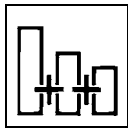


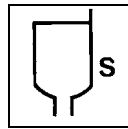


# 04806 - 04810 MACROFAN HS RAPIDFILLER



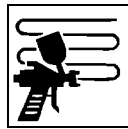
**UHS Hardeners**  
1000 g +  
100 g +  
100-250 g

**HS Hardeners**  
1000 ml +  
250 ml +  
100-250 ml

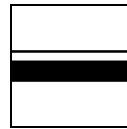


25-35" DIN4  
at 20° C

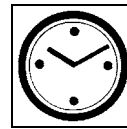
**Pot-life at 20°C:**  
HS= 60-20 min.  
UHS = 45-15 min.



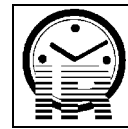
Ø 1,5-1,7 mm  
2-2,5 bar  
HVLP:  
2-2,5 bar  
N° of coats: 2-3



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 00665 HYDROCLEANER SLOW / 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:**

Filler	HS Hardeners		UHS Hardeners	
MACROFAN HS RAPIDFILLER (04806 or 04810)	1000 g	1000 ml	1000 g	Mixture by volume not recommended
00362 HS HARDENER MEDIUM	160 g	250 ml		
MH400 MACROFAN UHS HARDENER			100 g	
00740 -00741-00742- 00755 AUTOREFINISHING THINNERS	50-200 g	100-250 ml	100-250 g	
For spot repairs	HS Hardeners		UHS Hardeners	
MACROFAN HS RAPIDFILLER (04806 or 04810)	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			100 g	
00740-00741-00742 AUTOREFINISHING THINNERS	100-200 g	150-250 ml	150-250 g	

	T: 15-35°C		Spot Repairs	
HARDENERS	00362	MH400	00174	MH415
Pot-life at 20 °C	60 min.	45 min.	20 min.	15 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 m<sup>2</sup> at 80 µ; 1 l = 5,2 m<sup>2</sup> 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**

HARDENERS	00362 or MH400		00174 or MH415	
	Sealer	Filler	Sealer	Filler
<b>Air drying at 20°C:</b>				
Tack free	40 min.		20 min.	Not
Can be sanded after	3 h	4 h	1 h	suggested
<b>Low bake at 60 °C (surface temperature):</b>				
Can be sanded after	30 min.		10-15in.	
<b>IR Lamp (short-wave IR):</b>				
Flash off	4-5 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 or HYDROFAN / BSB + 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:

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

**TECHNICAL DATA SHEET N° 0496-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