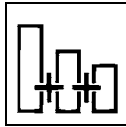




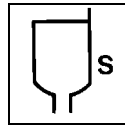
04706 - 04710

MACROFAN HS HIGHFILLER



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

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



20-25" DIN4
at 20° C

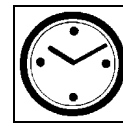
Pot-life at 20°C:
HS = 120-30 min.
UHS = 90-30 min.



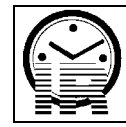
Ø 1,5-1,7 mm
2-2,5 Atm
HVL P: 2-2,5 Atm
n° of coats: 2-3



Sealer: 60-100 µ
High-build filler:
120-180 µ



Sanding:
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 sealers/fillers available in two colours, Light Grey (04706) and Dark Grey (04710).

USE

Sealer - filler for all vehicle refinishing, in dry-on-dry process.

CHARACTERISTICS

- Very fast drying.
- Very good sanding.
- Very good filling power.
- Good sealing power.
- Low top coat absorption.
- Good adhesion on zinc-coated steel sheet
- The two fillers can be mixed each other 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. fillers.

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

On steel always apply 1-2 coats of 04318 FIX-O-DUR or 05720 MONOPRIMER.

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

Old coatings and new parts treated with cataphoresis

Sand and degrease with 00665 HYDROCLEANER SLOW / 00699 HYDROCLEANER. The application on thermoplastic or 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	
MACROFAN HS HIGHFILLER (04706 or 04710)	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	
MACROFAN HS HIGHFILLER (04706 or 04710)	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÷100 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

These products ready for use contain 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 recommended
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.
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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

One coat finishes:

Dry sanding with P320 (rotorbital)

Wet sanding with P500

Two coats finishes:

Dry sanding with P400 (rotorbital)

Wet sanding with P600-800

OVERCOATINGS

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

OBSERVATIONS

Mixing the two fillers 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 fillers with the suggested ratios, you can obtain approx. the following grey shade:

	100	70	50	10	0
04710	100	70	50	10	0
04706	0	30	50	90	100

TECHNICAL DATA SHEET N° 0547-GB

UPDATED 09/2008

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