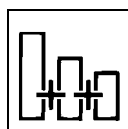




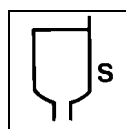
MAC 85 (M8005)

MACROFAN HS COLOR ISOSEALER



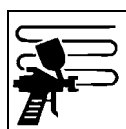
UHS Hardeners
1000 g +
130 g +
150-300 g

HS Hardeners
1000 g +
200 g +
100-250 g



25-30" DIN 4
at 20°C

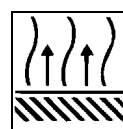
Pot-life at 20° C:
HS = 20-30 min.
UHS = 15-30 min.



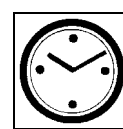
Ø 1,4-1,8 mm
3,5-4 bar
HVLP:
Ø 1,4-1,8 mm
2-2,5 bar
N° of coats: 1-2-3



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

High solids coloured sealer for use "wet-on-wet" and "dry-on-dry" paint processes.

USE

Insulating undercoat recoatable directly without sanding (wet-on-wet system) with finishing enamels (HYDROFAN/MACROFAN HS TOPCOAT), for total or partial car or commercial vehicles repairs. It is particularly suitable to insulate new parts already coated with cataphoresis . It can be also used as a sealer for spot repairs by sanding (dry on dry cycle).

CHARACTERISTICS

- Suitable for use "wet-on-wet" and "dry-on-dry"
- Very good sealing power on critical substrates (solvent sensitive).
- Excellent overspray-recovery.
- Easy to sand
- Very good adhesion on cataphoresis.
- High-solid content.
- Can be tinted to obtain any colour shade to improve the hiding power of the finishing coat and to reproduce the same original colours used.

SUBSTRATE PREPARATION

Knifing polyester putties:

Sand dry with P240 and degrease with 00695 SILICONE REMOVER SLOW.

Steel, galvanized or zinc coated steel, aluminium:

Apply a priming coat of 04318 FIX-O-DUR or 05720 MONOPRIMER as anti-corrosion protection.

Old coatings:

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

New parts coated with cataphoresis:

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

Plastics (car field):

Apply MAC0, or 04363 UNIVERSALPLAST.

APPLICATION

Spray application by conventional or HVLP guns.

Mixing ratio:

Dry-on-Dry cycle	HS Hardeners		UHS Hardeners	
MAC 85 MACROFAN HS COLOR ISOSEALER (derived from binder M8005)	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	HS Hardeners		UHS Hardeners	
MAC 85 MACROFAN HS COLOR ISOSEALER (derived from binder M8005)	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	250-300 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 min. - D/D: 30 min.	W/W: 20 min. - D/D: 30 min.	W/W: 15 min. - D/D: 20 min.

Spray viscosity at 20°C: 25-30" DIN 4

Air cap Ø (conventional and HVLP guns): D/D = 1,6-1,8 mm; W/W =1,4 mm

Air pressure: 3,5 – 4 bar; HVLP: 2 – 2,5 bar

N° of coats: D/D = 2-3; W/W = 1-2

Film thickness: 60-100 µ

Interval between coats: 6-8 min.

Coverage (Theoretic value): 1 kg mixture = 4,3 m² at 80 µ; 1 l mixture = 5,6 m² 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.	

OVERCOAT WITH

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

NOTES

You can find the formulation for the colours obtainable with MAC85 under **sottotinte/undercoats** suggested as undercoats for the finishing system HYDROFAN and indicated as original undercoat used by the Car Manufacturers.

ATTENTION: if you use "MACROFAN HS SYSTEM Primers&Fillers Color Range" colour fans for the preparation of the coloured primer, use the formulations indicated in the MAC8 table and replace M8000 binder with M8005 binder. Black fillers have a faster pot-life than other colours, therefore they must be mixed with their hardener when being used.

TECHNICAL DATA SHEET N° 0441/85-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