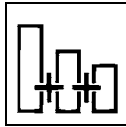


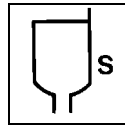


MAC 71 (M7010) MACROFAN HS COLOR HIGH FILLER



HS Hardeners:
1000 ml +
250 ml +
150-250 ml

UHS Hardeners:
1000 g +
130 g +
100-200 g



20-25" DIN 4
at 20° C

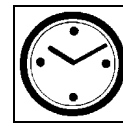
Pot-life a 20°C:
HS = 120-30 min.
UHS = 90-30 min.



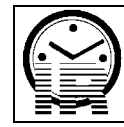
Ø 1,5-1,7 mm
2-2,5 Atm
HVLP: 2-2,5 Atm
n° of coats: 2-3



Sealer: 60-90 µ
High build filler:
120-180 µ



Sanding after:
2-5 h at 20° C
or
15-30 min. at 60° C



Flash off 5-6 min.
Max. power 10-15 min.

DESCRIPTION

High solids coloured sealer/filler for dry-on-dry paint processes.

USE

Sealer - filler for all car refinishing, for dry-on-dry process.

CHARACTERISTICS

- Very fast drying.
- Very good sanding
- Good filling power
- Very good sealing power.
- Low absorption of the topcoat.
- Good adhesion on zinc-coated steel sheet
- Can be tinted to obtain any colour shade to improve the hiding power of the finishing coat and to reproduce the original colour of the O.E.M. primer.

SUBSTRATE PREPARATION

Knifing polyester putties

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

Steel, galvanised or zinc coated steel, aluminium

On steel apply a priming coat of 04318 FIX-O-DUR or 05720 MONOPRIMER.

On zinc-coated or aluminium original parts MAC71 has a good direct adhesion; on large surfaces it is however recommended to use 04318 or 05720.

Old coatings and new surfaces treated with cataphoresis

Sand and degrease with 00665 HYDROCLEANER SLOW / 00699 HYDROCLEANER. The application on solvent-sensitive films is not recommended.

Plastic Parts (car field)

Apply MAC0 or 04363 UNIVERSAL PLAST.

In case of flexible substrates add max 10% of plasticizer 09760 to the filler (see TDS n° 0281).

APPLICATION

Spray application by conventional or HVLP guns.

| | T: 15-30°C | T: >30°C | T: 15-30°C | Spot Repairs | |
|--------------------------|--------------|--------------|--------------|--------------|--------------|
| HARDENERS | 00362 | 00379 | MH400 | 00174 | MH415 |
| Pot-life at 20 °C | 2 hours | 2 hours | 1,30 hour | 30 min. | 30 min. |

Mixing ratio:

| High build filler | HS Hardeners | | UHS Hardeners | |
|---|--------------|------------|---------------|---|
| MAC 71 MACROFAN HS COLOR HIGH FILLER (derived from binder M7010) | 1000 g | 1000 ml | 1000 g | Mixture by volume not recommended |
| 00362 - 00379 HS HARDENER | 160 g | 250 ml | | |
| MH400 MACROFAN UHS HARDENER | | | 130 g | |
| 00740 - 00741 - 00742 - 00755 AUTOREFINISHING THINNERS | 100-200 g | 150-250 ml | 100-200 g | |

| For spot repairs | HS Hardeners | | UHS Hardeners | |
|---|--------------|------------|---------------|---|
| MAC 71 MACROFAN HS COLOR HIGH FILLER (derived from binder M7010) | 1000 g | 1000 ml | 1000 g | Mixture by volume not recommended |
| 00174 HS HARDENER EXTRA SPEEDY | 160 g | 250 ml | | |
| MH415 MACROFAN UHS SPOT REPAIRS | | | 130 g | |
| 00740 - 00741 - 00742 - 00755 AUTOREFINISHING THINNERS | 100-200 g | 150-250 ml | 100-200 g | |

Spray viscosity at 20 °C: 20÷25" 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: high build filler 2-3 coats ; sealer 2 coats

Interval between the coats: 5÷8 min.

Suggested film thickness: high build filler 120-180 µ; sealer 60÷90 µ;

Coverage (theoretic value): 1 kg mixture = 5,9 m² at 50 µ; 1 l mixture = 7,5 m² at 50 µ

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

This product ready for use contains at most 540 g/l VOC

DRYING TIME

| HARDENERS | 00362 or MH400 | | 00379 | | 00174 or MH415 | |
|---|----------------|---------|---------|---------|----------------|------------------------|
| | Sealer | Filler | Sealer | Filler | Sealer | Filler |
| Air drying at 20°C (Object temperature): | | | | | | |
| Tack-free | 40 min. | | 40 min. | | 20 min. | Not recommende d |
| Sanding after | 4 hours | 5 hours | 4 hours | 5 hours | 2 hours | |

Low bake at 60 °C (Object temperature):

| | | | |
|---------------|---------|---------|---------|
| Sanding after | 30 min. | 30 min. | 15 min. |
|---------------|---------|---------|---------|

IR Lamps (short waves):

| | | | |
|------------|------------|------------|-----------------|
| Flash-off | 5-6 min. | 5-6 min. | Not recommended |
| Max. power | 10-15 min. | 10-15 min. | |
| Distance | 80 cm. | 80 cm. | |

SANDING**For one coat finishes:**

Dry sanding with P320 (sanding machine)

Wet sanding with P500

For two-coat finishes:

Dry sanding with P400 (sanding machine)

Wet sanding with P600-800

OVERCOATINGS

- MACROFAN HS TOPCOAT
- HYDROFAN / BSB + Refinish clearcoats of Lechler range

NOTES

You can find the formulations for the colours obtainable with MAC71 under "Casa Sottotinte/Undercoats" suggested as undercoats for the finishing system HYDROFAN and indicated as original undercoat used by the car Manufacturer.

TECHNICAL DATA SHEET N° 0441/71-GB

UPDATED 09/2008

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