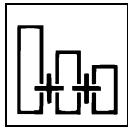




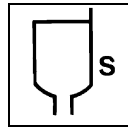
MAC 6 (M6000)

MACROFAN GREEN-TECH HS COLOR FILLER



MH100 Line 5:1:1
1000 ml +
200 ml +
150-350 ml

POWER Line 2:1:1
1000 ml +
500 ml +
500 ml



25-30" DIN 4
at 20° C
Pot life at 20°C:
15-60 min.

Pot life at 20°C
15 min.

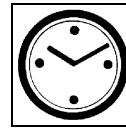


Ø 1,5-1,8 mm
N° coats: 2-3 with
flash-off between coats

One phase:
1 coat, 1 min. flash-off,
+ 2 consecutive coats
without flash-off

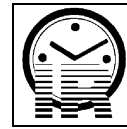


Sealer: 60-90 µ
Filler: 120-160 µ



Sanding:
at 20°C 1-3 h
at 60°C 15-30 min.
or

Sanding:
at 20°C 30-60 min.
at 60°C 5-10 min.



Distance : 70-80 cm
Half-power:
8-10 min.
5-7 min.
4-6 min.

DESCRIPTION

High Solids filler with "**Powertech**" technology, obtainable in all colours in combination with the Macrobases of the Macrofan HS System.

USE

Filler and sealer for all Car Refinish paintwork, especially when speed is an essential requirement. The product used in the "**Powertech**" version allows you to speed up the work and to maximise the energy saving by avoiding or reducing the use of the oven. Therefore this product is especially suitable for High Efficiency processes, where a high productivity and reduced energy consumption are required.

CHARACTERISTICS

- Good application and excellent vertical stability
- Excellent fast drying, both low bake and air drying
- Excellent filling and sealing power
- Good sanding
- Low topcoat absorption
- Good anticorrosive power (this product contains active pigments)
- Good adhesion also on electro-galvanised steel sheet
- Any grey shade (from white to black) of the filler can be obtained, thus helping the topcoat coverage and matching the colours of the fillers used in O.E.M.

SUBSTRATE PREPARATION

Knifing polyester putty: Sand with P120-180-240 grit paper and degrease with 00695 SILICONE REMOVER SLOW.

Steel, galvanised steel sheet, aluminium: The filler has a good adhesion on steel and electrolytically zinc-coated steel sheet with good anticorrosive power. However, on large areas and on bare metal sheet, it is recommended to treat the substrate, carefully sanded and cleaned, with **PW600 POWER WIPES AC PRIMER**, to ensure the suitable corrosion resistance.

Pre-existing coatings and new parts treated with cathodic coatings: Sand and degrease with 00665 HYDROCLEANER SLOW/00699 HYDROCLEANER. Wipe the bare metal sheet with **PW600 POWER WIPES AC PRIMER**. It is not recommended to apply on thermoplastic or solvent-sensitive coatings.

Plastic substrates (car sector): Apply MF302-06-10/MAC81, 04363 and MAC0.

SMC – PRFV: Sand with P120-180-240 grit paper and degrease with 00695 SILICONE REMOVER SLOW. In case of flexible substrates, add the plasticiser 09760 to the filler (max. 10% - see TDS n° 0281).

NOTES

The colours obtainable with MAC6 are available in Car Manufacturer sottotinte/undercoats, where you can find the colours recommended as undercoats in HYDROFAN finishes and the filler colours used by the Car manufacturers.

FILLERS

FILLER / SEALER (STANDARD PROCESS)

APPLICATION

By traditional spray gun or HVLP.

| | <i>T: 20-35°C</i> | <i>T: 15-25°C</i> | <i>Spot Repairs T: 15-25°C</i> |
|--------------------------|--------------------|-------------------|--------------------------------|
| HARDENERS | MH100-MH110 | MH115 | MH120 |
| Pot life at 20 °C | 60-40 min. | 30 min. | 20 min. |

| Mixing ratio: | Volume | Weight |
|---|---------------|---------------|
| MAC6 MACROFAN GREEN-TECH HS COLOR FILLER (derived from binder M6000) | 1000 ml | 1000 g |
| MH100-110-115-120 MACROFAN UHS HARDENER | 200 ml | 130 g |
| 00740-00741-00742 AUTOREFINISHING THINNERS | 150-350 ml | 100-200 g |

Spray viscosity at 20 °C: 25-30" DIN 4

Ø Conventional air cap and HVLP: 1,5-1,8 mm;

Pressure: as indicated by the gun producers

N° of coats: Sealer 2 coats; Filler 2-3 coats

Interval between coats: 5-8 min.

