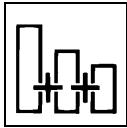


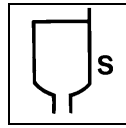


MAC1 (M1000) MACROFAN HS FAST



1000 ml +
500 ml +
150-300 ml

Pot life at 20° C:
4 - 5 h



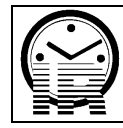
17 - 19° DIN 4
at 20° C



Ø 1.3 - 1.4 mm
3.5 - 4 Atm
HVLP:
1.3 - 1.4 mm
2 - 2.5 Atm
N° of coats: 2 - 3



Air drying at 20° C:
16 - 24 h
Low bake at 60° C:
30 min.



6-7' flash off
10-16' max power

DESCRIPTION

High solids two-pack finishing enamel in solid colours.

USE

For solid colour finishes of valuable manufactured items.

CHARACTERISTICS

- Good hiding power
- High solids
- Easy to apply and excellent flow
- Excellent light and weather resistance
- Excellent gloss
- Very fast drying
- Easy to polish and simple to retouch

SUBSTRATE PREPARATION

Apply the finishing MACROFAN TOPCOAT on one of the following filler-sealers, duly dry sanded with P 320 paper and degreased with 00695 SILICONE REMOVER SLOW:

- 04001-04004-04007-04109 GREEN TI FILLER
- MACROFAN FILLERS
- HS611 HYDROFAN 1K SEALER LIGHT GREY

or, for W/W system apply on:

- 04122 HI-GARD SEALER or MAC 9 HS COLOR UNDERCOATS SEALER
- MACROFAN FILLERS

In case of old coatings dry sand with P320 paper or with Scotch Brite grey and degrease with 00695 SILICONE REMOVER SLOW.

APPLICATION

Spray application by conventional or HVLP guns.

Mixing ratio:

MAC1 MACROFAN HS FAST (derived from binder M1000)
00362 - 00174 - 00379 HARDENER HS
00740 - 00741 - 00742 - 00755 THINNER AUTOREFINISHING

volume and weight

1000 parts
500 parts
150 – 300 parts

< 15°C	15-35°C	> 35°C
00174*	00362	00379

* 00174 hardener is suggested only for spot repairs.

Pot life at 20° C: 4 – 5 hours
Spray viscosity at 20° C: 17 – 19" DIN 4
Air cap Ø: conventional gun 1.3 – 1.4 mm; HVLP gun 1.3 – 1.4 mm
Air pressure: conventional gun 3.5 – 4 Atm; HVLP gun 2 – 2.5 Atm
Number of coats: 2 – 3
Interval between coats: 10 – 15 min.
Suggested film thickness: 50 – 60 µ
Coverage (theoretic value): 1 l mixture = 7-7.5 m² at 50 µ
1 kg mixture = 6.5-7 m² at 50 µ
V.O.C. R.F.U. (17-19" DIN 4): 550 g/l

DRYING TIME

Air drying at 20 °C:

Dust-free: 10 ÷ 15 min.
Tack-free: 6 ÷ 7 hours
Through-dry: 16 - 24 hours

Low bake at 60 °C:

30 min.

IR drying:

after 6-7 min. flash off
10-16 min. max power

The complete hardening keeps on in the following 3 - 4 days.

POLISHING

After 24 h at 20 °C or 1 h at 60 °C.

SPECIAL NOTE

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° 0441/1-GB
UPDATED 09/2016

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