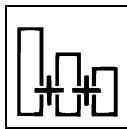
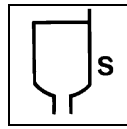


# MF402 – MF406 – MF410 MACROFAN AIR-TECH HS SEALER



1000 g  
500 g  
150-300 g



13-16" DIN4 20°C

Working Time at 20°C:  
15 min.



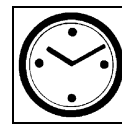
W/W-D/D system  
Ø 1,2 1,4 mm

W/W system  
½ +1 cross coat  
D/D system  
2 – 3 coats



W/W system:  
30-40 µ

D/D system:  
120-140 µ



W/W system 5 min.

D/D system 30-40 min.



Always use DPI

## DESCRIPTION

Two-pack "Air-Tech" primer/sealer with very fast drying. Available in 3 colours MF402 **White**, MF406 **Grey** (light grey) and MF410 **Black**.

## USE

Suitable primer/sealer for air drying painting processes. It can be overcoated in wet-on-wet process after a few minutes and can be sanded in dry-on-dry process after 30 minutes. It is possible to remove small impurities on the applied film just after 5 min. at 20°C and 50% R.H.

## CHARACTERISTICS

- Very good application, allowing you to obtain a smooth and stretched surface
- High sealing properties, ensuring a very good gloss level of the finish
- Very good speed of drying, both air drying and low baking at low temperatures, which allow to perform painting processes with very low energy consumption.
- Great versatility, usable both in W/W and D/D painting process
- It can be optimally overcoated up to 5 days without sanding

## SUBSTRATE PREPARATION

- **New parts treated with cathodic coatings:** degrease with 00695 SILICONE REMOVER SLOW or 00665 HYDROCLEANER SLOW / 00699 HYDROCLEANER; if in good condition sanding is not required.
- **Zinc-coated steel sheet, aluminium:** bare metal parts, suitably sanded and degreased, are to be treated with PW600 Power Wipes AC Primer.
- **Old coatings:** dry sanding with P280-320 grit paper and degrease with 00665 HYDROCLEANER SLOW / 00699 HYDROCLEANER.
- **Knifing polyester putty:** finish with P240 grit paper and degrease with 00695 SILICONE REMOVER SLOW or 00880 SILICONE REMOVER FAST.
- **Plastic substrates (car sector):** Apply MF302-06-10/MAC81 or 04363

## APPLICATION

By traditional spray gun or HVLP.

Mixing ratio:	w/w system	d/d system
MF402-6-10 MACROFAN AIR-TECH HS SEALER	1000 g	1000 g
MH440 MACROFAN AIR-TECH HARDENER	500 g	500 g
00740-00741-00742 AUTOREFINISHING THINNERS	300 g	150 g

Considering the product reactivity characteristics it is recommended to thoroughly follow the advices and application parameters indicated here below: low rates of relative humidity <30% slacken the product, high rates of relative humidity >70% speed up the product.

## PRIMER/FILLER

<b>Working time at 20°C</b>	15 min.
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Application parameters:	w/w system	d/d system
Spray viscosity at 20 °C DIN 4	13-14"	15-16"
Ø conventional air cap and HVLP	1,2 mm	1,3-1,4 mm
Pressure	As indicated by the gun producer	
N° of coats	½ +1 cross coat	2 – 3 coats
Interval between coats	0 min.	2-3 min.
Recommended film thickness	30-40 µ	120-140 µ
Theoretical coverage	9,5 m <sup>2</sup> /l (35 µ)	4,4 m <sup>2</sup> /l (90 µ)

**DIR 2004/42/CE: Primer-Filler 2K IIB/c – VOC ready for use 540 g/l**  
**These products ready for use contain at most 540 g/l VOC**

### DRYING TIME

w/w system	MH440
<b>Air drying at 20°C</b>	
overcoatable after	5 min.
without sanding up to	5 days

It is possible to remove any possible pollution or spray dirt by wet sanding with soft P2000 emery cloth or by dry sanding with soft P800/1000 emery cloth when the surface is completely matt, before applying the colour. It is possible to apply a tape after 30 min. at 20°C.

d/d system	MH440
<b>Air drying 20°C:</b>	
Sanding	30-40 min.
<b>Low bake at 40°/50°C (Substrate's temperature):</b>	
Sanding	15-20 min.

### SANDING

Dry sanding with **P400-600** grit paper (on random orbital sanding machines)

### RECOMMENDED OVERCOATING

- MACROFAN HS TOPCOAT
- HYDROFAN / BSB + Refinish clearcoats from the Lechler product range

### NOTE

By mixing the 3 primers/sealers with each other it is possible to obtain the full grey scale. This allows you to optimise the covering power of the topcoat or to produce the same grey colour as the primer used originally by the Car Manufacturers.

**Example:** by mixing the primers/sealers in the following mixing ratios you approximately obtain the following grey scale

	Black	Grey 4	Grey 3	Light Grey	Grey 2	Grey 1	White
<b>MF410</b>	100	65	40		10	3	
<b>MF406</b>				100			
<b>MF402</b>		35	60		90	97	100

### TECHNICAL DATA SHEET N° 0739-GB UPDATED 07/2022

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