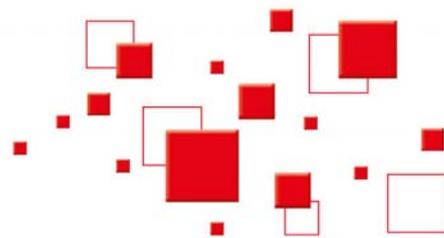


ONYX HD

Blending process for four-coat systems

B 3.2



Process description

This blending process allows achieving almost invisible paintwork repairs. In the case of three- or four-coat systems, there must be a sufficiently large area on which to fade out. This is why blending in within one panel is not suitable. The process we recommend instead is blending in on the adjacent panel.

The color of four-coat finishes depends on the thickness of the film applied in step 3. In order to find the matching color, you should prepare spray-out samples with different numbers of spraycoats (two to four). These spray-out samples will clearly show how the film thickness applied in step 3 will actually influence the final color.

Substrates

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

Products required

- ONYX HD precoat / see step 1 of the mixing formula
- ONYX HD basecoat / see step 2 of the mixing formula
- ONYX HD basecoat / see step 3 of the mixing formula
- Selected clear

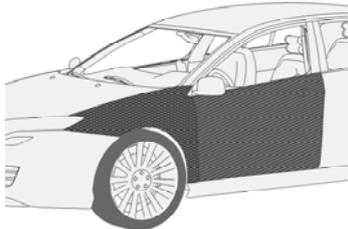
Safety instructions

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

The products are suitable for professional use only.

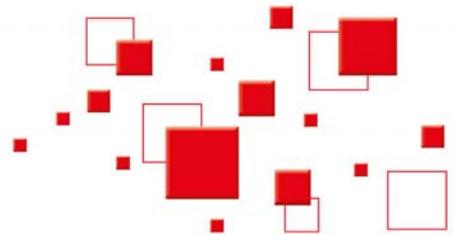
For the use of these products please adhere to the actual safety recommendations and the personal protective equipment.

1) Pre-treatment

	<p>Degrease with PK 1000.</p> <p>Dry-sand filler patch with P400.</p> <p>Sand the adjacent panel with P1000.</p> <p>Degrease with PK 2000.</p>
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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. You can obtain the latest version from our website at www.rmpaint.com or directly from your sales partner. It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed.

R-M Automotive Refinish Paints, Z.I. du Merret F-60676 Clermont de l'Oise Cedex, Tel. (+33) (0) 3 44 77 77 77, 12/2014



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2) Applying the pre coat (step 1)

	Masking: Cover the adjacent panel with masking film.						
	Mixing ratio: <table style="width: 100%; border: none;"> <tr> <td style="width: 60%;">ONYX HD</td> <td style="text-align: right;">100% by vol.</td> </tr> <tr> <td>ONYX ACTIVATOR</td> <td style="text-align: right;">5% by vol.</td> </tr> <tr> <td>HYDROMIX</td> <td style="text-align: right;">80% by vol.</td> </tr> </table> <p style="text-align: center;">Stir thoroughly after adding each of the components.</p>	ONYX HD	100% by vol.	ONYX ACTIVATOR	5% by vol.	HYDROMIX	80% by vol.
	ONYX HD	100% by vol.					
	ONYX ACTIVATOR	5% by vol.					
	HYDROMIX	80% by vol.					
Spraying pressure: 2 bar							
Application: Apply one or two spraycoats to the panel being repaired							

2.1) Applying the pre coat (step 2)

	Masking: Remove the masking film from the adjacent panel.
	Spraying pressure: 1.5 bar
	Application: 1 spraycoat Blend in the transition between the panel being repaired and the adjacent panel.
	Flash-off: Flash off until mat.
	Cleaning: Use a tack rag to remove overspray.

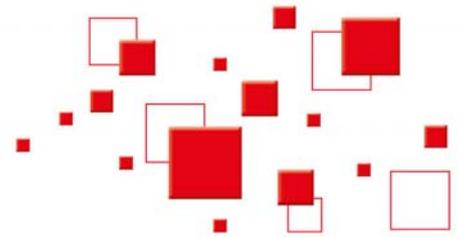
3) Applying the basecoat (step 1)

	<table style="width: 100%; border: none;"> <thead> <tr> <th style="width: 15%;"></th> <th style="width: 45%; text-align: center;">Solid color</th> <th style="width: 40%; text-align: center;">Special effect basecoat</th> </tr> </thead> <tbody> <tr> <td>Mixing ratio:</td> <td>ONYX HD 100% by vol.</td> <td>100% by vol.</td> </tr> <tr> <td></td> <td>ONYX ACTIVATOR 5% by vol.</td> <td>/</td> </tr> <tr> <td></td> <td>HYDROMIX 80% by vol.</td> <td>60% by vol.</td> </tr> <tr> <td></td> <td colspan="2">Stir thoroughly after adding each of the components.</td> </tr> </tbody> </table>		Solid color	Special effect basecoat	Mixing ratio:	ONYX HD 100% by vol.	100% by vol.		ONYX ACTIVATOR 5% by vol.	/		HYDROMIX 80% by vol.	60% by vol.		Stir thoroughly after adding each of the components.	
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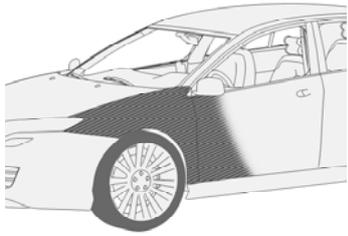
ONYX HD

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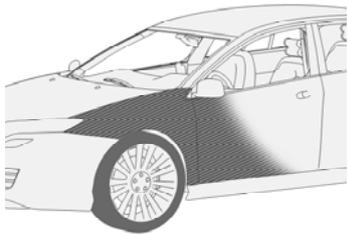
B 3.2



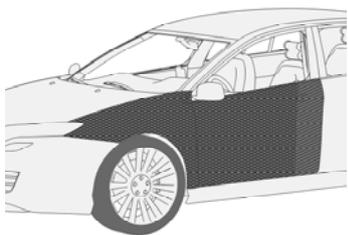
3.1) Applying the basecoat (step 2)

	Application: 2 spraycoats For each new spraycoat, reduce the pressure to 1.5 bars and blend in along the fade-out areas of the previous coat. Then increase the spraying pressure to 2 bars and spray the entire repair panel.
	Flash-off: Flash off until mat after each spraycoat.
	Cleaning: Use a tack rag to remove overspray.

4) Applying the basecoat (step 3)

	Mixing ratio: ONYX HD 100% by vol. HYDROMIX 60% by vol.
	Application: 2 to 4 spraycoats (depending on the desired color) When starting a new spraycoat, reduce the pressure to 1.5 bar and blend in along the fade-out areas of the previous coat. Then increase the spraying pressure to 2 bar and spray the entire repair panel.
	Flash-off: Flash off until mat after each spraycoat. After the final spraycoat, allow an extra 10 minutes flash-off period.

5) Applying the clear

	Prepare and apply the selected R-M clear according to the instructions of the relevant Technical Data Sheet.
	Apply 2 spraycoats over the entire surface repaired.

6) Drying the repair area

Dry the repair area according to the instructions of the Technical Data Sheet for the clear applied.