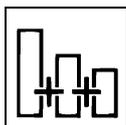


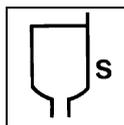


# MAC81 (M8011)

## MACROFAN AP COLOR AUTOLEVEL PRIMER



**Primer/Filler:**  
1000 g +  
110 g MH100 Line+  
100-300 g



**W/W system:**  
20-22" DIN4 20° C

**D/D system:**  
24-29" DIN4 20° C

Pot life at 20°C:  
30-120 min.



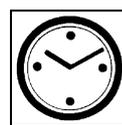
**W/W system:**  
Ø 1,2-1,4 mm  
N° coats: 1 or ½+1

**D/D system:**  
Ø 1,6-1,8 mm  
N° coats: 2-3



**W/W system:**  
30-50 µ

**D/D system:**  
100-120 µ



**W/W system:**  
after 15-30 min.

**D/D system:**  
after 3-5 h at 20°C  
15-30 min. at 60° C



**D/D system:**  
Flash off: 3-5 min.  
Max. power: 10-15 min.

### DESCRIPTION

2K polyacrylic high solid self-levelling primer/filler obtainable in all colours by using the binder M8011 in combination with the Macrobases of the Macrofan HS System.

### USE

**As a primer field in wet-on-wet system with direct adhesion on cathodic coated and plastic substrates in the motor vehicle repair market;** directly overcoatable without sanding (w/w up to 5 days) with finishing topcoats. Especially suitable for sealing new parts already primed with a cathodic coating and for all plastic substrates.

**As a sealer** in a higher build mode in dry-on-dry systems.

### CHARACTERISTICS

- Any grey shade (from white to black) of the primer/filler can be obtained, thus helping the topcoat coverage and matching the colours of the primers used in O.E.M.

#### PRIMER (w/w)

- Easy application and good vertical stability
- Excellent flow in w/w systems
- Excellent adhesion on the main substrates used on motor vehicles
- Excellent overcoating up to a maximum 5 days without sanding
- Fast drying

#### SEALER

- Anticorrosive power for small areas (it contains active pigments)
- Fairly good filling power in d/d system
- Good sanding
- Good sealing power on critical, solvent-sensitive substrates

#### PLASTIC PRIMER (w/w)

- It can be used as an adhesion promoter for all plastics used in the car field in combination with the dedicated hardener and activator

### RECOMMENDED OVERCOATING

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

### NOTES

The colours obtainable with MAC81 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 Producers in origin.

ATTENTION: when using the colour fans MACROFAN HS SYSTEM Primers&Fillers Colour Range for the coloured filler preparation, use the formulations indicated on the relevant table concerning MAC8 and replace the binder M8000 with M8011. Black fillers have a shorter pot life than other colours, therefore mix them with hardener when using.

## PRIMER/FILLER

### PRIMER / SEALER

#### SUBSTRATE PREPARATION

**New parts treated with cathodic coatings:** degrease with 00695 SILICONE REMOVER SLOW or 00665 HYDROCLENER SLOW / 00699 HYDROCLENER; if in good conditions no sanding is required.

**Steel, zinc-coated steel sheet, aluminium:** this product has a good direct adhesion on parts made of steel, zinc-coated steel sheet or aluminium; nevertheless, on large areas the application of 1-2 coats of 04318 FIX-O-DUR EC or 05720 MONOPRIMER is recommended.

**Old coatings:** dry sanding with P280-320 grit paper and degrease with 00665 HYDROCLENER SLOW / 00699 HYDROCLENER.

**Knifing polyester putty:** finish with P240 grit paper and degrease with 00695 SILICONE REMOVER SLOW or 00880 SILICONE REMOVER FAST

### 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>
<b>HARDENERS</b>	<b>MH100-MH110</b>	<b>MH115</b>	<b>MH120</b>
<b>Pot life at 20 °C</b>	2 h	1,30 h	30 min.

