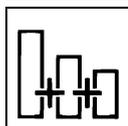
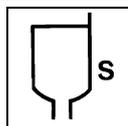


**CLEARCOATS****MC404 - MACROFAN AVANTAGE  
UHS CLEARCOAT**

1000 ml +  
500 ml +  
100-200 ml

**Hi-Tech:**  
See table



16-19" DIN 4  
at 20°C

**Hi-Tech:**  
See table



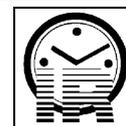
Ø 1,2 1,3 mm  
2- Atm  
N° coats: ½ + 1



Low baking:  
60°C: 15 -35 min.  
40-50°C: 20-45 min.



At 20°C:  
Handling: 1,5-4 h  
Through-drying: 12-24 h



4-6 min. flash-off  
10-12 min. max. power

According 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**

The product can be available in the two following versions:

➤ **STANDARD PROCESS**

➤ **Hi-Tech PROCESS**

## MIXING RATIO - STANDARD PROCESS

	weight or volume
MC404 MACROFAN AVANTAGE UHS CLEARCOAT	1000 parts
MH110-115-120 MACROFAN UHS HARDENERS	500 parts
00740-00741-00742-00755 THINNERS AUTOREFINISHING	100-200 parts

NOTE: 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	Side or 2-3 panels T: 20-30°C	1-2 panels T: 15-25°C	Fast Repair T: 15-25°C
Hardener	MH110	MH115	MH120
Thinner	00742	00740-1	00740
Time of use at 20°C and 60% R.H.	40 min.	30 min.	20 min.
Spray viscosity at 20°C	16-19" DIN 4		

## APPLICATION

Conventional spraying and HVLP.

Ø Air cap: 1.2- 1.3 mm

Air pressure: as recommended by the producer

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

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

Suggested cycles	Side or 2-3 panels	1-2 parts	Fast Repair
Application	1 uniform coat on all parts followed by 1 full coat		1 coat or 1 thin coat + 1 uniform coat
Flash-off between coats	2 - 5 minutes	2 - 3 minutes	0 - 2 minutes
Final flash-off	0 - 5 minutes		0 - 3 minutes
Dry film thickness	40-50 micron		30- 40 micron

## DRYING TIMES

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

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

Handling after	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	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	4-5 min.	4-5 min.	3-4 min.
Max. power	10-12 min.	10-12 min.	8-10 min.
Distance	60-80 cm.	60-80 cm.	60-80 cm.

The through-drying continues in the following 3-4 days.

## CLEARCOATS

### MIXING RATIO - Hi-Tech PROCESS

	weight
<b>MC404 MACROFAN AVANTAGE UHS CLEARCOAT</b>	1000 g
<b>MH404 MACROFAN AVANTAGE CLEAR HT HARDENER</b>	500 g
<b>MT404 MACROFAN AVANTAGE CLEAR HT ADDITIVE or MT404-405 HT ADDITIVE-POWER ADDITIVE (50-50)</b>	250 g

**NOTE: 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	<i>T: &gt;30°C</i>	<i>T: 20-30°C</i>
<b>Hardener</b>	<i>MH404</i>	
<b>Additive</b>	<i>MT404</i>	<i>MT404 / MT405 (50/50)</i>
<b>Time of use at 20°C and 60% R.H.</b>	60 min	90 min.
<b>Spray viscosity</b>	35°C: 14-17" DIN 4	20°C: 16-19" DIN 4

### APPLICATION

Conventional spraying and HVLP.

Ø Air cap: 1.2- 1.3 mm

Air pressure: as recommended by the producer

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

Suggested cycles	Complete or partial painting	Side or 2-3 panels	1-2 parts
<b>Application</b>	1 regular stretched coat on all parts followed by 1 full coat		
<b>Flash-off between coats</b>	5 -10 minutes	2 - 5 minutes	2 - 3 minutes
<b>Final flash-off</b>	0 –10 minutes	0 - 5 minutes	
<b>Dry film thickness</b>	45-50 micron		

### DRYING TIMES

	<i>MT404</i>	<i>MT404 / MT405</i>
<b>Air drying at 20 °C</b>		
Dust-free	<i>40 min.</i>	<i>20 min.</i>
Handling	<i>3-4 hours</i>	<i>2-3 hours</i>
Through-drying	<i>12-24 hours</i>	<i>12-18 hours</i>

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

Handling after	35 min.	30 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.
Max. power	10-12 min.	10-12 min.
Distance	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).



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## **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 06/2021**

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