.5 |
|-----------------------------|-----------|

| | |
|------------------------------------|-----|
| Air pressure required for spraying | 3-4 |
|------------------------------------|-----|

Drying times at 60 °C

| | |
|-----------------|------------|
| Initial dryness | 10 minutes |
|-----------------|------------|

| | |
|-----------|--------|
| Final dry | 1 Hour |
|-----------|--------|

Color

According to the color catalog 4m

Expiry

2 years at 25 °C

Material safety data

When using these products it is required to comply with the national regulations for health and safety

DUCO PAINT MATT

Characteristic properties

A quick-drying nitro-cellulosic paint that gives a smooth surface that has a high adhesion force. After complete drying, it gives a hard, crack-resistant surface. With the flexibility in the paint layer as it is non-porous, which helps in maintaining the car body from corrosion

Viscosity

2:10 – 1:50 / ford cup 8 at 25 °C

Density

1.10 – 1.07gm/cm³

Solid content

40 – 45 %

Coverage

5-7 m²/Kgm

Bending

Good

Materials for application

4M Duco
Thinner 5025

Suitable substrate and surface preparation

The surface should be dry, smooth, free from dust and grease. Previously painted surfaces after removing scales and pimples. Suitable for painting metal and wood.

The following sandpaper is used to make the surface smooth
P400: Sanding with water, mechanically or manually
P280: For dry sanding mechanically or manually

Mixing ratio

Dilute with Thinner 5025 to the right viscosity, then apply using a spray gun or brush



Packaging

0.950kgm

3kgm

25kgm

DUCO PAINT MATT

Thickness of paint layer

12-17micron per layer

Spray viscosity

18 -22 ford cup 4 at 20 °C

Spraying instructions

Spray 3-2 different layers
Wait 10-5minutes for complete drying between layers

Color

According to the color catalog 4m

Expiry

2 years at 20°C

Material safety data

When using these products it is required to comply with the national regulations for health and safety

Spray conditions

Spray gun Gravity feed

Spray gun aperture diameter 1.2 – 1.5

Air pressure required for spraying 3-4

Drying times at 20 °c

Initial dryness 20 minutes

Final dry 6-8 Hours

Drying times at 60 °c

Initial dryness 10 minutes

Final dry 1Hour

2K SYSTEM COLOURS

Characteristic properties

It is a 2K acrylic mixing system for car refinishing. It offers high gloss top coats, hard and durable finish with very good coverage. In conjunction with 4M range of hardeners 851 , 951 can be easily applied and it is suitable for any type of car repair work.

Viscosity

0:30 – 0:35 ford cup 8 at 25 °C

Density

1.30 – 1.33 gm/cm³

Solid content

63 +/- 2 %

Coverage

8 - 9 m²/Kg

Materials for application

4m 2K System
Hardener 851 or Hardener 951
Thinner 9006

Suitable substrate and surface preparation

Filler dry by hardener
Air dry filler
The types of fillers are sanded using sandpaper:
P1000-p800 for sanding using water
P400 - p360 for dry sanding

Mixing ratio

| | |
|--------------|-----|
| 4m system | 100 |
| Hardener 851 | 50 |
| Thinner 9006 | 30 |

Packaging

3.7le

Pot life

4 hour at 20°C

2K SYSTEM COLOURS

Drying times at 20 °C

| | |
|------------------|------------|
| Initial dryness | 45 minutes |
| internal dryness | 3 Hours |
| Final dry | 24 Hours |

Spray viscosity

40-45 ford cup 4 at 20 °C

Spraying instructions

Spray3-2 different layers
Wait 5-10 minutes for complete drying between layers

Spray conditions

| | |
|------------------------------------|--------------|
| Spray gun | Gravity feed |
| Spray gun aperture diameter | 1.2 – 1.5 |
| Air pressure required for spraying | 3-5 |

Drying times at 60 °C

| | |
|-----------------|------------|
| Initial dryness | 5 minutes |
| Initial dryness | 15 minutes |
| Final dry | 2 Hours |

Color

According to the color catalog 4m

Expiry

2 years at 25 °C

Material safety data

When using these products it is required to comply with the national regulations for health and safety

VARNISH C2020MS

Characteristic properties

It is a 2K medium solids acrylic clearcoat especially formulated for applying over solvent-based basecoats. It gives high gloss final appearance. It offers high durability and weathering resistance. delivers (851 – 951) 4M Hardeners When used in conjunction with high gloss and excellent finish

Viscosity

34 ± 2 sec / ford cup 8 at 25 °C

Density

0.99 - 1.01 gm/cm³

Solid content

65 ± 2%

Coverage

6.5 – 7.5 m²/Kgm

Materials for application

Hardener 851
Thinner 9006
Varnish c2020 MS

Suitable substrate and surface preparation

- This product has been specifically designed for application to base-system products

