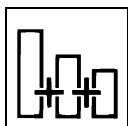


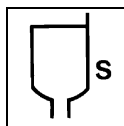
**PRIMER/FILLER**

MAC81 (M8011)

MACROFAN AP COLOR AUTOLEVEL PRIMER



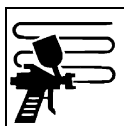
Primer/Filler:
1000 g +
110 g MH100 Line+
100-300 g



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 HYDROCLEANER SLOW / 00699 HYDROCLEANER; 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 HYDROCLEANER SLOW / 00699 HYDROCLEANER.

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

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

Application parameters:	w/w system	d/d system
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 ² /l	3,3 m ² /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

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

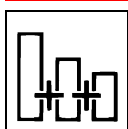
When the surface has gone completely matt, it is possible to remove defects or overspray with P2000 soft wet sanding paper or P800/1000 soft dry sanding paper before applying the topcoat colour. It is possible to apply adhesive tapes after 30 min. at 20°C.

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

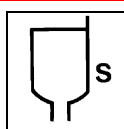
SANDING

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

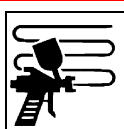
PRIMER/FILLER

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



W/W system:
20-22" DIN4 20° C

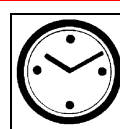
Pot life at 20°C:
90 min.



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.

	MH300
Pot life at 20 °C	1,5 h

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

Application parameters:	w/w system
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 m²/l

Product out of the directive 2004/42/EC

DRYING TIME

w/w system	MH300
Air drying at 20°C overcoatable after	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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