

## BLEND'ART

### Blend-in repair with ONYX HD on the panel being repaired

#### A 2.2

#### Process description

BLEND'ART is a universally suitable system of three processes, providing solutions for all types of blend-in repairs. This process for blend-in repairs on the panel being repaired using ONYX HD has been developed for professional refinish centers. The goal is to reliably achieve invisible repairs for all shades of the color range.

#### Substrates

- R-M fillers
- Automotive OEM finishes, fully cured and solvent-resistant
- Refinishes, fully cured and solvent-resistant

#### Products required

- PK 1000 / 2000
- ONYX HD
- ONYX EASY BLENDER A 2520
- HYDROMIX
- RAPIDCLEAR C 2570
- BLENDING FLASH

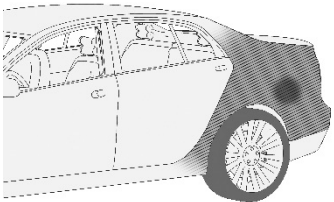
#### Safety instructions

It cannot be ruled out that these products contain particles < 0.1 µm.

The products are suitable for professional use only.

For the use of these products please adhere to the actual safety recommendations and the personal protective equipment.

#### Pre-treatment

	<ol style="list-style-type: none"><li>1) Sanding of filler patch Degrease with PK 1000. Sand with P400 / P500, then P1000 so as to remove filler overspray from the surrounding areas.</li><li>2) Sanding of ONYX HD blending area Sand with P1000 – P2000.</li><li>3) Polishing of RAPIDCLEAR C 2570 melt-in zone Polish with any standard fine polishing compound and a moist, medium-hard sponge. Degrease with PK 2000.</li></ol>
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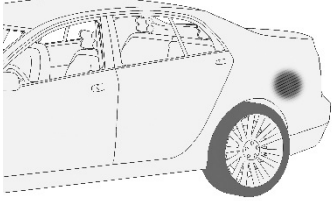
R-M Automotive Refinish Paints, Z.I. du Merret F-60676 Clermont de l'Oise Cedex, Tel. (+33) (0) 3 44 77 77 77, 10/2015

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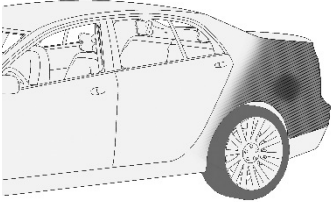
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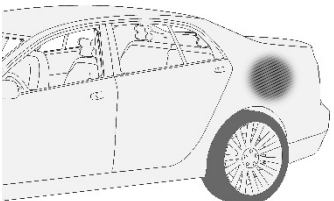
#### 1) Hiding the filler patch

	<b>Mixing ratio:</b>	ONYX HD HYDROMIX	100% by vol. 60% by vol.
	<b>Spraygun:</b>	1.4 – 1.5 mm HVLP	
	<b>Pressure:</b>	1.0 – 1.5 bar	
	<b>Application:</b>	1 or 2 coats until the filler patch is almost invisible.	
	<b>Flash-off:</b>	Flash off until mat.	

#### 2) Applying ONYX EASY BLENDER A 2520

	<b>Mixing ratio:</b>	ONYX EASY BLENDER A 2520 HYDROMIX / HYDROMIX SLOW	100% by vol. 60% by vol.
	<b>Spraygun:</b>	1.4 – 1.5 mm HVLP	
	<b>Pressure:</b>	2.0 bar	
	<b>Application:</b>	1 spraycoat	
	<b>Flash-off:</b>	not necessary	

#### 3) Blending into the surrounding area and applying the ONYX HD effect coat

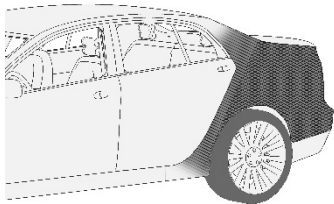
	<b>Mixing ratio:</b>	ONYX HD / HYDROMIX (ready for use)	100% by vol.
		ONYX EASY BLENDER A 2520 / HYDROMIX (ready for use)	100% by vol.
	<b>Spraygun:</b>	1.4 – 1.5 mm HVLP	
	<b>Pressure:</b>	1.0 – 1.5 bar	
	<b>Application:</b>	2 or 3 thin spraycoats, fading out into the surrounding area.	
<b>Flash-off:</b>	Flash off until mat. 1 thin coat to match the effect.		

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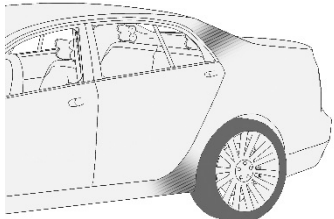
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#### 4) RAPIDCLEAR C 2570

	<b>Mixing ratio:</b> RAPIDCLEAR C 2570*	300% by vol.
	H 2550	100% by vol.
	R 2200	100% by vol.
	* Option CHRONOLUX CP	
	<b>Spraygun:</b> 1.4 – 1.5 mm HVLP	
<b>Pressure:</b> 2.0 bar		
<b>Application:</b> 1 thin and 1 full spraycoat, overlapping.		
<b>Flash-off:</b> No flash-off between coats.		

#### 5) BLENDING FLASH

	<b>Spraygun:</b> 1.4 – 1.5 mm HVLP
	<b>Pressure:</b> 1.5 – 2.0 bar
	<b>Application:</b> 2 – 3 spraycoats to melt in the RAPIDCLEAR C 2570 fade-out area.
	<b>Drying:</b> 10 min at 60°C