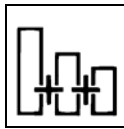


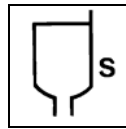


04806 - 04810 MACROFAN HS RAPIDFILLER



1000 ml +
250 ml +
100-250 ml

Pot-life at 20° C:
60-20 min



25-35" DIN4
at 20° C



Ø 1,5-1,7 mm
2-2,5 bar
HVLP:
2-2,5 bar
N° of coats: 2-3



Sealer: 60-90 µ
High build filler:
100-140 µ



Sanding:
1-4 hours at 20° C or
20-30 min. at 60° C



IR: 5-6 min. flash-off
8-10 min. max power

DESCRIPTION

Acryl-urethane high solids sealers/fillers available in two colours, Light Grey (04806) and Dark Grey (04810).

USE

Sealer - filler for all vehicle refinishing, in particular for those repairs where the rapidity is essential.

CHARACTERISTICS

- Very fast drying.
- Particularly suitable for SPOT REPAIRS.
- Easy to sand.
- Good sealing power.
- Good hold out.
- Good anti-corrosive protection for small surfaces (it contains zinc phosphate).
- Good adhesion also on electro zinc-coated steel.
- The two primers can be mixed to obtain any grey shade to improve the hiding power of the finishing coat and to reproduce the original grey colours of the O.E.M. primer.
- High solids content.

SUBSTRATE PREPARATION

Knifing polyester putties

Sand with P120-180-240 dry paper then degrease with 00695 SILICONE REMOVER SLOW.

Steel, galvanised or zinc coated steel, aluminium

It has good anti-corrosive and adhesion qualities. On large surfaces apply a priming coat of 04318 FIX-O-DUR or 05720 MONOPRIMER to improve the protection against corrosion.

Old coatings

Sand and degrease with 00660 QUICK CLEANER / 00699 HYDROCLEANER. The application on solvent-sensitive films (i.e. TPA) is not recommended.

Plastic Parts (car field)

Apply MAC0 or 04363 UNIVERSAL PLAST as adhesion priming coat.

APPLICATION

Spray application by conventional or HVLP guns.

Mixing Ratio:

	by volume	by weight
MACROFAN HS RAPIDFILLER (04806 or 04810)	1000 ml	1000 g
00362 HS HARDENER MEDIUM	250 ml	160 g
00740 (Speedy)-741 (Medium)-742 (Slow) -00755 (Extra Slow)		
THINNERS AUTOREFINISHING	100-250 ml	50-200 g

For SPOT REPAIRS

MACROFAN HS RAPIDFILLER (04806 or 04810)	1000 ml	1000 g
00174 HS HARDENER EXTRA SPEEDY	250 ml	160 g
00740 (Speedy) –741 (Medium) THINNERS AUTOREFINISHING	150-250 ml	100-200 g

	00362 <i>T: 15-35°C</i>	00174 <i>Spot Repairs</i>
Pot-life at 20 °C	60 min.	20 min.

Spray viscosity at 20 °C: 25÷35" DIN 4

Air cap Ø: conventional and HVLP gun 1,5÷1,7 mm

Air pressure: conventional gun and HVLP gun: 2÷2,5 bar

Number of coats: sealer 2 coats; high build filler: 3 coats

Interval between the coats: 5÷8 min.

Suggested film thickness: sealer 60÷90 µ; high build filler 100-140 µ

Coverage (theoretic value): 1 kg = 4.1 m² at 80 µ; 1 l = 5,2 m² at 80 µ

DIR 2004/42/CE: Primer IIB/c – VOC ready for use 540 g/l

These products ready for use contain at most 500 g/l VOC (04806) and 540 g/l VOC (04810)

DRYING TIME

	00362		00174	
Air drying at 20°C:	Sealer	Filler	Sealer	Filler
Tack free	40 min.		20 min.	Not suggested
Can be sanded after	3 h	4 h	1 h	suggested

Low bake at 60 °C (surface temperature):

Can be sanded after	30 min.	10 min.
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IR Lamp (short-wave IR):

Flash off	5-6 min.	Not suggested
Max power	8-10 min.	
Distance from the substrate	60-80 cm.	

SANDING**For one coat finishes:**

Dry sanding with P320

Wet sanding with P500

For two coats (base + clear) finishes:

Dry sanding with P400

Wet sanding with P600-800






OVERCOATINGS

- MACROFAN HS TOPCOAT
- HYDROFAN + low VOC Refinish clearcoats of Lechler range

OBSERVATIONS

Mixing the two primers in different ratios, you can obtain the whole shade of grey in order to improve the hiding power and to reproduce the same grey as original undercoat used by the car Manufacturer.

Ex.: by mixing the two primers with the suggested ratios, you can realise approx. the following grey shade:

					
04810	100	70	50	10	0
04806	0	30	50	90	100

TECHNICAL DATA SHEET N° 0496-GB

UPDATED 10/2007

The information shown in these sheets is given in good faith as being true and although every effort of verification has been made before use, we cannot accept responsibility for any inaccuracy. THIS PRODUCT IS FOR THE PROFESSIONAL PAINTING OF ROAD VEHICLES BY QUALIFIED PERSONNEL