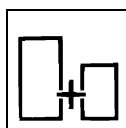




# HS611 - HYDROFAN 1K SEALER LIGHT GREY



1000 ml +  
0-150 ml



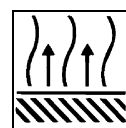
Ø 1,3-1,7 mm  
3-3,5 Atm  
HVLP: 2-2,5 Atm



40-100 µ



**D/D cycle:**  
2-4 h at 20° C  
30 min. at 60° C



**W/W cycle:**  
20-30 min. at 20° C  
50% R.H. and by 8 h



+5- +35° C

N° of coats: 2-3

## DESCRIPTION

One-pack water-thinnable filler/sealer of light grey colour.

## USE

Quick drying sealer for touch-ups, partial car paintings, or suitable to seal new car parts in car refinishing.

## CHARACTERISTICS

- Easy to use and good vertical hold
- Good adhesion to:
  - Steel
  - Zinc-coated steel sheet EG and HDG
  - Aluminium and light alloys
  - Fibreglass
  - Old coatings
  - ABS – PC – PRFG (car field). On other plastics apply a specific adherence primer
- Excellent sealing power on solvent sensitive coatings
- Possible tinting with Hydrofan basecoats
- Low top coat absorption
- Good filling power
- Quick drying
- Good wet and dry sanding
- Fairly good anti-corrosive power (the product contains active pigments)

## SUBSTRATE PREPARATION

**Steel:** degrease with 00695 SILICONE REMOVER SLOW, sanding with dry grit paper P120-180, blowing.

**Zinc-coated steel-sheet EG:** degrease with 00695 SILICONE REMOVER SLOW, sand with Scotch-brite red and blow.

**Zinc-coated steel sheet HDG, FGRP:** sand with P180-220 grit paper and degrease with 00695 SILICONE REMOVER SLOW.

**Old coatings:** sand with P180-220 grit paper or Scotch-brite grey and degrease with 00665 HYDROCLEANER SLOW / 00699 HYDROCLEANER.

**Aluminium and light alloys:** sand with P180 grit paper or Scotch-brite red and degrease with 00695 SILICONE REMOVER SLOW.

**ABS and plastic substrates:** degrease with 00617 PLASTIC CLEANER, rub / sand and clean with 00617 PLASTIC CLEANER.

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## APPLICATION

Spray application by traditional or HVLP guns.

Mixing ratio:	by weight or by volume	
	D/D system	W/W system
HS611 HYDROFAN 1K SEALER LIGHT GREY	1000 parts	1000 parts
00089 DESALTED WATER	0-100 parts	0-150 parts

**It is possible to tint the product with Hydrofan basecoats until a 10% maximum**

Air pressure: 3-3,5 Atm; HVLP 2-2,5 Atm

Ø Air cap: W/W system 1,2-1,4 mm; D/D system 1,5-1,7 mm

Number of coats: W/W system ½ + 1 coat; D/D system 2-3 coats

Interval between coats: allow the surface to get uniform matt

Recommended film thickness: 30 - 100 µ

Theoretical coverage: 1 l = 7 m<sup>2</sup> by 60 µ

**DIR 2004/42/CE: Primer IIB/c – VOC ready for use 540 g/l**

**This product ready for use contains at most 181 g/l VOC**

Recommended application conditions: Temperature +18 - +25°C - Relative Humidity: 40 - 70%.

Temperature and humidity are decisive factors for the application of the subsequent coats as well as for the sanding.

N.B.: For spot retouches it is recommended to widen the first coat application beyond the spot self and to apply the following coats inside the first coat (and not viceversa); this avoids possible gradations by sanding the filler HS611.

It is recommended, moreover, due to the different nature of OEM manufacturers, to apply on bare areas, suitable adherence and sealing primers for plastic or metallic substrates, before applying HS611.

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## DRYING TIME

### D/D System:

#### **Air drying at 20°C**

Dust-free: 30 - 40 min.

Tack-free: 60 - 90 min.

Sand after 2-4 hours (according to film thickness and relative humidity)

#### **Low bake at 60°C:**

Sanding after 30 min.

### W/W System:

Overcoating after 20-30 min. at 20°C, 50% relative humidity and by 8 hours

N.B.: to speed up the water evaporation it is possible to use blowers.

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## SANDING

Dry or wet sanding.

**One-coat** finishes: sand with P320 grit paper.

**Two-coat** finishes: sand with P400 grit paper.

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## OVERCOATINGS

- HYDROFAN + UHS Refinish clearcoats of Lechler range
  - MACROFAN HS TOPCOAT
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## SPECIAL NOTE

KEEP WARM. Store at +5 - +35°C. Guaranteed storage stability: 12 months.

## TECHNICAL DATA SHEET N° 0645-GB

UPDATED 12/2012

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