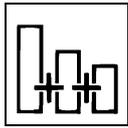




FILLERS

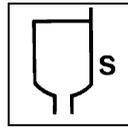


MF602 – MF606 – MF610
MACROFAN GREEN-TECH HS FILLER



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.

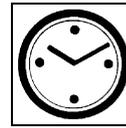


Ø 1,5-1,8 mm
N° coats: 2-3 with
flash-off between coats

One phase:
1 coat, 1 min. flash-off,
+ 2-3 consecutive coats
without flash-off

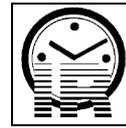


Sealer: 60-90 µ
Filler: 120-160 µ



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, available in three colours, White, Light Grey and Black.

USE

Filler and sealer for all Car Refinish paintwork, especially when speed is an essential requirement. The products use 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

Kniving 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 electrically 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

By mixing the 3 fillers with each other it is possible to obtain the full grey scale. This allows you to optimise the covering power of the topcoat or to produce the same colour grey as the primer used originally by the Car Manufacturers.

Example: by mixing the fillers in the following mixing ratios you approximately obtain the following grey scale:

	Black	Grey 4	Grey 3	Light Grey	Grey 2	Grey 1	White
MF610	100	65	40		10	3	
MF606				100			
MF602		35	60		90	97	100

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
MF602-6-10 MACROFAN GREEN-TECH HS FILLER	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.
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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
MF602-6-10 MACROFAN GREEN.-TECH HS FILLER	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.
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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°0703-GB UPDATED 01/2018

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