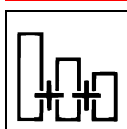
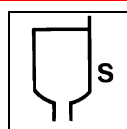




04702 - 04706 - 04710 MACROFAN HS HIGHFILLER



HS /MH100 Line:
1000 ml +
250 ml +
150-250 ml



20-25" DIN4
at 20° C



Ø 1,5-1,7 mm
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.

Pot life at 20°C:
30-120 min.

DESCRIPTION

High solids sealer/filler available in three colours, 04702 White, 04706 Light Grey and 04710 Dark Grey.

USE

Filler and sealer for all car refinishing works, in dry-on-dry system.

CHARACTERISTICS

- Very fast drying
- Excellent sanding
- Excellent filling power
- Good sealing power, low top coat absorption
- Good adhesion on zinc-coated steel sheet
- Possibility of obtaining any grey shade to improve the finishing coat covering 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 EC or 05720 MONOPRIMER. On zinc-coated or aluminium original parts it has 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 coatings is not recommended.

Plastics (car field): Apply MAC0 MACROFAN 1K PLASTIC COLOR PRIMER or 04363 UNIVERSALPLAST. In case of flexible substrates add max. 10% of plasticizer 09760 to the filler (see TDS n° 0281).

SMC – PRFG: Sand with P120-180-240 dry paper then degrease with 00695 SILICONE REMOVER SLOW.

APPLICATION

By mixing the fillers in different ratios you can obtain the whole shade of grey.

Ex.: by mixing according to the suggested ratios you can obtain approx. the following grey shade:

	Black	Grey 4	Grey 3	Light Grey	Grey 2	Grey 1	White
04710	100	65	40		10	3	
04706				100			
04702		35	60		90	97	100

Spray application by conventional or HVLP guns.

	T: 20-35°C	T: 15-25°C	Spot Repairs T: 15-25°C
HARDENERS	00379-MH100-MH110	00362-MH115	00174-MH120
Pot life at 20 °C	2 h	1 h	30 min.

Mixing Ratio:

High build filler	HS / UHS Hardeners	
MACROFAN HS HIGHFILLER (04702-04706-04710)	1000 g	1000 ml
00362-00379 HS HARDENER or MH100-110 MACROFAN UHS HARDENER	160 g	250 ml
00740-00741-00742-00755 AUTOREF. THINNERS	100-150 g	150-250 ml

For spot repairs	HS / UHS Hardeners	
MACROFAN HS HIGHFILLER (04702-04706-04710)	1000 g	1000 ml
00174 HS HARDENER EXTRA SPEEDY or MH115-MH120 MACROFAN UHS HARDENER	160 g	250 ml
00740-00741-00742-00755 AUTOREF. THINNERS	100-150 g	150-250 ml

Spray viscosity at 20 °C: 20-25" DIN 4

Air cap Ø: conventional and HVLP gun 1,5÷1,7 mm; Air pressure: according to the gun producer's instructions

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	00362-00379 or MH100-MH110		00174 or MH115-MH120	
	Sealer	Filler	Sealer	Filler
Air drying at 20°C (Object temperature):				
Tack-free	40 min.		20 min.	Not
Sanding after	4 hours	5 hours	2 hours	recommended
Low bake at 60 °C (Object temperature):				
Sanding after	30 min.		15 min.	
IR Lamps (short waves):				
Flash-off	5-6 min.		Not recommended	
Max. power	10-15 min.			
Distance	80 cm.			

SANDING

One-coat finishes:

Dry sanding with P320 (rotorbital)

Wet sanding with P500

Two-coat finishes:

Dry sanding with P400 (rotorbital)

Wet sanding with P600-800

OVERCOATINGS

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

TECHNICAL DATA SHEET N° 0547-GB

UPDATED 09/2020

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