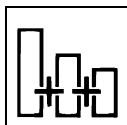
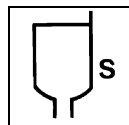


**CLEARCOATS****MC421 - MACROFAN PLUS
UHS CLEARCOAT 2:1**1000 ml +
500 ml +17-19" DIN 4
at 20°CØ 1,2-1,3 mm
2-2,5 Atm
N° coats: ½ + 1 or 2Low bake at 60°C:
15-20-30 min.4-7 min. flash-off
15-20 min. max. powerTime of use at 20°C :
25-50 min.At 20°C :
Handling : 3-7 h
Through-drying : 24-36 h**DESCRIPTION**

Ultra high solid two-pack acrylic clearcoat (V.O.C. < 420 g/l) with excellent aesthetical aspect and versatile use.

USE

Clearcoat for high quality two-coat metallic, mica/pearl and solid colour finishing, designed for touch-ups, partial and complete repair in car refinishing.

CHARACTERISTICS

- Easy use and application
- Wide-ranging use
- Fast drying
- Very good aesthetical aspect and gloss
- Very good weather resistance
- Good polishing

SUBSTRATE PREPARATION

Apply on surfaces already painted with HYDROFAN matt basecoats.

APPLICATION

Spray application by traditional or HVLP guns.

Mixing ratio:

MC421 MACROFAN PROF UHS CLEARCOAT
MH100-110-115-120 MACROFAN UHS HARDENERS

weight and volume

1000 parts
500 parts

AREAS NOT SUBJECTED TO DIR. 2004/42/CE

Optional addition: it is possible to add a maximum 5% of the thinners 00740-00741-00742-00755 THINNERS AUTOREFINISHING

Use conditions	Complete or partial painting T: 20-35°C	Side or partial painting T: 20-30°C	1-2 parts T: 15-25°C	Touch-ups T: 15-20°C
Hardener	MH100	MH110	MH115	MH120
Time of use at 20°C and 60% R.H.	50 min.	50 min.	35 min.	25 min.

All information here included is the result of carefully controlled tests and expresses our best and up to date knowledge. This news is given only as an information, so the firm cannot be accountable for further results. Furthermore it cannot be used as a contestation related to the use of the described product. All this is due to the fact that use conditions are not under our control.

IMPORTANT

- The product will have always to be at room temperature (18-20°C) before the mixing ratio in order to get the correct spray viscosity. Choose HARDENER (and THINNER) according to the temperature/substrate size and the ventilation system. In case of use of fast hardeners it is recommended to prepare the mixture only immediately before its use avoiding idle times.

Spray viscosity at 20°C: 17-19" DIN 4

Ø air cap: conventional: 1.2- 1.3 mm

Air pressure: conventional: 2 Atm (or as recommended by the producer)

Application methods:

2 regular coats – apply two regular coats, with 5-10 min. flash-off between coats (according to the temperature).

½ + 1 coat – apply one regular stretched coat. After 5 min. flash-off apply a uniform coat.

One coat – apply a wet uniform coat.

Suggested cycles	Standard (complete or partial painting)	Fast (Side or 2-3 panels)	Touch-ups (1 panel)
Hardeners (2:1)	MH100-MH110	MH115	MH120
Thinners (areas not subjected to dir. 2004/42/CE)	00742-00755	00741-00742	00740-00741
Dry film thickness	45-55 micron	40-50 micron	30-40 micron
Application	1 regular stretched coat on all parts followed by 1 full coat	1 light uniform coat on all parts followed by 1 full coat	1 only coat or 1 light coat + 1 uniform coat
Flash-off between coats	5-10 minutes	5-7 minutes	0 – 3 minutes
Final Flash-off	0-10 minutes	0-5 minutes	0 – 5 minutes

Theoretical coverage: 11,7 m² for 1 kg mixture at 40 µ; 12 m² for 1 lt mixture at 40 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		45 min.	35 min.	25 min.
Handling	Not recommended	6-7 h	4-5 h	3-4 h
Through-drying		24-36 h	24-36 h	24-36 h
Low bake at 60 °C object's temperature: (without flash-off)				
Handling	30 min.	30 min.	20 min.	15 min.
IR Lamps: (always follow the lamps producer's instructions, times and distances change according to the colour)				
Flash-off	6-7 min.	5-6 min.	4-5 min.	
Max. Power	18-20 min.	16-18 min.	15-17 min.	Not recommended
Distance	60-80 cm.	60-80 cm.	60-80 cm.	

The through-drying proceeds in the following 3-4 days.

AREAS NOT SUBJECTED TO DIR. 2004/42/CE

In order to accelerate the drying it is possible to add MT167 MACROFAN UHS SPEEDY ACCELERATOR by replacing the thinner up to the maximum percentage of 5%. This addition reduces the pot life of the prepared product.

CLEARCOATS

POLISHING

After 24 h air drying or after low baking wait about one hour until the car has reached the room temperature again (ca. 1 h), then remove any possible dirt and polish with Lechler abrasive paste and polish (see technical data sheets for polishing processes N° CL013 and following).

OBSERVATIONS

The painted car must not be exposed to severe conditions in the first days after the painting. Until the film has reached complete cross-linking, strong humidity condensation like dew and frost and contact with aggressive agents like smog, detergents, salt on the roads, must be avoided.

TECHNICAL DATA SHEET N° 0662-GB
UPDATED 07/2012

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