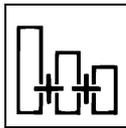


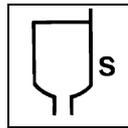


HS626 HYDROFAN 2K HB SURFACER LIGHT GREY



1000 g+
100 g +
100-300 g

Pot life at 20° C:
2 h



25-65"
DIN 4
at 20°C



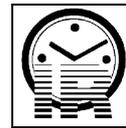
Ø 1,5-1,8 mm
2 Atm

N° coats: 2-3



Air drying at 20°C:
Handling: 40-60'
Sanding: 2-3 h

Low bake at 60°C:
20-30 min.



Flash-off: 5'
Half-power 8-10 min.



Always use DPI

DESCRIPTION

Two-pack, very fast drying, water-borne primer filler/sealer with great safety of application for painting processes with very low solvent emission.

USE

Primer filler/sealer for all car repair works, suitable both for touch-ups and whole panels as well as for complete painting.

CHARACTERISTICS

- Good application and very good vertical stability
- Excellent speed of drying, in the air and by low baking, along with a long pot life (decoupling)
- Very good filling and sealing power
- Very good sanding
- Low absorption of the finishes
- Good anticorrosive power (it contains active pigments)

SUBSTRATE PREPARATION

Knifing polyester putties: finish with P120-P180-P240 abrasive paper and degrease with 00695 SILICONE REMOVER SLOW.

Steel, zinc-coated steel sheet, aluminium: the primer filler has good adhesion and good anticorrosive power on different metallic substrates. To further improve the resistance to corrosion on large surfaces it is possible to treat the substrate, suitably sanded and cleaned, with 04318 FIX-O-DUR EC or 05720 MONOPRIMER.

Old coatings and cathodic coated new parts: sand and degrease with 00665 HYDROCLEANER SLOW / 00699 HYDROCLEANER. Treat bare metal parts with 04318 FIX-O-DUR EC or 05720 MONOPRIMER.

Plastic substrates (car field): apply MF302-06-10/MAC81 (Plastic Primer version), 04363 or MAC0.

SMC – PRFV: sand with P180-P240-P320 abrasive paper and degrease with 00695 SILICONE REMOVER SLOW.

APPLICATION

By high transfer pneumatic spray or HVLP.

Mixing ratio:

	weight
HS626 HYDROFAN 2K HB SURFACER LIGHT GREY	1000
HH930 HYDROFAN HF HARDENER	100
00089 DESALTED WATER	* 100 to 300

*The quantity of 00089 can vary according to weather conditions or user's needs

N.B. It is recommended to thoroughly mix after adding the hardener HH930.

Pot life at 20°C: 2 h
Spray viscosity at 20°C: 25-65" DIN4
Ø High transfer nozzle and HVLP: 1,5-1,8 mm
Pressure: according to spray gun producer's instructions
N° of coats: 2-3
Interval between coats: 10 minutes
Film thickness: sealer: 80-120µ
Theoretical coverage at 80µ: 4 m²/kg; 4,7 m²/l

DIR 2004/42/CE: Primer-Filler 2K IIB/c – VOC ready for use 540 g/l
This product ready for use contains at most 70 g/l VOC

DRYING

The product allows you to apply in complete safety (no popping) and to combine a flash-off allowing an easy application even at high temperatures on large surfaces with a fast reaction with the hardener. This allows a quick cross-linking and a consequent quick achievement of sanding and drying properties. All this together with a long pot life (decoupling).

Air drying at 20 °C:

Handling: 40 - 60 min
Sanding: 2 - 3 h

Low baking at 60°C (substrate temperature):

Sanding: 20 - 30 min.

IR lamps (always observe the producer's instructions):

Distance: 60-80 cm
Flash-off: 5 min.
Half-power (70°C): 8-10 min.

To verify according to film thicknesses and lamp model

SANDING

Primer filler: dry with P360/400 abrasive paper (random orbital sanding machine)
Sealer: dry with P400 abrasive paper (random orbital sanding machine)

OVERCOAT WITH

- Full water painting process: HYDROFAN + HC200 HYDROFAN HI-TECH CLEARCOAT
 - MACROFAN HS TOPCOAT or HYDROFAN + UHS Clearcoats from the Refinish Lechler range
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NOTES

KEEP AWAY FROM FROST: store at temperatures between +5 ÷ +35°C. Guaranteed stability: 12 months.

TECHNICAL DATA SHEET N° 0680-GB
UPDATED 10/2021

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