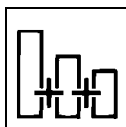
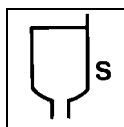




MAC 9 (M9000) MACROFAN HS COLOR UNDERCOAT



1000 g +
250 g +
250-300 g



16-18" DIN 4
at 20 °C

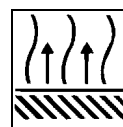
Pot-life at 20 °C:
30 min. – 4 h



Ø 1,3÷1,4 mm
2,5 Atm
HVLP: 2 Atm
N° of coats: 1÷3



30÷80 µ



from 40-30-15 min. to 8 h
at 20°C

DESCRIPTION

High solids coloured undercoat for “wet-on-wet” paint processes.

USE

Undercoat-sealer suitable to overcoat without sanding (wet-on-wet) with finishing lacquers. For vehicle refinishing including part repair, when the work speed is very important.

CHARACTERISTICS

- Suitable for use “wet-on-wet” without sanding.
- Quick drying.
- No top coats absorption.
- Easy to apply and very good flow.
- Very good adhesion.
- Suitable to be used as adhesion promoter for writings.
- Can be overapplied with solvent-based and water-based products.
- The binder can be applied without mixing with base colours. In this case, as transparent sealer.
- Can be tinted to obtain any colour shade to improve the hiding power of the finishing coat and to match the colour of the original fillers used.

SUBSTRATE PREPARATION

Knifing polyester putties:

sand with P240 dry paper. In case of large surfaces we recommend a traditional sanding sealer.

Steel, galvanised or zinc-coated steel, aluminium:

apply a priming coat of 04318 FIX-ODUR or 05720 MONO PRIMER for the protection against corrosion.

Old coatings and parts treated with cataphoresis:

sand dry with P240-280 or wet with P360-400 and degrease with 00665 HYDROCLEANER SLOW / 00699 HYDROCLEANER. The application on solvent-sensitive films (i.e. TPA) is not recommended.

Plastic Materials (car field):

apply MAC0, or 04363 UNIVERSALPLAST as adhesion priming coat.

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.

Mixing ratio:

MAC 9 MACROFAN HS COLOR UNDERCOAT (derived from binder M9000)
 MH400- MH410-MH415 MACROFAN UHS HARDENER
 00740 -00741-00742- 00755 THINNER AUTOREFINISHING

by weight

1000 g
 250 g
 250-300 g

	MH400	MH410	MH415
Pot-life at 20 °C	2 h	1 h	30 min.

Spray viscosity at 20 °C: 16-18" DIN 4

Ø Air cap: conventional and HVLP gun: 1,3-1,4 mm; Air pressure: conventional gun 2,5 Atm; HVLP gun 2 Atm

Number of coats: ½ + 1 full coat; Suggested film thickness: 30-50 µ

Coverage (theoretic value): 7.9 m² or 1 kg mixture by 50 µ; 9.2 m² for 1 lt mixture by 50 µ

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

This product ready for use contains at most 530 g/l VOC

DRYING TIME

Flash-off before overcoating with topcoat

Surface size	MH400 (T: >30°C)	MH410 (T: 15-30°C)	MH415 (T: 15-25°C)
	Large surfaces	Large surfaces	Spot repair 1-2 panels
at 20 °C	40 min.	30 min.	15 min.

up to 8 hours from the application at 20 °C; after this time allow to dry through and slightly rub at least.

OVERCOATINGS

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

NOTES

You can find the formulations for the colours obtainable with MAC 9 under "Casa Sottotinte/Undercoats) suggested as undercoats for the finishing systems HYDROFAN and indicated as original undercoat used by the Car Manufacturer.

In case of white colour or its derivates, in order to obtain a good coverage, the ratio between M9000/Base Colours must be 80/20 by volume (double then the amount of Base Colours and maintain unchanged the catalysis ratio).

At temperatures above 25-30°C and with high humidity the product mixed, ready for spraying, can skin over after 60 min.; in this case filter by a 2000 mesh gauze.

TECHNICAL DATA SHEET N° 0441/9-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