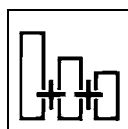


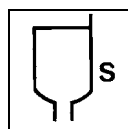


04804 MACROFAN HS ISOSEALER



UHS Hardeners
1000 g +
130 g +
150-300 g

HS Hardeners
1000 ml +
250 ml +
150-350 ml



20-25" Din 4
at 20° C

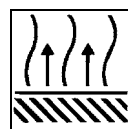
Pot-life at 20° C:
HS = 60-20 min.
UHS = 60-15 min.



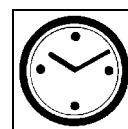
Ø 1,4-1,8 mm
3,5-4 Atm
HVLP:
Ø 1,4-1,8 mm
2-2,5 Atm
N° coats: 2-3



60-100 µ



W/W Cycle:
15-30 min. at 20° C



D/D Cycle
Air drying at 20°C:
sanding after 6-8 h
Low bake at 60°C:
10-20-30 min.
IR Lamps:
Flash off 4-5 min.
Max. Power 12-15 min.

DESCRIPTION

Two-pack HS polyacrylic sealer, for wet-on-wet and dry-on-dry cycles.

USE

Sealing undercoat directly over coatable without sanding (wet on wet cycles) with topcoats (MACROFAN HS TOPCOAT / HYDROFAN). It can be used for total or partial car and commercial vehicles repairs. It is particularly suggested to seal new pieces previously painted with cataphoresis primers. It can also be used as a sealer on dry-on-dry cycles.

CHARACTERISTICS

- It can be used on dry-on-dry and wet-on-wet cycles
- Very good sealing power on critical fillers (solvent sensitive).
- Excellent overspray-recovery
- Very good sanding
- Very good adhesion on cataphoresis
- High-solid content
- Grey colour

SUBSTRATE PREPARATION

Polyester knifing putty:

Use abrasive paper P240 and degrease with 00695 SILICONE REMOVER SLOW.

Steel, zinc-coated sheet, aluminium:

Apply 04318 FIX-O-DUR or 05720 MONOPRIMER as antirust coating.

Old coatings:

Dry sanding with P240-280 or wet sanding with P360-400 and degrease with 00665 HYDROCLEANER SLOW / 00699 HYDROCLEANER.

New parts treated with cataphoresis:

Use Scotch Brite and degrease with 00665 HYDROCLEANER SLOW / 00699 HYDROCLEANER.

Plastics (car field):

Apply MAC0 or 04363 UNIVERSALPLAST

APPLICATION

Spray with traditional or HVLP spray gun.

Mixing ratio:

Dry-on-Dry cycle	Hardeners HS		Hardeners UHS	
04804 MACROFAN HS ISOSEALER	1000 g	1000 ml	1000 g	Mixture by volume not recommended
00362 HS HARDENER MEDIUM	200 g	250 ml		
MH400-MH415 MACROFAN UHS HARDENER			130 g	
00740-00741-00742 – 00755 AUTOREFINISHING THINNERS	100-200 g	150-250 ml	150-250 g	

Wet-on-Wet cycle	Hardeners HS		Hardeners UHS	
04804 MACROFAN HS ISOSEALER	1000 g	1000 ml	1000 g	Mixture by volume not recommended
00362 HS HARDENER MEDIUM	200 g	250 ml		
MH400-MH415 MACROFAN UHS HARDENER			130 g	
00740-00741-00742 AUTOREFINISHING THINNERS	200-250 g	250-350 ml	250-300 g	

	T: 15-35°C	T: 25-35°C	T: 15-25°C
HARDENERS	00362	MH400	MH415
Pot-life at 20 °C	W/W: 20-30 min. – D/D: 60 min.	W/W: 20-30 min. D/D: 60 min.	W/W: 15 min. - D/D: 30 min.

Spray viscosity at 20°C: D/D = 20–25" DIN 4
 Ø Air cap (traditional and HVLP): D/D = 1,6-1,8 mm; W/W = 1,4 mm
 Air pressure: 3,5 – 4 Atm; HVLP: 2 – 2,5 Atm
 N° coats: D/D = 2-3; W/W = 1-2
 Suggested thickness: 60-100 µ
 Interval between coats: 6-8 min.

Coverage (theoretical values) : 4,3 m² for 1 kg of mixture at 80 µ
 5,6 m² for 1 l of mixture at 80 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		MH415	
Air drying at 20°C (Substrate temp):	D/D	W/W	D/D	W/W
Sanding	6-8 h		4-6 h	
Overcoatable		30 min. (by 12 h)		15 min. (by 1 h)
Low bake at 60 °C (Substrate temp):	D/D	W/W	D/D	W/W
Sanding	20-30 min.		10 min.	
Overcoatable		10 min.		Not recommended

IR Lamps (short waves):

Flash-off	4-5 min.	Not recommended
Max. power	12-15 min.	
Distance	60-80 cm.	

SUGGESTED OVERCOATINGS

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

TECHNICAL DATA SHEET N° 0483-GB
UPDATED 11/2008

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