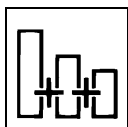


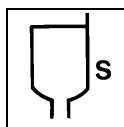


MAC 4 (M4000) MACROFAN ULTRA HS TOPCOAT

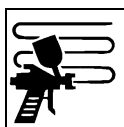


MH100 Line
1000 g +
600 g +
0-50 g

Pot life at 20°C:
30-90 min.



20-25" IDIN 4
at 20°C



Ø 1.3-1.4 mm
N° of coats: ½+1



Air drying at 20°C
Tack-free: 3-5-7 h
Through-drying: 24-36 h
Low bake at 60°C:
20-30-40 min.



5-6 min. flash-off
10-12 min. max. power
60-80 cm distance

DESCRIPTION

Ultra high solids topcoat in solid colours.

USE

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

CHARACTERISTICS

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

SUBSTRATE PREPARATION

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

- 04706-04710 MACROFAN HS HIGH FILLER o MAC71 MACROFAN HS COLOR HIGH FILLER
- 04806-04810 MACROFAN HS RAPID FILLER or MAC75 MACROFAN HS COLOR RAPID FILLER
- 04804 MACROFAN HS ISOSEALER or MAC85 MACROFAN HS COLOR ISOSEALER
- 04004-04109 GREEN TI FILLER
- HS611 HYDROFAN 1K SEALER

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

- 04804 MACROFAN HS ISOSEALER or MAC85 MACROFAN HS COLOR ISOSEALER
- 04122 HI-GARD SEALER or MAC 9 MACROFAN HS COLOR UNDERCOAT

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

APPLICATION

Spray application by conventional or HVLP guns.

Mixing ratio:

AREAS SUBJECTED TO DIR. 2004/42/CE

	ULTRA HS weight	UHS weight
MAC4 MACROFAN ULTRA HS (derived from binder M4000)	1000 g	1000 g
MH400-MH410-MH415 MACROFAN ULTRA HS HARDENERS	500 g	
MH100-MH110-MH115-MH120 MACROFAN UHS HARDENERS		600 g
00740-00741-00742-00755 THINNERS AUTOREFINISHING	*100-200 g	*0-50 g

* The maximum thinning to remain below 420 g/l V.O.C. is 150 g (with MH400), 200 g (with MH410-MH415) and 50 g (with MH100-110-115-120) per kg

AREAS NOT SUBJECTED TO DIR. 2004/42/CE	ULTRA HS weight	UHS weight
MAC4 MACROFAN ULTRA HS (derivato da binder M4000)	1000 g	1000 g
MH400-MH410-MH415 MACROFAN ULTRA HS HARDENERS	500 g	
MH100-MH110-MH115-MH120 MACROFAN UHS HARDENERS		600 g
00740-00741-00742-00755 THINNERS AUTOREFINISHING	100-350 g	50-250 g

Use condition	MH400-MH100-MH110 T: 25-35°C	MH410-MH115 T: 15-25°C	MH415-MH120 Spot repairs
Pot-life at 20 °C	1,5 h	1 h	30 min.

Spray viscosity at 20°C: 20-25" DIN 4

Air cap Ø: conventional gun 1,3-1,4 mm; HVLP gun 1,3-1,4 Atm

Air pressure: according to the gun producer's instructions

Number of coats: 1/2 + 1 full coat

Interval between coats: 10÷15 min.

Suggested film thickness: 50÷70 µ (1/2 +1 coats)

Coverage (theoretic value): 1 l mixture = 9-10 m² at 50 µ; 1 kg mixture = 9.5-10 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

	MH400-MH100-MH110	MH410- MH115	MH415-MH120
Air drying at 20°C:			
Dust-free	50 min.	40 min.	30 min.
Tack-free	6-7 h	5-6 h	3-4 h
Through-dry	24-36 h	24 h	24 h
Low bake at 60°C:			
Tack-free	40 min.	30 min.	20 min.
IR drying:			
Flash-off	5-6 min.		
Max power	10-12 min.		
Distance	60-80 cm.		

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

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

POLISHING

	MH400-MH100-MH110	MH410-MH115	MH415-MH120
At 20°C after	24 h	24 h	24 h
At 60°C after	60 min.	40 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.

NOTE

The binder M4000, used to realise the product MAC4, kept at temperature under – 10°C, tends to slightly crystallise; this phenomenon, by re-conditioning the product at temperature above 10°C, is reversible.

TECHNICAL DATA SHEET N° 0441/40-GB UPDATED 01/2012

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