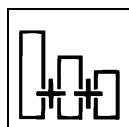
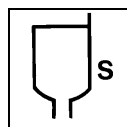




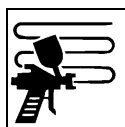
MAC 41 (M4001) MACROFAN PW UHS TOP COAT



MH100 Line
1000 ml +
600 ml +
150 ml
Pot life at 20° C:
15 to 90 min.



22"±28" DIN 4
at 20° C



Ø 1.2 – 1.3 mm
N° of coats:
½ + 1



Air drying at 20°C
Tack-free:
1.5 to 6 h
Through-drying: 12 h
Low bake at 60° C:
15 to 40 min.



5-6 min. flash-off
10-12 min. max. power
60-80 cm distance
Indicative values, which
can vary according to the
lamp model

DESCRIPTION

Ultra high solids topcoat in solid colours.

USE

For complete or partial painting and touch-ups of cars, commercial vehicles and buses.

CHARACTERISTICS

- Easy to apply with excellent flow
- Excellent covering power
- Excellent full-bodied film and aesthetical aspect
- Excellent light and weather resistance
- Fast drying and possible usage of extra rapid hardener on small parts and spot repairs
- Useable in High Efficiency Processes

SUBSTRATE PREPARATION

Apply MACROFAN PW UHS TOPCOAT on one of the following filler-sealers, duly dry sanded with P320/P400 paper and degreased with 00665 HYDROCLEANER SLOW / 00699 HYDROCLEANER:

- 04706-04710 MACROFAN HS HIGH FILLER or MAC71 MACROFAN HS COLOR HIGH FILLER
- MF602-06-10 MACROFAN HS GREEN-TECH FILLER or MAC6 MACROFAN HS COLOR GREEN-TECH FILLER
- 04001-04004-04007-04109 GREEN TI FILLER
- HS611 HYDROFAN 1K SEALER

or, in case of wet-on-wet system:

- MF302-06-10 MACROFAN AP AUTOLEVEL PRIMER or MAC81 MACROFAN HS COLOR AUTOLEVEL PRIMER
- 04122 HI-GARD SEALER or MAC 9 MACROFAN HS COLOR UNDERCOAT

In case of old coatings sand dry with P320/P400 paper or roughen up with grey Scotch-Brite and degrease with 00665 HYDROCLEANER SLOW / 00699 HYDROCLEANER.

APPLICATION

By high transfer spray and HVLP.

Mixing ratio:

AREAS SUBJECTED TO DIR. 2004/42/-CE

	By volume
MAC 41 MACROFAN PW UHS TOP COAT (derived from binder M4001)	1000 ml
MH100-MH110-MH115-MH120 MACROFAN UHS HARDENERS	600 ml
00740-00741-00742-00755 THINNERS AUTOREFINISHING	*150 ml

* Maximum thinning to remain below 420 g/l V.O.C.

Spray viscosity at 20 °C: 25" ± 3" DIN 4

AREAS NOT SUBJECTED TO DIR. 2004/42-CE	By volume
MAC 41 MACROFAN PW UHS TOP COAT (derived from binder M4001)	1000 ml
MH100-MH110-MH115-MH120 MACROFAN UHS HARDENERS	600 ml
00740-00741-00742-00755 THINNERS AUTOREFINISHING	150-250 ml

Use condition	MH100 T: over 30°C	MH110 T: 20-30°C	MH115 T: 15-25°C	MH120 Spot repairs
Pot life at 20 °C	2 h	90 min.	1 h	15 min.
Pot life at 30 °C	1 h	45 min.	30 min.	5 min.
Flash-off between coats	15 min.	10 min.	5 min.	0-2 min.
Final flash-off	15 min.	10 min.	5 min.	0-2 min.

Spray viscosity at 20 °C: 22" ± 3" DIN 4

Ø Air cap: conventional gun 1.2–1.3 mm; HVLP: 1.2–1.3 mm

Air pressure: according to the gun producer's instructions

Number of coats: ½ +1 regular

Suggested film thickness: 50 - 70 µ

Coverage (theoretic value): 1 l mixture = 10 m² at 50 µ

DIR 2004/42/CE: Topcoat IIB/d – VOC ready for use 420 g/l

This product ready for use contains at most 420 g/l VOC

DRYING TIME

	MH100	MH110	MH115	MH120
Air drying at 20 °C				
Dust-free	40 min.	35 min.	30 min.	25 min.
Tack-free	6 h	5 h	4 h	1,5-2 h
Through-dry	20 h	18 h	16 h	12 h
Low bake at 60 °C:				
Tack-free	40 min.	30 min.	20 min.	15 min.
IR drying:				
Flash-off	5-6 min.	Indicative values, which can vary according to the lamp model		
Max power	10-12 min.			
Distance	60-80 cm			

The complete hardening continues in the following 3-4 days.

POLISHING

	MH100	MH110	MH115	MH120
At 20°C after	24 h	24 h	18 h	14 h
At 60°C after	60 min.	50 min.	35 min.	30 min.

OBSERVATIONS

In case of drying at temperatures below 60°C, when the full hardness of the film is not yet achieved, aggressive conditions (washing, rain, heavy humidity condensations like dew and hoar-frost, smog, detergents and de-icing salt) should be avoided.

TECHNICAL DATA SHEET N° 0441/41-GB

UPDATED 03/2019

All information contained in this data sheet is the result of carefully controlled tests and is correct to the best of Lechler's knowledge at the time of issue. Since conditions of use are beyond the control of the manufacturer, information contained herein is without warranty, implied or otherwise, and final determination of the suitability of any information or material for the use contemplated and the manner of use is the sole responsibility of the user. FOR PROFESSIONAL USE ONLY.