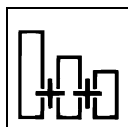
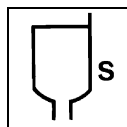
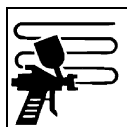




Technical Data Sheet n° 0723-GB

CLEARCOATS**MC404 - MACROFAN AVANTAGE
UHS CLEARCOAT**1000 ml +
500 ml +
100-200 ml15-20" DIN 4
at 20°CØ 1,2 1,3 mm
2- Atm
N° coats: ½ + 1Low baking:
60°C: 15 -35 min.
40-50°C: 20-45 min.At 20°C:
Handling: 1,5-4 h
Through-drying: 12-24 h4-6 min. flash-off
10-12 min. max. power**HT:**
See table14-17" DIN 4
at 35°CAccording to the lamps
producer's instructions**DESCRIPTION**

Two-pack UHS acrylic clear (VOC < 420 g/l) with a wide range of application and quick drying. The great application versatility of this product and its HT version make it suitable for the most extreme application conditions (temperatures >35°C).

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 critical application conditions as regards environment (high temperatures) and equipment (spray booths with high air flow).

CHARACTERISTICS

- Extremely easy and flexible in application, it allows you to obtain excellent final results under all environment conditions
- High coverage
- Fast drying by low baking, also in restricted drying processes and not optimum temperatures in all types of spray booths
- Good performance also by air drying
- Good polishing
- Very good hardness and surface slipperiness
- Very good gloss
- Very good weather resistance

SUBSTRATE PREPARATION

Surfaces already painted with matt bases from the systems HYDROFAN HE Basecoat or BSB HS Basecoat.

MIXING RATIO

Mixing ratio (weight/volume)	Standard Process	HT Process
MC404 MACROFAN AVANTAGE UHS CLEARCOAT	1000 parts	1000 g
MH110-115-120 MACROFAN UHS HARDENERS	500 parts	
MH404 MACROFAN AVANTAGE CLEAR HT HARDENER		500 g
MT404 MACROFAN AVANTAGE CLEAR HT ADDITIVE		250 g
00740-00741-00742-00755 THINNERS AUTOREFINISHING	100-200 parts	(100 g 00742)*

*NOTE: under special climate and/or surface conditions it is possible to add 00742 to the mixture of the HT process.

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

Use conditions	HT PROCESS		STANDARD PROCESS		
	1-2 parts T: >30°C	Complete or partial painting T: 20-30°C	Side or partial painting T: 20-30°C	1-2 parts T: 15-25°C	Fast Repair T: 15-25°C
Hardener	MH404 / MT404 / (00742/755)		MH110 / 00742	MH115 / 00742-1	MH120 / 00741
Time of use at 20°C and 60% R.H.	90 min.		40 min.	30 min.	20 min.
Spray viscosity	35°C 14-17" DIN 4		20°C 15-20" DIN 4	20°C 15-20" DIN 4	20°C 15-20" DIN 4

APPLICATION

Conventional spraying and HVLP.

Ø Air cap: 1.2- 1.3; Air pressure: as recommended by the producer

Theoretical coverage: 11,7 m² for 1 kg mixture at 40 µ; 12 m² for 1 l mixture at 40 µ

Apply as indicated on the table: 1 coat, 1,5 coat or 2 coats

Suggested cycles	Complete or partial painting T >30°C	Side or 2-3 panels	1-2 parts	Fast Repair
Application	1 regular stretched coat on all parts followed by 1 full coat	1 uniform coat on all parts followed by 1 full coat	1 uniform coat on all parts followed by 1 full coat	1 coat or 1 thin coat + 1 uniform coat
Flash-off between coats	5 -10 minutes	2 - 5 minutes	2 - 3 minutes	0 - 2 minutes
Final flash-off	0 -10 minutes	0 - 5 minutes	0 - 5 minutes	0 - 3 minutes
Dry film thickness	45-50 micron	40-50 micron	40-50 micron	30- 40 micron

DRYING TIMES

	MH404 / MT404	MH110	MH115	MH120
Air drying at 20 °C				
Dust-free	40 min.	40 min.	30 min.	20 min.
Handling	3-4 hours	3-4 hours	2-3 hours	1,5-2 hours
Through-drying	12-24 hours	12-24 hours	12-24 hours	12-24 hours

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

Handling after	35 min.	30 min.	20 min.	15 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.
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IR Lamps: (always follow the lamps producer's instructions, times and distances change according to the model and the colour)

Flash-off	5-6 min.	4-5 min.	4-5 min.	3-4 min.
Max. power	10-12 min.	10-12 min.	10-12 min.	8-10 min.
Distance	60-80 cm.	60-80 cm.	60-80 cm.	60-80 cm.

The through-drying continues 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).

CLEARCOATS

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° 0723-GB

UPDATED 06/2019

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