<b>Mixing ratio:</b>	<b>w/w system</b>	<b>d/d system</b>
<b>MAC81</b> MACROFAN AP COLOR AUTOLEVEL PRIMER	1000 g	1000 g
<b>MH100-110-115-120</b> MACROFAN UHS HARDENER	110 g	110 g
<b>00740-00741-00742</b> AUTOREFINISHING THINNERS	250-300 g	100-200 g

<b>Application parameters:</b>	<b>w/w system</b>	<b>d/d system</b>
Spray viscosity at 20 °C DIN 4	20-22"	24-29"
Ø conventional air cap and HVLP	1,2-1,4 mm	1,6-1,8 mm
Pressure	1,9-2,0 Atm	1,6-1,8 Atm
N° of coats	1 o ½ +1	2 – 3 coats
Interval between coats	0 min.	4-6 min.
Recommended film thickness	30-50 µ	100-120 µ
Theoretical coverage	9.1 m <sup>2</sup> /l	3,3 m <sup>2</sup> /l

**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 TIME

<b>w/w system</b>	<b>MH100</b>	<b>MH110</b>	<b>MH115</b>	<b>MH120</b>
<b>Air drying at 20°C</b>	30 min.	25 min.	20 min.	15 min.
<b>overcoatable after</b>	on matt substrate	on matt substrate	on matt substrate	on matt substrate
<b>Without sanding</b>	up to 5 days			

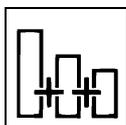
When the surface has gone completely matt, it is possible to remove defects or overspray with P2000 soft wet sanding paper or P800/1000 soft dry sanding paper before applying the topcoat colour. It is possible to apply adhesive tapes after 30 min. at 20°C.

<b>d/d system</b>	<b>MH100</b>	<b>MH110</b>	<b>MH115</b>	<b>MH120</b>
<b>Air drying 20°C (Substrate's temperature):</b>				
Sanding	4-6 h	4-6 h	4-5 h	3-5 h
<b>Low bake at 60 °C (Substrate's temperature):</b>				
Sanding	35 min.	30 min.	20 min.	15 min.
<b>IR lamps (short waves) 60-80 cm distance:</b>				
Flash-off	3-5 min.		Not recommended	
Max. power	10-15 min.			

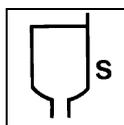
### SANDING

**One coat finishes:** dry sanding with P400 grit paper (on random orbital sanding machines), wet sanding with P500 abrasive paper

**Two-coat finishes:** dry sanding with P500 grit paper (on random orbital sanding machines), wet sanding with P600-800 abrasive paper

**PRIMER/FILLER**


**Plastic Primer:**  
1000 g +  
180 g MH300 +  
500 g MT300



**W/W system:**  
20-22" DIN4 20° C  
  
Pot life at 20°C:  
90 min.



**W/W system:**  
Ø 1,2-1,4 mm  
N° of coats: 1 or ½+1



**W/W system:**  
30-50 µ



**W/W system;**  
after 15-30 min.

**PLASTIC PRIMER**
**SUBSTRATE PREPARATION**

**Rigid external plastics: PP/EPDM, ABS, PC, PA, PVC, UP-GF, PBT, R-TBU, SMC, PUR (car field):** degrease with 00695, wet sand with 00695 SILICONE REMOVER SLOW or 00617 PLASTIC CLEANER, clean with 00695 and dry carefully with compressed air. For more information see the poster "**Treatment process of car plastic parts**" available onto our website.

**APPLICATION**

By traditional spray gun or HVLP.

	<b>MH300</b>
<b>Pot life at 20 °C</b>	1,5 h

<b>Mixing ratio:</b>	<b>w/w system</b>
<b>MAC81 MACROFAN AP COLOR AUTOLEVEL PRIMER</b>	1000 g
<b>MH300 MACROFAN PLASTIC PRIMER HARDENER</b>	180 g
<b>MT300 MACROFAN AUTOLEVEL PLASTIC ACTIVATOR</b>	500 g

**N.B.** Under special temperature conditions and according to the substrate size it is possible to dilute the product up to max.10% with AUTOREFINISHING THINNERS.

<b>Application parameters:</b>	<b>w/w system</b>
Spray viscosity at 20 °C DIN 4	20-22"
Ø conventional air cap and HVLP	1,2-1,4 mm
Pressure	1,9-2,0 Atm
N° of coats	1 or ½+1
Interval between coats	0 or 5-10 min.
Recommended film thickness	30-50 µ
Theoretical coverage	9.1 m <sup>2</sup> /l

**Product out of the directive 2004/42/EC**

**DRYING TIME**

<b>w/w system</b>	<b>MH300</b>
<b>Air drying at 20°C overcoatable after</b>	30 min. on matt substrate

When the surface has gone completely matt, it is possible to remove any defect or overspray with P2000 soft wet sanding paper or P800/1000 soft dry sanding paper before applying the finishing colour. It is possible to apply adhesive tapes after 60 min. at 20°C.

**NOTES**

The use of different hardeners and activators from the MH300 and MT300 ranges jeopardizes the primers adhesion on plastic substrates.

**TECHNICAL DATA SHEET N° 0441/81a-GB**  
**UPDATED 06/2016**

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