AGILIS BASE

HB 010

Mixing clear for AGILIS Basecoat

Application:

AGILIS BASE HB 010 is used for mixing effect colors. AGILIS BASE HB 030 is used for mixing solid colors and effect colors with low effect content.
AGILIS BASE HB 010X is used for mixing effect colors at high temperatures, low humidity or on big surfaces. AGILIS BASE HB 030X is used for mixing solid colors and effect colors with low effect content at high temperatures, low humidity or on big surfaces.
Wet-on-wet process with R-M clears.

Key Features:

Water-thinnable, less than 6% organic solvents (ready for use).

Remarks:

- Mixing formulas with AGILIS BASE HB 010 / AGILIS BASE HB 030 / AGILIS BASE HB 010X / AGILIS BASE HB 030X and mixing bases are available to cover the whole range of colours needed in automotive refinishing.
- For high temperatures, low humidity or big surfaces the mixing bases AGILIS BASE HB 010, AGILIS BASE HB 030 and the reducer AGILIS MIX RA 050 can be exchanged by the products AGILIS BASE HB 010X, AGILIS BASE HB 030X and AGILIS MIX RA 050X.
- Use HB 010 / HB 030 only mixed with AGILIS base colors and AGILIS MIX RA 050.
- Use HB 010X / HB 030X only mixed with AGILIS base colors and AGILIS MIX RA 050X.
- Mixtures will keep for up to 3 months when stored in corrosion-resistant (plastic or internally coated) closed cans.
- Ready for use mixtures will keep for up to 3 weeks when stored in corrosion-resistant (plastic or internally coated) closed cans.
- Flash-off times can be reduced significantly by using appropriate air blow equipment.
- Please refer to the INFO R-M module “R-M AGILIS” for further details and information about application processes.

Storage temperature 5-40 °C

Safety advice:
2004/42/IIB(d)(420)249: The EU limit value for this product (product category: IIB.d) in ready to use form is max 420 g/litre of VOC. The VOC content of this product is 249 g/litres.
The products are suitable for professional use only.
It cannot be ruled out that this product contains particles < 0.1 µm.
For the use of this product please adhere to the actual safety recommendations and the personal protective equipment.

The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our products, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the products for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein are for general information purpose only; they may change without prior information and do not constitute the agreed contractual quality of the products (product specification). The latest version supersedes all previous versions.
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R-M Automotive Refinish Paints, Z.I.du Merret F-60676 Clermont de l'Oise Cedex,
Tel. (+33) (0) 3 44 77 77 77

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Cleaning

Sand with P400 / P500, resp. with P500 / P600 for effect colors. The final sanding should be carried out with an interface pad in order to achieve the best results. Clean with R-M waterborne cleaner (base-/topcoat). Alternative: apply to R-M wet-on-wet filler or sealer.

VOC ready for use	249 g/l	
	2:1	
Mixing Ratio	100 % by volume	HB 010 Mixing clear for AGILIS Basecoat HB 010X Mixing clear for AGILIS Basecoat HB 030 Mixing clear for AGILIS Basecoat HB 030X Mixing clear for AGILIS Basecoat Solids or Metallics (acc. to mixing formula)
Thinner	50 % by volume	RA 050 Thinner RA 050X Thinner (acc. to mixing formula) Stir IMMEDIATELY after adding.

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	HVLP spray gun	Compliant gravity-feed spray gun
Application pressure		2 bar
Nozzle size		1.3-1.4
Number of spray coats	1 full coat + 1 "Finish coat" applied wet-on-wet	
Flash off at 20°C	Flash-off until the surface is completely mat after the "Finish coat".	
Film thickness	10-15 µm	
Application Remark	Spraying pressure = Inlet pressure The setup depends on the spray gun supplier, please refer to the INFO R-M module "BASIC KNOWLEDGE - BODYSHOP EQUIPMENT" for detailed information.	

	Drying	
	Infrared (short wave)	Surface temperature 40 – 50°C (max. 60°C) until mat surface + cooling.

Remark Apply one of the recommended R-M clears.

Please note: For automotive refinish, repair instructions of vehicle manufacturers, in particular regarding installed sensor technology, must always be observed in addition to the processing instructions given within this document.

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