Mixing ratio

| | |
|------------------|-----|
| Varnish C2020 MS | 100 |
| Hardener 851 | 50 |
| Thinner 9006 | 30 |

Pot life

4 hour at 20°C



Color

Clear

Packaging

| | |
|----------|----------|
| 1.150kgm | 0.575kgm |
|----------|----------|

Spraying conditions

| Spray gun | Nozzle diameter | Spraying pressure |
|--------------|-----------------|-------------------|
| Gravity feed | 1.3 – 1.4 mm | 3-4 bar |
| Suction feed | 1.7 – 1.5 mm | 3-4 bar |

Drying times at 20 °C

| | |
|---------------------|------------|
| superficial dryness | 45 minutes |
| internal dryness | 4 Hours |
| complete dryness | 16 Hours |

Drying times at 60 °C

| | |
|---------------------|------------|
| superficial dryness | 5 minutes |
| Initial dryness | 15 minutes |
| complete dryness | 45 minutes |

Instructions for spraying viscosity

Spray 3 layers individually
Wait (5-10) minutes for complete drying between layers
Suspended dust and defective varnish parts can be polished after completely drying for two days at 20°C or 30 minutes at 60°C
Then crush the defective areas using a very fine sandpaper and then polish them using (polish) manually or automatically

spray viscosity

15 – 18 sec ford cup 4 at 20 °C

Expiry

2 years at 25 °C

Material safety data

When using these products it is required to comply with the national regulations for health and safety

2K HARDENER 851

Characteristic properties

It is a multi-use hardener in different products. When added to acrylic products, it gives the paint layer the required specifications with high gloss, high resistance to weathering and high resistance to chemicals.

Materials for application

2K Hardener 851
4m system
Varnish c2020, c2030, c2040
Thinner 9006

Mixing ratio

| | |
|-------------------|-----|
| C2020 – 4m system | 100 |
| Hardener 851 | 50 |
| Thinner 9006 | 30 |

Expiry

1 year at 25 °C

Material safety data

When using these products it is required to comply with the national regulations for health and safety

Packaging

| | |
|----------|----------|
| 1.150kgm | 0.575kgm |
|----------|----------|



2K HARDENER 951

Characteristic properties

it is a quick-drying hardener that is multi-use in different products. When added to acrylic products, the paint layer gives it the required specifications with high gloss, high resistance to weathering and high resistance to chemicals.

Materials for application

2K Hardener 951
4m system
Varnish c2020, c2030, c2040
Thinner 9006

Mixing ratio

| | |
|-------------------|-----|
| C2020 – 4m system | 100 |
| Hardener 951 | 50 |
| Thinner 9006 | 30 |

Expiry

1 year at 25 °C

Material safety data

When using these products it is required to comply with the national regulations for health and safety

Packaging

| | |
|----------|----------|
| 1.150kgm | 0.575kgm |
|----------|----------|



THINNER 9006

Characteristic properties

A Thinner that offer great versatility of applications within the range of 4M Car Refinish Paints.

Materials for application

4M Car system
Varnish c2020
Hardener 851
Thinner 9006

Mixing ratio

| | |
|-----------------------|-----|
| C2020 – 4m Car System | 100 |
| Hardener 851 | 50 |
| Thinner 9006 | 30 |

Expiry

2 years at 25 °C

Material safety data

When using these products it is required to comply with the national regulations for health and safety

Packaging

| | |
|------|----------|
| 1kgm | 0.500kgm |
|------|----------|



UNDERCOAT

Characteristic properties

It is a 1K underbody product based on modified alkyd resin designed to protect car underbody from corrosion as well body floor and other metal parts. It gives anticorrosion properties, excellent adhesion and chemical resistance.

Viscosity

10000 – 15000 cp at 25 °C

Density

1.79 – 1.82 g/cm³

Solid content

83 ± 2%

Coverage

6 - 8 m²/Kg

Bending

Good

Materials for application

Under coat
Thinner

Suitable substrate and surface preparation

undercoat used over bare metals. Following degreasing flat with the following sandpaper grades.
P400: to wet (mechanically or manually).
P280: to dry flat (mechanically or manually).

Method of Application

thinned with thinner5025. Under coat can be applied in 1 - 2 coats. For spraying a special undercoat spray gun is recommended at a pressure of 3 - 5 bar.

Color

White – Grey - black

Drying times at 20 °C

| | |
|-----------------|----------|
| Initial dryness | 3 Hours |
| Final dry | 24 Hours |

Expiry

2 years at 25 °C

Material safety data

When using these products it is required to comply with the national regulations for health and safety

Packaging

| | |
|---------|-------|
| 1.5 kgm | 5 kgm |
|---------|-------|

Notes

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4M COATINGS



📍 Industrial zone, South Port Said, G Piece Tribal C9

☎ 066 3758102 | 066 3758103 | 066 3758104

☎ (+2) 0100 504 0464

🌐 www.4mcoatings.com ✉ info@4mcoatings.com