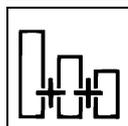




**CLEARCOATS**

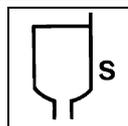


# MC405 - MACROFAN POWER UHS CLEARCOAT



1000 ml +  
500 ml +  
**100-150 ml**

Time of use at 20°C :  
20-45 min.



18-20" DIN 4  
at 20°C



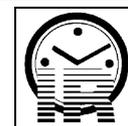
Ø 1,2 1,3 mm  
2- Atm  
N° coats: ½ + 1



Low baking:  
60°C: 15 -35 min.  
50°C: 20-45 min.  
**Power Process:**  
5 min. at 60°C  
10 min. at 50°C



A 20°C:  
Handling : 2-4 h  
Through-drying : 12-24 h



4 min. flash-off  
10 min. max. power

## DESCRIPTION

Two-pack UHS acrylic clear (VOC < 420 g/l) with quick drying and easy application.

## USE

Clearcoat for high quality mica, metallic and solid finishes, designed for touch-ups, partial and complete car repainting in Car Refinish.

Recommended suitable for small repairs; it allows you to optimise the process times/costs especially under some application conditions (low temperatures) and some equipment conditions (ineffective spray booths).

## CHARACTERISTICS

- Easy and flexible application, allowing good final results under all conditions
- High coverage
- Quick low bake drying, also allowing restricted processes and not optimum spray booth temperatures
- Good performance also by air drying
- Easy polishing
- Very good hardness and superficial slipperiness
- Very good gloss
- Very good weather resistance

## SUBSTRATE PREPARATION

Surfaces already painted with matt bases HYDROFAN Basecoat or BSB HS Basecoat.

## APPLICATION

Spraying and HVLP.

Mixing ratio (weight/volume)	Standard Process	Power Process
MC405 MACROFAN POWER UHS CLEARCOAT	1000 parts	1000 parts
MH100-110-115-120 MACROFAN UHS HARDENERS	500 parts	500 parts (MH120)
00740-00741-00742-00755 THINNERS AUTOREFINISHING	100-150 parts	
<b>MT405 MACROFAN POWER ADDITIVE</b>		150 parts

Use conditions	Complete or partial repainting T: 20-35°C	Side or partial repainting T: 20-30°C	1-2 parts T: 15-25°C	Spot Repairs T: 15-20°C	Power Process T: 15-20°C
Hardeners	MH100	MH110	MH115	MH120	MH120/MT405
Time of use at 20°C and 60% R.H.	45 min.	40 min.	30 min.	20 min.	15 min.

## IMPORTANT

Considering the characteristics of the product's rapidity it is recommended to prepare the mixture only immediately before its use avoiding idle times. It is also recommended to choose HARDENER and THINNER

according to the temperature / substrate size and to the ventilation system, by carefully mixing components after each addition.

Spray viscosity at 20°C: 18-20" DIN 4

Ø Air cap: 1.2- 1.3 mm or HVLP or conventional; Air pressure: as recommended by the producer

Application methods:

**2 regular coats** – apply two regular coats, with flash-off between coats as indicated in the table.

**½ + 1 coat** – apply one regular stretched coat. After flash-off apply one uniform and full coat

**One coat** – apply one wet uniform coat.

Suggested cycles	Complete or partial painting	Side or 2-3 panels	1-2 panels	Power Process ( 1 -2 panels )
Hardeners	MH100-MH110	MH110-MH115	MH120	MH120
Thinners (10-15%)	00742-00755	00742	00741-00742	MT405
Dry film thickness	45-50 micron	40-50 micron	30-40 micron	30- 40 micron
Application	1 regular stretched coat on all parts followed by 1 full coat	1 light and uniform coat on all parts followed by 1 full coat	1 coat or 1light coat + 1 uniform coat	1 coat or 1 light coat + 1 uniform coat
Flash-off between coats	5 -10 minutes	2 - 3 minutes	0 - 2 minutes	0 - 2 minutes
Final flash-off	0 –10 minutes	0 - 5 minutes	0 - 5 minutes	0 - 5 minutes

Theoretical coverage: 11,7 m<sup>2</sup> for 1 kg mixture at 40 µ; 12 m<sup>2</sup> 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 TIMES

	MH100	MH110	MH115	MH120	MH120/MT405
<b>Air drying at 20 °C</b>					
Dust-free	Not recommended	40 min.	30 min.	20 min.	10 min.
Handling		3-4 h	2-3 h	1,5-2 h	1-1,5 h
Through-drying		12-24 h	12-24 h	12-24 h	12-24 h

**Low bake at 60 °C object temperature:** (without flash-off)

Handling after	35 min.	30 min.	20 min.	15 min.	5 min.
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ENERGY SAVING PROCESS: heat the spray booth up to 60°C air temperature, then stop heating and leave the painted substrates in the spray booth until complete cooling.

**Low bake with restricted drying at 40-50°C object temperature** (without flash-off)::

Handling after	45 min.	40 min.	30 min.	20 min.	10 min.*
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\*Power Process: after this table time it is enough to wait ca. 1 hour before handling the substrate

**IR Lamps:** (always follow the lamps producer's instructions, times and distances change according to the colour)

Flash off	5-6 min.	4-5 min.	3-4 min.	Not recommended	Not recommended
Max. power	10-12 min.	10-12 min.	8-10 min.		
Distance	60-80 cm.	60-80 cm.	60-80 cm.		

The through-drying keeps on in the following 3-4 days

## POLISHING

After 18 h air drying or after through-drying by 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 the 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° 0693-GB UPDATED 06/2015

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