Recommended film thickness: **Sealer** 60-90 µ; **Filler** 120-160 µ

Theoretical coverage: 4.1 m² by 1 kg mixture at 80 µ; 5.2 m² by 1 l mixture at 80 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

| HARDENERS | MH100-MH110 | | MH115-MH120 | |
|--|--------------------|---------------|--------------------|---------------|
| | <i>Sealer</i> | <i>Filler</i> | <i>Sealer</i> | <i>Filler</i> |
| Air drying at 20°C (Object temperature): | | | | |
| Handling | 40 min. | | 30 min. | |
| Sanding (according to film thickness) | 1,5 - 2 h | 2 - 3 h | 1 - 1,5 h | 1 - 2 h |

Low bake at 60 °C (Object temperature):

| | | |
|---------------------------------------|--------------|--------------|
| Sanding (according to film thickness) | 25 – 30 min. | 15 - 20 min. |
|---------------------------------------|--------------|--------------|

IR Lamps (short waves):

| | | |
|--|-----------|----------|
| Distance | 70-80 cm | |
| Half-power (70°C temperature) | 8-10 min. | 5-7 min. |
| To verify according to film thickness and lamp model | | |

SANDING

Filler

Dry sand with P320/400 grit paper
(on random orbital sanding machine)

Sealer

Dry sand with P400/500 grit paper
(on random orbital sanding machine)

RECOMMENDED OVERCOATING

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

FILLERS

RAPID FILLER (POWER PROCESS)

APPLICATION

By traditional spray gun or HVLP.

| | |
|--------------------------|--------------------------------|
| | <i>Spot Repairs T: 15-25°C</i> |
| HARDENERS | MH600 |
| Pot life at 20 °C | 15 min. |

| Mixing ratio: | volume | weight |
|---|---------------|---------------|
| MAC6 MACROFAN GREEN-TECH HS COLOR FILLER (derived from binder M6000) | 1000 ml | 1000 g |
| MH600 MACROFAN POWER FILLER HARDENER | 500 ml | 330 g |
| MT600 MACROFAN POWER FILLER ADDITIVE | 500 ml | 270 g |

Spray viscosity at 20 °C: TIXO not measurable in DIN Cup 4

Ø Conventional air cap and HVLP: 1,5-1,8 mm

Pressure: as indicated by the gun producers

N° of coats: 2-3 coats

Interval between coats: not necessary for **2 coats**, apply two consecutive coats. **3 coats**: apply 1 coat, 1 min. flash-off, then apply 2 consecutive coats.

Recommended film thickness: **Sealer** 60 -90 µ; **Filler** 100-140 µ

Theoretical coverage: 4.1 m² by 1 kg mixture at 80 µ; 5.2 m² by 1 l mixture at 80 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

MH600 + MT600

Air drying at 20°C (Object temperature):

| | |
|---------------------------------------|--------------|
| Handling | 20 - 40 min. |
| Sanding (according to film thickness) | 30 - 60 min. |

Low bake at 60°C (Object temperature):

| | |
|---------------------------------------|-------------|
| Sanding (according to film thickness) | 5 - 10 min. |
|---------------------------------------|-------------|

IR Lamps (short waves):

| | | |
|-------------------------|----------|---|
| Distance | 70-80 cm | To verify according film thickness and lamp model |
| Half-power (temp. 70°C) | 4-6 min. | |

SANDING

Filler

Dry sand with P320/400 grit paper
(on random orbital sanding machine)

Sealer

Dry sand with P400/500 grit paper
(on random orbital sanding machine)

RECOMMENDED OVERCOATING

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

NOTE

Use POWER FILLER hardeners and activators only for use in combination with MACROFAN GREEN-TECH HS Filler.

TECHNICAL DATA SHEET N° 0441/60-GB

UPDATED 01/2018

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